

WELDING PROCEDURE SPECIFICATION (WPS)

Refer to American Welding Society D1.5 Bridge Welding Code
For Chelsea, VT Bridge #9 & #11 Support Angle Welding Procedure
Project Number: NNE-16-009

Company Name: CPM Constructors
WPS Number: CPM-SM-Fillet/ Bridge Deck Forming Revision: 0 Date: 04/07/2017
 Prequalified Qualified by Testing Approved By: Jacob Hall
Welding Process(s): Shielded Metal Arc Welding (SMAW) Type(s): Manual

Joint Design

Type: Fillet (refer to page 3 for addition details prequalified fillet welds and for job specific details)
Backing Yes No N/A

Base Metals

Material Specification (Type or Grade): A709 grade 50
Material Thickness: All

Filler Metals

AWS Specification: AWS A5.1
AWS Classification: E7018
Manufacture Trade Name: Lincoln Excalibur 7018 MR

Preheat / Interpass Temperature

per table 4.3 for preheat and interpass temperature requirements

Preheat Temperature for Base Metal Thickness:

Top Flanges are great than 3/4" thick. 70 deg min pre-heat required.

Extent of Preheat: Up to 3/4", minimum preheat & interpass temperature shall be 50°F.
Preheat temperature shall be maintained during the welding operation for a distance at least equal to the thickness of the thickest part welded, but not less than 3" in all directions from the edge of the weld joint, measured at the location of the welding arc.
Extent of Interpass: The maximum interpass temperature shall be measured at a distance of 1" to 3" in all directions from the edge of the weld, measured just prior to welding the next pass.

Positions

Position of Fillet: 2F Horizontal
Vertical Progression: Up Down N/A

Vermont Agency of Transportation
RECEIVED
CK'D BY TYLin, R. Foster OK'D BY TYLin, R. Foster
April 7, 2017
RESUBMIT No Approved AsNoted
BY Kristin Higgins DATE 4/11/2017

T.Y. LIN INTERNATIONAL
THE STAMPED DOCUMENTS ARE HEREBY:
 APPROVED
 APPROVED AS NOTED
 REVISE AND RESUBMIT
SEE TRANSMITTAL FOR ADDITIONAL INFORMATION AS APPLICABLE.
THIS REVIEW IS FOR GENERAL CONFORMANCE WITH DESIGN CONCEPT ONLY. ANY DEVIATION FROM THE PLANS OR SPECIFICATIONS NOT CLEARLY NOTED BY THE CONTRACTOR HAS NOT BEEN REVIEWED. REVIEW BY THE ENGINEER SHALL NOT RELIEVE THE CONTRACTOR OF THE CONTRACTUAL RESPONSIBILITY FOR ANY ERRORS OR DEVIATION FROM THE CONTRACT REQUIREMENTS.
JOSH OLUND REVIEWER April 11, 2017 DATE