

WELDING PROCEDURE SPECIFICATION

Material Specification A36
 Welding Process GMAW
 Manual or Machine SEMI-AUTOMATIC
 Position of Welding FLAT
 Filler Metal Specification A5.18
 Filler Metal Classification L-50.052 LINCOLN
 Flux N/A
 Shielding Gas 90% ARGON /10% CO2 Dew Point -40DEG F Flow Rate 50 CFM
 Single or Multiple Pass SINGLE
 Single or Multiple Arc SINGLE
 Welding Current DC
 Polarity REVERSE
 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		
Variable	LIMITS	430	32	13	
		TO	TO	TO	
		473	34	14	

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

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

Procedure No. 3040 Contractor Elderlee, Inc.
 Revision No. _____ Authorized By RANDY SCOTT
 Date 12/20/2011