

WELDING PROCEDURE SPECIFICATION

Material Specification	PQR ELDERLEE #3		
Welding Process	A36/A500GR.B/A53/A572GR.36/50/A709GR.36/50/A108		
Manual or Machine	FCAW		
Position of Welding	SEMAUTOMATIC		
Filler Metal Specification	FLAT		
Filler Metal Classification	A5.29		
Flux	E81T1-NI1C-JH4 LINCOLN ULTERCORE 81i1C-H		
Shielding Gas	CO 2	Dew Point	-40DEG F Flow Rate 50CFH
Single or Multiple Pass	SINGLE	(45 TO 63 CFH)	
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	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	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. 8004 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
 BY Kristin Higgins DATE 2/28/2017

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.	
	Job Number <u>150223</u> Reviewed by <u>S. BEAUMONT</u> Date <u>02/28/2017</u>