

WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE#1

Material Specification	A572 GRD. 50 /A992-06a		
Welding Process	FCAW		
Manual or Machine	SEMAUTOMATIC		
Position of Welding	FLAT/HORIZONTAL		
Filler Metal Specification	A5.20		
Filler Metal Classification	E70 LINCOLN OUTERSHEILD		
Flux	N/A		
Shielding Gas	CO 2	Dew Point	-40DEG F
Single or Multiple Pass	SINGLE	Flow Rate	50 CFH (45 TO 63 CFH)
Single or Multiple Arc	N/A		
Welding Current	DC		
Polarity	DCEP		
Welding Progression	STRINGER		
Root Treatment	PER D1.5		
Preheat and Interpass Temperature	PER D1.5		
Postheat Temperature	NONE		
Heat Input	Min		Max

Vermont Agency of Transportation

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Woodstock BPP 0151 (21) - Final Shop Drawing Submittal - Rev 1 - Reviewed By/Date/Approved.pdf

CK'D BY _____ OK'D BY Rob Young

January 7, 2016

RESUBMIT No Approved _____

BY Rob Young DATE 01/14/2016

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	3/32	390	27	12	
Variable	LIMITS	351	25	11	
		TO 429	TO 29	TO 13	

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

Procedure No. 3008

Contractor Elderlee, Inc.

Revision No. _____

Authorized By RANDY SCOTT

Date 12/14/2015