

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

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	310	25	11	
		320	26	12.1	
		TO 285	TO 24	TO 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. 8004 Contractor Elderlee, Inc.
 Revision No. 1 Authorized By RANDY SCOTT
 Date 2/7/2017

Vermont Agency of Transportation
RECEIVED
AN APPROVED MAILING GROUP PER 12120100
 CK'D BY ROSTER/CHENETTE OK'D BY WBP
 February 15, 2017
 RESUBMIT 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		
<small>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.</small>		