

**WELDING PROCEDURE SPECIFICATION**

PQR ELDERLEE #3

Material Specification	ASTM-A500-A53-GRADE B TO A36		
Welding Process	FCAW-G		
Manual or Machine	SEMAUTOMATIC		
Position of Welding	1G		
Filler Metal Specification	A5.29		
Filler Metal Classification	E81T1-Ni1C-JH4		
Flux	N/A		
Shielding Gas	CO 2	Dew Point	-40DEG F FLOW RATE 50 CFH
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	310	25	11	
Variable	LIMITS	341	27	12	
		TO 269	TO 23	TO 10	

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

Procedure No. 3012  
 Revision No. \_\_\_\_\_

Contractor Elderlee, Inc.  
 Authorized By RANDY SCOTT  
 Date 3/20/2014

Vermont Agency of Transportation

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**CONFORMANCE**

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