

WELDING PROCEDURE SPECIFICATION

Material Specification A709 TO A500 GR B
 Welding Process FCAW
 Manual or Machine SEMI-AUTOMATIC
 Position of Welding FLAT
 Filler Metal Specification A5.20 - 95
 Filler Metal Classification E71T-1H8 E71T-9H8 LINCOLN ULTRACORE
 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 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	1/16	300	26	14	
Variable	LIMITS	270	24	12.6	
		300 TO 330	28	15.4	
<p>Vermont Agency of Transportation RECEIVED CK'D BY <u>RMK</u> OK'D BY <u>JWC</u> January 4th, 2013 RESUBMIT <u>X</u> APPROVED <u>X</u> 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. 3009 Contractor Elderlee, Inc.
 Revision No. _____ Authorized By RANDY SCOTT
 Date 10/18/2011