



Identification #	470	Rev.
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AWS D1.5 2010

Single Pass Fillet weld in 1F position, No bigger than 3/8 in a single pass
Single Pass Fillet weld in 2F, 4F position, No bigger than 5/16 in a single pass
Single Pass Fillet weld in 3F position, No bigger than 1/2 in a single pass

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). Refer to AWS D1.5 2010 Table 4.3 (pg85)

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 1/16 GAP

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
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