

WELDING PROCEDURE SPECIFICATION

Material Specification	PQR ELDERLEE # 3		
Welding Process	A36/A500GR.B/A53/A572GR.36/50/A709GR.36/50/A108 / A307/A325/A563/A449		
Manual or Machine	FCAW		
Position of Welding	SEMAUTOMATIC		
Filler Metal Specification	FLAT/HORIZONTAL		
Filler Metal Classification	A5.29		
Flux	E81T1-NI1C-JH4 LINCOLN ULTERCORE 811C-H		
Shielding Gas	N/A		
Single or Multiple Pass	CO 2	Dew Point	-40DEG F Flow Rate 50CFH
Single or Multiple Arc	SINGLE	(45 TO 63 CFH)	
Welding Current	SINGLE		
Polarity	DC		
Welding Progression	REVERSE ELECTRODE POSITIVE CTWD 3/4"		
Root Treatment	STRINGER		
Preheat and Interpass Temperature	ROOT SHALL BE CLEAN AND FREE OF FOREIGN MATTER		
Postheat Temperature	MIN PREHEAT 50 DEG ≤ 0.75" 70 DEG > 0.75" MAX INTERPASS 400 DEG		
Heat Input	Min	33.92	Max 50.42

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Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	310	25	11	
		320	26	12.1	
		TO 285	TO 24	TO 9.9	

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure No. 8000
 Revision No. 1

Contractor Elderlee, Inc.
 Authorized By RANDY SCOTT
 Date 2/7/2017

Form III-2

Vermont Agency of Transportation
RECEIVED
 CK'D BY R. Foster OK'D BY R. Foster
 February 13, 2017
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 BY Kristin Higgins DATE 2/15/2017