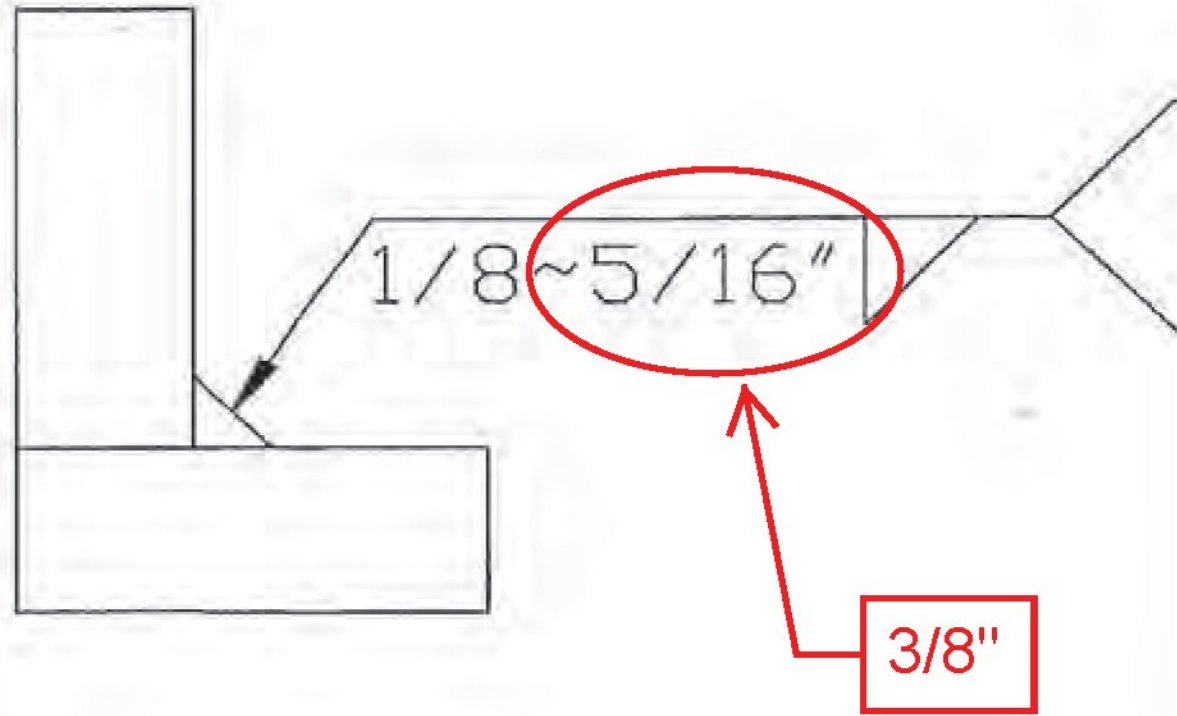


WELDING PROCEDURE SPECIFICATION

Material Specification PQR ELDERLEE # 3
A36/A500GR.B/A53/A572GR.36/50/A709GR.36/50/A108 / A307/A325/A563/A449
Welding Process FCAW
Manual or Machine SEMAUTOMATIC
Position of Welding FLAT/HORIZONTAL
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

SHOP DRAWING REVIEW	
<input type="checkbox"/> REVIEWED AS REQUIRED BY THE CONSTRUCTION CONTRACT DOCUMENTS AND APPROVED, BUT ONLY FOR CONFORMANCE TO THE DESIGN CONCEPT OF THE WORK, AND SUBJECT TO FURTHER LIMITATIONS AND REQUIREMENTS CONTAINED IN THE CONSTRUCTION CONTRACT DOCUMENTS.	
<input type="checkbox"/> REJECTED	<input type="checkbox"/> REVISE AND RESUBMIT
<input checked="" type="checkbox"/> APPROVED AS NOTED	
CORRECTIONS OR COMMENTS MADE ON THE SHOP DRAWINGS DURING THIS REVIEW DID NOT RELIEVE CONTRACTOR FROM COMPLIANCE WITH REQUIREMENTS OF THE DRAWINGS AND SPECIFICATIONS. THIS CHECK IS ONLY FOR REVIEW OF GENERAL CONFORMANCE WITH THE DESIGN CONCEPT OF THE PROJECT AND GENERAL COMPLIANCE WITH THE INFORMATION GIVEN IN THE CONTRACT DOCUMENTS. THE CONTRACTOR IS RESPONSIBLE FOR CONFIRMING AND CORRELATING ALL QUANTITIES AND DIMENSIONS; SELECTING FABRICATION PROCESSES AND TECHNIQUES OF CONSTRUCTION; COORDINATING THEIR WORK WITH THAT OF ALL OTHER TRADES; AND PERFORMING THEIR WORK IN A SAFE AND SATISFACTORY MANNER.	
 DLD Consulting Engineers 540 Commercial Street Manchester, NH 03101 603-888-8223	Job Number <u>150223</u> Reviewed by <u>S.BEAUMONT</u> Date <u>02/28/2017</u>

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	TO	TO	
		285	24	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. 8000 Contractor Elderlee, Inc.
Revision No. 1 Authorized By RANDY SCOTT
Date 2/7/2017

Form III-2

Vermont Agency of Transportation
RECEIVED
 CK'D BY Ryan Foster OK'D BY Ryan Foster
 February 14, 2017
 RESUBMIT No Approved AsNoted
 BY Kristin Higgins DATE 2/28/2017