

WELDING PROCEDURE SPECIFICATION

Material Specification	A36		
Welding Process	GMAW		
Manual or Machine	SEMAUTOMATIC		
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		
	.052	430	32	13	
Variable	LIMITS	387	29	12	
		TO 473	TO 34	TO 14	

**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. 3040

Contractor Elderlee, Inc.

Revision No. _____

Authorized By RANDY SCOTT

Date 12/20/2011