



Identification #	480	Rev.
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AWS D1.5 2010

Single Pass Fillet weld in 1F position, No bigger than 3/8 in a single pass
 Single Pass Fillet weld in 2F, 4F position, No bigger than 5/16 in a single pass
 Single Pass Fillet weld in 3F position, No bigger than 1/2 in a single pass

For thickness 1/8 to 3/4(in.): 50°F. Preheat to 70(°F) if the base metal temperature is below 32(°F).
 Over 3/4 thru 1-1/2(in.): 70(°F).
 Over 1-1/2 thru 2-1/2(in.): 150(°F).
 Over 2-1/2(in.): 225(°F). Refer to AWS D1.5 2010 Table 4.3 (pg85)

FOR FRACTURE CRITICAL WELDS

For thickness 1/8 to 3/4(in.): 125°F.
 Over 3/4 thru 1-1/2(in.): 200(°F).
 Over 1-1/2 thru 2-1/2(in.): 300(°F).
 Over 2-1/2(in.): 350(°F). No welding to be done if ambient temperature in immediate area is below 0(°F)

ALL VERTICAL WELDING SHALL BE DONE UPWARD

IF A GAP FROM 1/16 TO 3/16 IS EVIDENT, INCREASE WELD SIZE 1/16 FOR EACH 1/16 GAP

EX 1/16 GAP IS +1/16 FROM DETAILED SIZE
 1/8 GAP IS +1/8 FROM DETAILED SIZE
 3/16 GAP IS +3/16 FROM DETAILED SIZE

Preheats to the NYSSCM

	Gr 50	Gr 50W
to 3/4	50F	100F
over 3/4 to 1-1/2	70F	200F
over 1-1/2 to 2-1/2	150F	300F
over 2-1/2	225	350F

Vermont Agency of Transportation

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CK'D BY _____ OK'D BY Rob Young

April 4, 2016

RESUBMIT NO _____ Approved
 BY Rob Young DATE 04/08/2016