

**WELDING PROCEDURE SPECIFICATION**

ELDERLEE #2

Material Specification	ASTM-A500-A53-GRADE B TO A572 GRADE 50 / A36		
Welding Process	FCAW		
Manual or Machine	SEMAUTOMATIC		
Position of Welding	FLAT VERTICAL OVERHEAD	5G	
Filler Metal Specification	A5.20		
Filler Metal Classification	E71T-1/T-1M ESAB DUAL SHIELD 7000		
Flux	N/A		
Shielding Gas	CO 2	Dew Point -40DEG F	FLOW RATE 50 CFH
Single or Multiple Pass	SINGLE		(45 TO 63 CFM)
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	18.48	Max 27.72

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Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	.035	110	21	6IPM	
Variable	LIMITS	120	23	7	
		TO 110	TO 19	TO 6	

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

Procedure No. 8002 Contractor Elderlee, Inc.  
 Revision No. 1 Authorized By RANDY SCOTT  
 Date 2/7/2017

Form III-2

Vermont Agency of Transportation  
**RECEIVED**  
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