

WELDING PROCEDURE SPECIFICATION

Material Specification	PQR ELDERLEE #4		
Welding Process	A36/A572 GR. 36 / 50 / A709 GR. 36 / 50		
Manual or Machine	GMAW		
Position of Welding	SEMAUTOMATIC ROBOTIC		
Filler Metal Specification	FLAT		
Filler Metal Classification	A5.18		
Flux	L-56 ER70S-6 LINCOLN		
Shielding Gas	N/A		
Single or Multiple Pass	90% ARGON / 10% CO2 Dew Point -40DEG F Flow Rate 45CFH		
Single or Multiple Arc	SINGLE		
Welding Current	SINGLE		
Polarity	DC		
Welding Progression	REVERSE ELECTRODE POSITIVE CTWD 3/4"		
Root Treatment	STRINGER		
Preheat and Interpass Temperature	ROOT SHALL BE CLEAN AND FREE OF FOREIGN MATTER		
Postheat Temperature	MIN PREHEAT 50 DEG ≤ 0.75" 70 DEG > 0.75" MAX INTERPASS 400 DEG		
Heat Input	Min	10.56	Max 15.84

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	.045	190	22	19	
		171	20	18	
		TO	TO	TO	
		200	23	21	

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

Procedure No. 8001 Contractor Elderlee, Inc.
 Revision No. 1 Authorized By RANDY SCOTT
 Date 2/7/2017

Vermont Agency of Transportation
RECEIVED
JAV-APPROVED RAILING SHOP FEB 21 2017.pdf
 CK'D BY RFOSTER/CHENETTE OK'D BY WBP
February 15, 2017
 RESUBMIT NO Approved AsNoted
 BY WPELLETIER DATE 02/21/2017

APPROVED: Approval of drawings and/or procedures indicates concurrence with the information presented and does not relieve the Contractor or Fabricator of compliance with all specifications and code requirements		
APPROVED AS NOTED	X	
REVISE AND RESUBMIT		
NOT REVIEWED		
Date: 02/21/17		
By: Michael J. Chenette		
This review by Stantec Consulting Services Inc. is for the sole purpose of ascertaining conformance with the general design concept. This review shall not mean that Stantec Consulting Services Inc approves the detail design inherent in the shop drawings, responsibility for which shall remain with the Contractor. Submitting same, and such review shall not relieve the Contractor of his responsibility for errors or omissions in the shop drawing or of his responsibility for meeting all requirements of the Contract Documents. The contractor is responsible for dimensions to be confirmed and correlated at the job site, for information that pertains solely to the fabrication processes or to techniques of construction and installation and for coordination of the work of all subtrades.		