

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	
<p>Vermont Agency of Transportation RECEIVED CK'D BY <u>RMK</u> OK'D BY <u>JWC</u> January 4th, 2013 RESUBMIT <u>APPROVED</u> X BY <u>KMH</u> DATE <u>1-8-13</u></p>					

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