

COSMEC INC.
WELDING PROCEDURE SPECIFICATION

SPECIFICATIONS AND CODE: AASHTO-AWS D1.5
 MATERIAL SPECIFICATION: ASTM A709 GR 50W, GR 50, GR 36
 WELDING PROCESS: FCAW-G
 MANUAL OR MACHINE: SEMI-AUTOMATIC
 POSITION OF WELDING: 1F & 2F
 FILLER METAL SPECIFICATION: AWS 5.29
 MANUFACTURER: LINCOLN ELECTRIC
 FLUX: INTERNAL
 SHIELDING GAS: 75 AR/25 CO2
 SINGLE OR MULTIPLE PASS: MULTIPLE
 SINGLE OR MULTIPLE ARC: SINGLE
 WELDING CURRENT: DC
 POLARITY: REVERSE (EP)
 WELDING PROGRESSION: _____
 ROOT TREATMENT: CLEANED & PREPARED BRIGHT METAL
 PREHEAT AND INTERPASS TEMPERATURE: SEE BELOW
 POSTHEAT TEMPERATURE: N/A
 HEAT INPUT MIN. _____ MAX. _____

CLASSIFICATION: E81T1-Ni1M-H8
 TRADENAME: OUTERSHIELD 81Ni1-H
 FLOW RATE: 45 CFH

Vermont Agency of Transportation
RECEIVED
 ON: January 22, 2016
 and Checked for
CONFORMANCE
 BY: Rob Young DATE: 02/18/2016

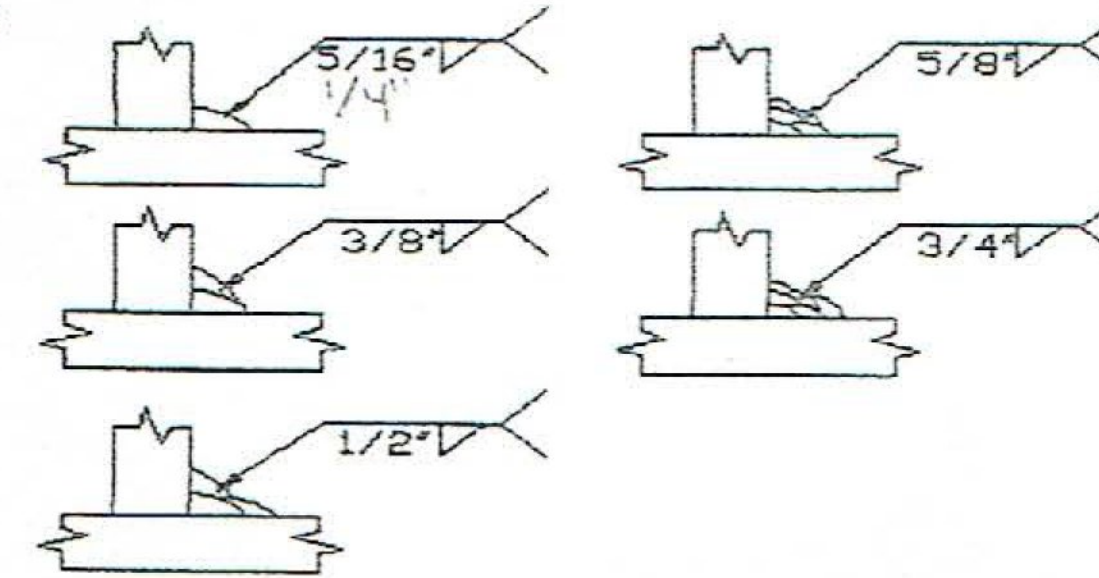
WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING CURRENT		TRAVEL SPEED	JOINT DETAIL
		AMPERES	VOLTS		
ALL	0.045	198-220	25-27	9.8-12.1	

PREHEAT TEMPS.

THICKNESS	TEMP.
UP TO 3/4"	125 DEG. F
OVER 3/4" TO 1 1/2"	125 DEG. F
OVER 1 1/2" TO 2 1/2"	150 DEG. F
OVER 2 1/2"	225 DEG. F
INTERPASS TEMP:	450 DEG. F

*FILLET WELD SHOWS NO. OF PASSES REQ. FOR SIZE



THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC. WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5.

PROCEDURE NO. FCAW-FILLET2012
 SUPPORTING PQR: FCAW-07-LA
 REVISION NO.

CONTRACTOR: COSMEC INC.
 AUTHORIZED BY: DONALD VOSE

DATE: 8/16/2012

