

**WELDING PROCEDURE SPECIFICATION**

Material Specification ASTM-A500-A53-GRADE B TO A36  
 Welding Process FCAW  
 Manual or Machine SEMAUTOMATIC  
 Position of Welding 5G  
 Filler Metal Specification A5.20  
 Filler Metal Classification E71T-1/T-1M ESAB DUAL SHIELD 7000  
 Flux N/A  
 Shielding Gas CO 2 Dew Point -40DEG F FLOW RATE 50 CFH  
 Single or Multiple Pass SINGLE  
 Single or Multiple Arc SINGLE  
 Welding Current DC  
 Polarity REVERSE ELECTRODE POSITIVE  
 Welding Progression STRINGER  
 Root Treatment PER D1.1  
 Preheat and Interpass Temperature PER D1.1  
 Postheat Temperature NONE  
 Heat Input Min \_\_\_\_\_ Max \_\_\_\_\_

**WELDING PROCEDURE**

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	.035	110	21	6IPM	
Variable	LIMITS	121 TO 99	23 TO 19	7 TO 5	

**Vermont Agency of Transportation  
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CK'D BY JWC OK'D BY JTS

June 5, 2013

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. 3012  
 Revision No. \_\_\_\_\_

Contractor Elderlee, Inc.  
 Authorized By RANDY SCOTT  
 Date 6/21/2012