

**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-NI1C-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	TO	TO	
		285	24	9.9	

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

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

Vermont Agency of Transportation  
**RECEIVED**

CK'D BY VHB OK'D BY TAS

March 14, 2017

RESUBMIT            APPROVED YES  
 BY T Sumner DATE 3/16/17

**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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Job Number: BRF 025-1(42)  
 Reviewed By: E.F. LAWES  
 Date: MARCH 15, 2017