



Identification # 469 Rev.

AWS D1.5 2015

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).

~~ALL VERTICAL WELDING SHALL BE DONE UPWARD
3/16 ELECTRODE SHALL NOT BE USED IN VERTICAL POSITION~~

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

Not Applicable

~~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~~

~~TACKING ONLY ON GR50W MATERIAL~~

Vermont Agency of Transportation
RECEIVED
CK'D BY R. Foster OK'D BY R. Foster
March 8, 2017
RESUBMIT No Approved AsNoted
BY Kristin Higgins DATE 3/10/2017

CBSS 696 RT 110 over 1st Branch White River
Br #9 Proj BHF 0169(9)
CBSS 697 RT 110 over South Washington Brook
Br #11 Proj BHF 169(10)
Chelsea, VT