

WELDING PROCEDURE SPECIFICATION

Material Specification	PQR ELDERLEE #3		
Welding Process	A36/A500GR.B/A53/A572GR.36/50/A709GR.36/50/A108		
Manual or Machine	FCAW		
Position of Welding	SEMAUTOMATIC		
Filler Metal Specification	FLAT		
Filler Metal Classification	A5.29		
Flux	E81T1-N11C-JH4 LINCOLN ULTERCORE 8111C-H		
Shielding Gas	CO 2	Dew Point	-40DEG F
Single or Multiple Pass	SINGLE	Flow Rate	50CFH (45 TO 63 CFH)
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. 8003 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.

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