

**WELDING PROCEDURE SPECIFICATION**

Material Specification A572 GRD. 50 /A992-06a  
 Welding Process FCAW  
 Manual or Machine SEMI-AUTOMATIC  
 Position of Welding FLAT  
 Filler Metal Specification A5.20  
 Filler Metal Classification E70 LINCOLN OUTERSHEILD  
 Flux N/A  
 Shielding Gas CO 2 Dew Point -40DEG F Flow Rate 50 CFM  
 Single or Multiple Pass SINGLE (45 TO 63 CFM)  
 Single or Multiple Arc N/A  
 Welding Current DC  
 Polarity DCEP  
 Welding Progression STRINGER  
 Root Treatment CLEAN AS PER SECTION 603 OF THE NYSSCM  
 Preheat and Interpass Temperature PREHEAT AS PER TABLE 708 OF THE NYSSCM  
 Postheat Temperature NONE  
 Heat Input Min \_\_\_\_\_ Max \_\_\_\_\_

**WELDING PROCEDURE**

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	3/32	390	27	12	
Variable	LIMITS	351 TO 429	25 TO 29	11 TO 13	

Vermont Agency of Transportation  
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 and Checked for  
**CONFORMANCE**  
 BY: Rob Young DATE: 06/07/2013

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

Procedure No. 3008 Contractor Elderlee, Inc.  
 Revision No. \_\_\_\_\_ Authorized By RANDY SCOTT  
 Date 10/18/2011