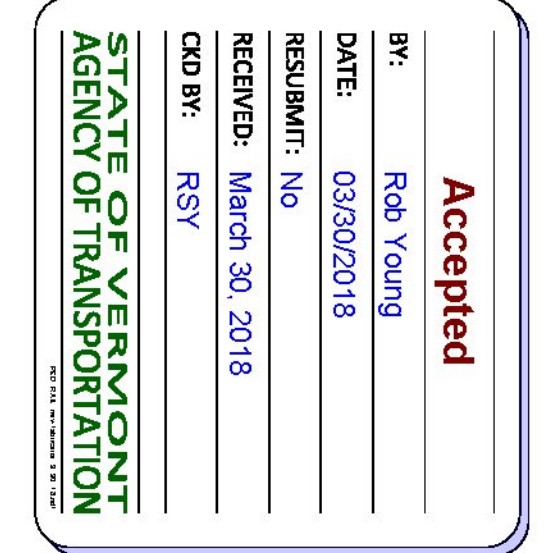
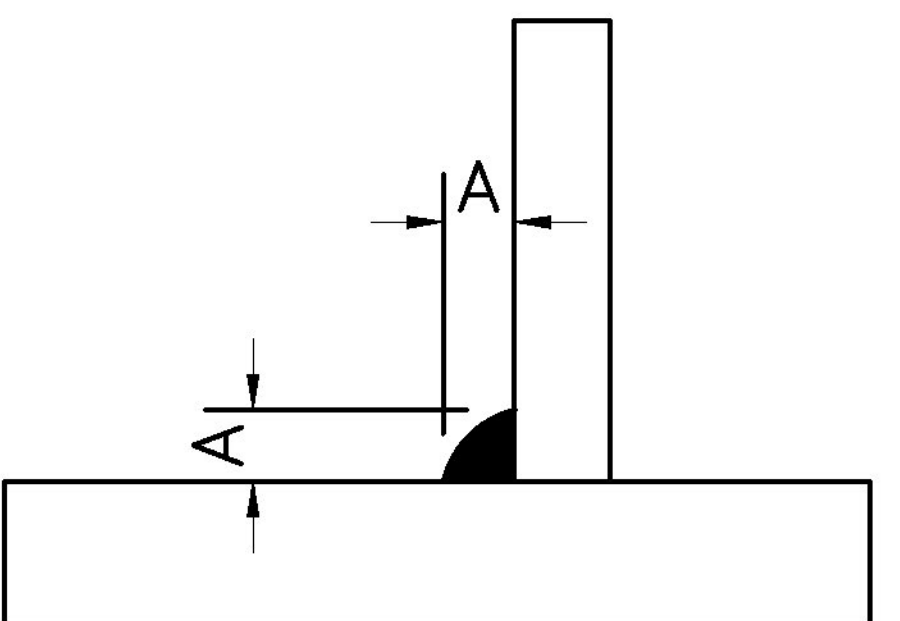
 <small>STEEL SALES & FABRICATION VERNON VT. USA</small>	WELDING PROCEDURE			NO. RB-FW-001	SHEET: 1 OF 1
	DATE: 3/30/18	PROJECT NAME: WOODSTOCK VILLAGE			
	BY: A. DUNKLEE	PROJECT NO. BF 020-2 (43)			
283 FT. BRIDGMAN RD. VERNON VT., 05354 PH. (802)257-7383 FAX (802)257-7308	AWS CODE: D1.5	PQR REF. NO: N/A			
MATERIAL SPECIFICATION:		A36, A53			
WELDING PROCESS:		SMAW			
MANUAL, SEMI-AUTOMATIC OR AUTOMATIC:		MANUAL			
WELDING POSITION:		ALL			
FILLER METAL SPECIFICATION:		ANSI/AWS A5.1-A5.5			
FILLER METAL CLASSIFICATION:		E7018			
FLUX:		N/A			
SHIELDING GAS:		N/A	FLOW RATE:	N/A	
SINGLE OR MULTIPLE PASS:		MULTIPLE			
SINGLE OR MULTIPLE ARC:		SINGLE			
WELDING CURRENT:		DC			
WELDING POLARITY:		ELECTRODE POSITIVE			
WELDING PROGRESSION:		N/A			
ROOT TREATMENT:		REMOVE ALL IMPURITIES & GALV.			
PREHEAT & INTERPASS TEMPERATURE:		≥1½"=70°F 1½"-2½"=150°F OVER 2½"=225°F			
POSTHEAT TREATMENT:		N/A			
HEAT INPUT:		MIN: N/A	MAX:	N/A	
ELECTRODE STICKOUT:		N/A			
APPROVAL STAMP					
					
PASS NO.	ELECTRODE SIZE:	WELDING CURRENT		TRAVEL SPEED	JOINT DETAIL: 
		AMPS	VOLTS		
AS REQ.	3/32"	70-110		ADJUST AS REQ.	
	1/8"	90-160			
NOTES:					
					A= 1/8" WELD @ PICKETS A= 3/16" WELD @ POSTS & RAIL CONN. <small>A-SIZE, 3/30/2018 7:47:21 AM, REV. 1</small>