

WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE #3

Material Specification ASTM A572 GR. 50 CVN TO A500 GR B
 Welding Process FCAW-G
 Manual or Machine SEMAUTOMATIC
 Position of Welding FLAT/HORIZONTAL
 Filler Metal Specification A5.29
 Filler Metal Classification E81T1-Ni1C-JH4
 Flux N/A
 Shielding Gas CO 2 Dew Point -40DEG F Flow Rate 50CFH
 Single or Multiple Pass SINGLE
 Single or Multiple Arc SINGLE
 Welding Current DC
 Polarity REVERSE ELECTRODE POSITIVE
 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 THAT OF RECEIVERS, CHECKS, AND/OR OTHERS IN A SAFE AND SATISFACTORY MANNER.

GLD Consulting Engineers
 502 Commercial Street
 Manchester, NH 03101
 603-988-9222

Job Number: 120121
 Reviewed by: SRB
 Date: 3/23/2015

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Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	310	25	11	
Variable	LIMITS	341	27	12	
		TO 269	TO 23	TO 10	

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

Procedure No. 3037 Contractor Elderlee, Inc.
 Revision No. _____ Authorized By RANDY SCOTT
 Date 12/1/2014

Vermont Agency of Transportation
RECEIVED
 ON: February 25, 2015
 and Checked for
CONFORMANCE
 BY: Rob Young DATE: 03/23/2015