

**WELDING PROCEDURE SPECIFICATION**

Material Specification A709 TO A500 GR B  
 Welding Process FCAW  
 Manual or Machine SEMAUTOMATIC  
 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 D1.5  
 Preheat and Interpass Temperature 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	300	26	14	
Variable	LIMITS	270	24	12.6	
		TO 330	TO 28	TO 15.4	

Vermont Agency of Transportation  
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 RESUBMIT NO Approved  
 BY KMH DATE 6-12-2013

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

Procedure No. 3009  
 Revision No. \_\_\_\_\_

Contractor Elderlee, Inc.  
 Authorized By RANDY SCOTT  
 Date 5/22/2013