

WELDING PROCEDURE SPECIFICATION

Material Specification	A572 GR 50		
Welding Process	GMAW		
Manual or Machine	SEMIAUTOMATIC/ROBOTIC		
Position of Welding	FLAT/HORIZONTAL		
Filler Metal Specification	A5.18		
Filler Metal Classification	L-56	LINCOLN	
Flux	N/A		
Shielding Gas	90% ARGON /10% CO2	Dew Point -40DEG F	Flow Rate 45CFH
Single or Multiple Pass	SINGLE		
Single or Multiple Arc	SINGLE		
Welding Current	DC		
Polarity	REVERSE		
Welding Progression	STRINGER		
Root Treatment	PER D1.5		
Preheat and Interpass Temperature	PER D1.5		
Postheat Temperature	NONE		
Heat Input	Min _____	Max _____	

SHOP DRAWING REVIEW

REVIEWED AS REQUIRED BY THE CONSTRUCTION CONTRACT DOCUMENTS AND APPROVED, BUT ONLY FOR CONFORMANCE TO THE DESIGN CONCEPT OF THE WORK, AND SUBJECT TO FURTHER LIMITATIONS AND REQUIREMENTS CONTAINED IN THE CONSTRUCTION CONTRACT DOCUMENTS.
 REJECTED REVISE AND RESUBMIT APPROVED AS NOTED

CORRECTIONS OR COMMENTS MADE ON THE SHOP DRAWINGS DURING THIS REVIEW DID NOT RELIEVE CONTRACTOR FROM COMPLIANCE WITH REQUIREMENTS OF THE DRAWINGS AND SPECIFICATIONS. THIS CHECK IS ONLY FOR REVIEW OF GENERAL CONFORMANCE WITH THE DESIGN CONCEPT OF THE PROJECT AND GENERAL COMPLIANCE WITH THE INFORMATION GIVEN IN THE CONTRACT DOCUMENTS. THE CONTRACTOR IS RESPONSIBLE FOR CONFIRMING AND CORRELATING ALL QUANTITIES AND DIMENSIONS, SELECTING FABRICATION PROCESSES AND TECHNIQUES OF CONSTRUCTION, COORDINATING THEIR WORK WITH TRADES CONTRACTORS, AND PERFORMANCE THEIR WORK IN A SAFE AND SATISFACTORY MANNER.

SLD Consulting Engineers 640 Commercial Street Manchester, NH 03101 603-271-1122	Job Number: <u>120121</u> Reviewed by: <u>SRB</u> Date: <u>3/23/2015</u>
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WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
Variable	LIMITS	190	22	19	
		171	20	17	
		TO 209	TO 24	TO 21	

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure No. <u>3022</u>	Contractor <u>Elderlee, Inc.</u>
Revision No. _____	Authorized By <u>RANDY SCOTT</u>
	Date <u>3/20/2014</u>

Vermont Agency of Transportation
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