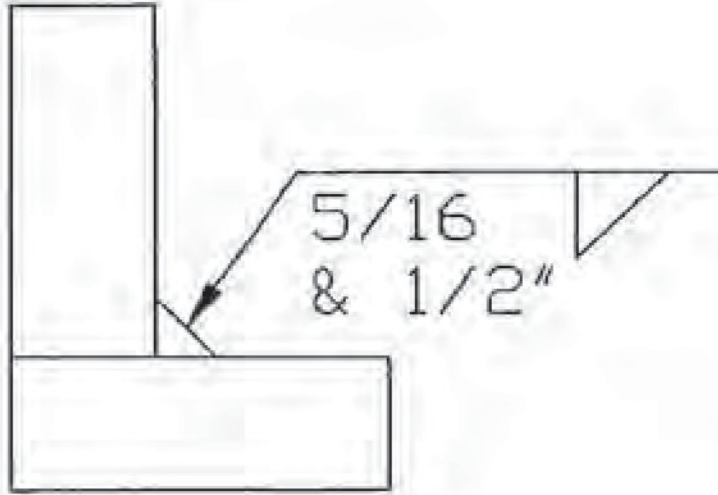


**WELDING PROCEDURE SPECIFICATION**

Material Specification ASTM A36 / A572 / A709 GR. 36 / 50  
 Welding Process FCAW  
 Manual or Machine SEMI AUTOMATIC  
 Position of Welding FLAT  
 Filler-Metal-Specification A5.20  
 Filler Metal Classification E70 LINCOLN OUTERSHEILD E70T-1  
 Flux N/A  
 Shielding Gas CO 2 Dew Point -40DEG F Flow Rate 50 CFM  
 Single or Multiple Pass SINGLE (45 TO 63 CFH)  
 Single or Multiple Arc N/A  
 Welding Current DC  
 Polarity DCEP 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 42 Max 63.84

**WELDING PROCEDURE**

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	3/32	390	27	12	
		350	26	11	
		TO 418	TO 28	TO 13	

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

Procedure No. 8007  
 Revision No. 1

Contractor Elderlee, Inc.  
 Authorized By RANDY SCOTT  
 Date 2/8/2017

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**

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

REJECTED  REVISE AND RESUBMIT  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.


 GLD Consulting Engineers  
 540 Commercial Street  
 Manchester, NH 03101  
 603-688-8222

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