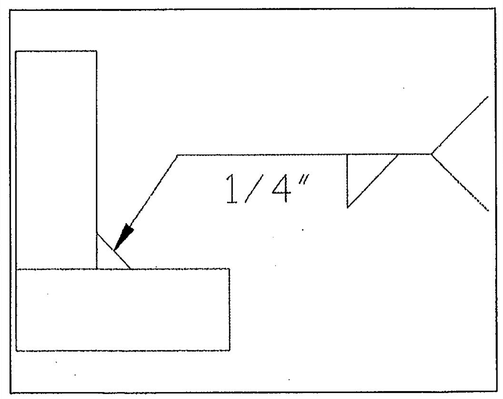
WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE #4

Material Specification	A36/A572 GR. 36 / 50 / A709 GR. 36 / 50
Welding Process	GMAW
Manual or Machine	SEMAUTOMATIC ROBOTIC
Position of Welding	FLAT
Filler Metal Specification	A5.18
Filler Metal Classification	L-56 ER70S-6 LINCOLN
Flux	N/A
Shielding Gas	90% ARGON / 10% CO2 Dew Point -40DEG F Flow Rate 45CFH
Single or Multiple Pass	SINGLE
Single or Multiple Arc	SINGLE
Welding Current	DC
Polarity	REVERSE ELECTRODE POSITIVE CTWD 3/4"
Welding Progression	STRINGER
Root Treatment	ROOT SHALL BE CLEAN AND FREE OF FOREIGN MATTER
Preheat and Interpass Temperature	MIN PREHEAT 50 DEG ≤ 0.75" 70 DEG > 0.75" MAX INTERPASS 400 DEG
Postheat Temperature	NONE
Heat Input	Min 10.56 Max 15.84

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	.045	190	22	19	
		171 TO 200	20 TO 23	18 TO 21	

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

Procedure No. 8001

Revision No. 1

Contractor Elderlee, Inc.

Authorized By RANDY SCOTT

Date 2/7/2017

Form III-2

Vermont Agency of Transportation
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