

WELDING PROCEDURE SPECIFICATION

Material Specification PQR ELDERLEE # 3
 A36/A500GR.B/A53/A572GR.36/50/A709GR.36/50/A108 / A307/A325/A563/A449.
 Welding Process FCAW
 Manual or Machine SEMAUTOMATIC
 Position of Welding FLAT/HORIZONTAL
 Filler Metal Specification A5.29
 Filler Metal Classification E81T1-N11C-JH4 LINCOLN ULTERCORE 8111C-H
 Flux N/A
 Shielding Gas CO 2 Dew Point -40DEG F Flow Rate 50CFH
 Single or Multiple Pass SINGLE (45 TO 63 CFH)
 Single or Multiple Arc SINGLE
 Welding Current DC
 Polarity REVERSE ELECTRODE POSITIVE CTWD 3/4"
 Welding Progression STRINGER
 Root Treatment ROOT SHALL BE CLEAN AND FREE OF FOREIGN MATTER
 Preheat and Interpass Temperature MIN PREHEAT 50 DEG ≤ 0.75" 70 DEG > 0.75" MAX INTERPASS 400 DEG
 Postheat Temperature NONE
 Heat Input Min 33.92 Max 50.42

WELDING PROCEDURE

| Pass no. | Electrode size | Welding Current | | Travel speed | Joint detail |
|----------|----------------|-----------------|----------|--------------|--------------|
| | | Amperes | Volts | | |
| 1 | 1/16 | 310 | 25 | 11 | |
| | | 320 | 26 | 12.1 | |
| | | TO 285 | TO 24 | TO 9.9 | |

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

Procédure No. 8000 Contractor Elderlee, Inc.
 Revision No. 3 Authorized By RANDY SCOTT
 Date 3/1/2017

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 FURNISH AS CORRECTED

CORRECTIONS OR COMMENTS MADE ON THE SHOP DRAWINGS DURING THIS REVIEW DO 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 HIS WORK WITH THAT OF ALL OTHER TRADES; AND PERFORMING HIS WORK IN A SAFE AND SATISFACTORY MANNER.

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| 40 IDX Drive Building 100, Suite 200 South Burlington, VT 05403 802.497.6100 | Job Number: BRF-025-1(42) Reviewed By: <u>E.F. LAWES</u> Date: <u>MARCH 14, 2017</u> |
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Vermont Agency of Transportation
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CK'D BY VHB OK'D BY TAS

March 14, 2017

RESUBMIT _____ APPROVED YES
 BY T Sumner DATE 3/14/17