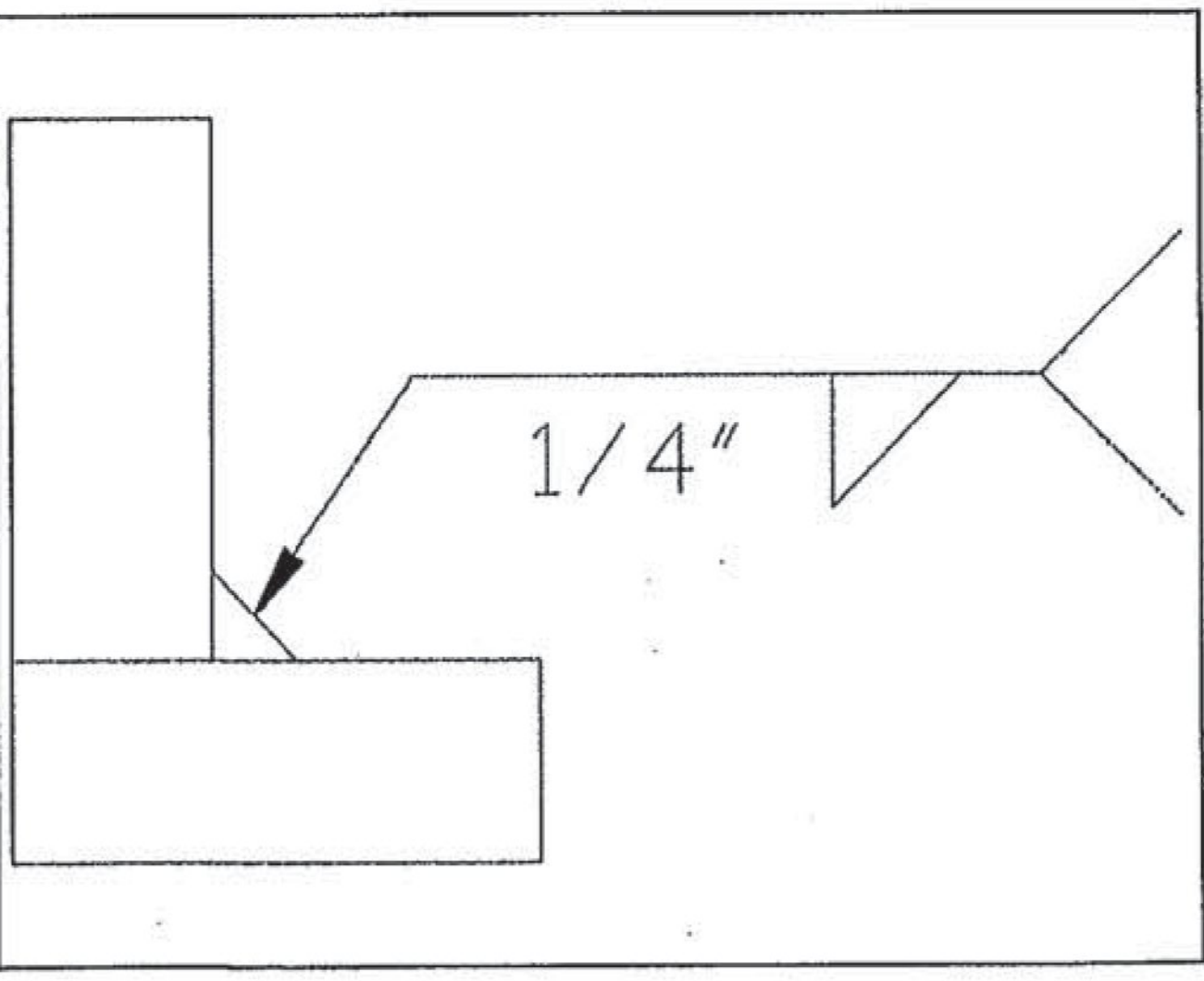


WELDING PROCEDURE SPECIFICATION

Material Specification PQR ELDERLEE #4
A36/A572 GR. 36 / 50 / A709 GR. 36 / 50
Welding Process GMAW
Manual or Machine SEMAUTOMATIC ROBOTIC
Position of Welding FLAT
Filler Metal Specification A5.18
Filler Metal Classification L-56 ER70S-6 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 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 10.56 Max 15.84

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	.045	190	22	19	
		171	20	18	
		TO	TO	TO	
		200	23	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. 8001 Contractor Elderlee, Inc.
Revision No. 1 Authorized By RANDY SCOTT
Date 2/7/2017


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.

 40 IDX Drive Building 100, Suite 200 South Burlington, VT 05403 802.497.6100	Job Number: <u>BRF 025-1(42)</u> Reviewed By: <u>E.F. LAWES</u> Date: <u>MARCH 15, 2017</u>
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