

WELDING PROCEDURE SPECIFICATION

Material Specification	A36 TO A500		
Welding Process	FCAW		
Manual or Machine	SEMAUTOMATIC		
Position of Welding	FLAT / HORIZONTAL		
Filler Metal Specification	A5.20 - 95		
Filler Metal Classification	E81T1-Ni1C-JH4		
Flux	N/A		
Shielding Gas	CO 2	Dew Point	-40DEG F Flow Rate 50CFH
Single or Multiple Pass	SINGLE		
Single or Multiple Arc	SINGLE		
Welding Current	DC		
Polarity	REVERSE ELECTRODE POSITIVE		
Welding Progression	STRINGER		
Root Treatment	PER D1.5		
Preheat and Interpass Temperature	PER D1.5		
Postheat Temperature	NONE		
Heat Input	Min		Max

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	300	26	14	
Variable	LIMITS	270	24	12.6	
		TO 330	TO 28	TO 15.4	

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

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Contractor Elderlee, Inc.
 Authorized By RANDY SCOTT
 Date 8/4/2014

Vermont Agency of Transportation

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