

WELDING PROCEDURE SPECIFICATION

Material Specification	PQR ELDERLEE #3 A36/A500GR.B/A53/A572GR.36/50/A709GR.36/50/A108		
Welding Process	FCAW		
Manual or Machine	SEMAUTOMATIC		
Position of Welding	FLAT		
Filler Metal Specification	A5.29		
Filler Metal Classification	E81T1-Ni1C-JH4 LINCOLN ULTERCORE 81i1C-H		
Flux	N/A		
Shielding Gas	CO 2	Dew Point	-40DEG F Flow Rate 50CFH
Single or Multiple Pass	SINGLE (45 TO 63 CFH)		
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	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	TO	TO	
		285	24	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. 8003
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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