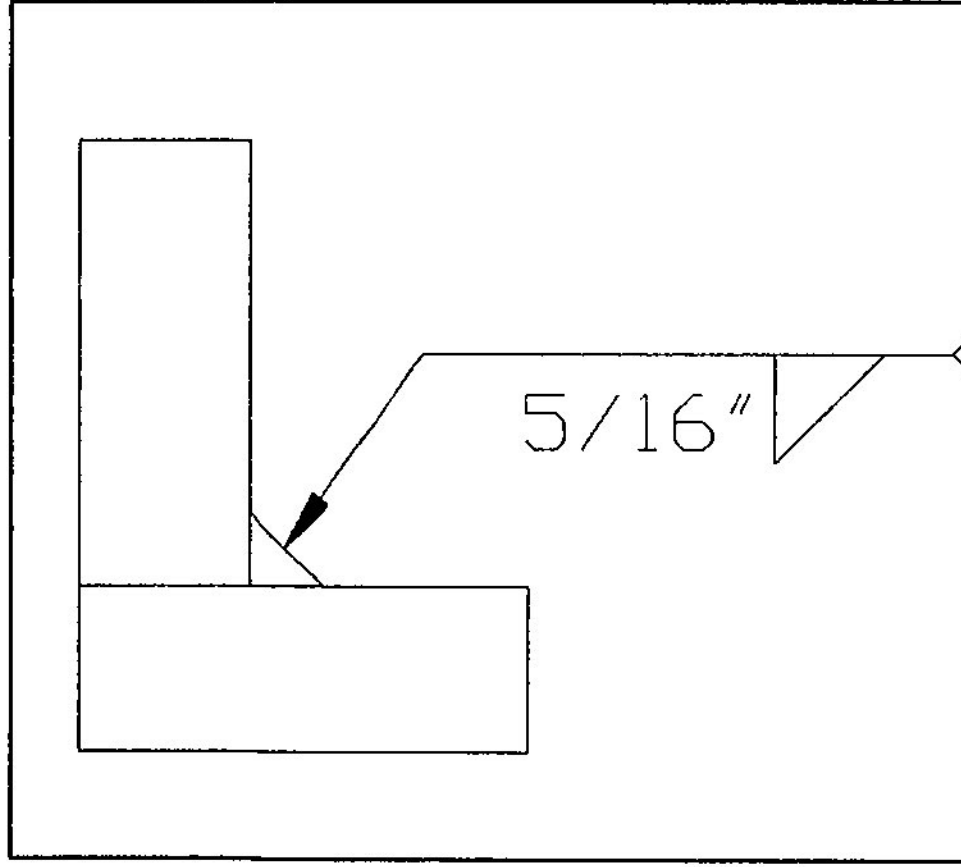


WELDING PROCEDURE SPECIFICATION

Material Specification	ASTM A572 GR. 50 CVN	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	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		
1	1/16	300	26	14	
Variable	LIMITS	270	24	12.6	
		330	28	15.4	

Vermont Agency of Transportation
RECEIVED

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. 3037

Contractor Elderlee, Inc.

Revision No. _____

Authorized By RANDY SCOTT

Date 12/20/2011