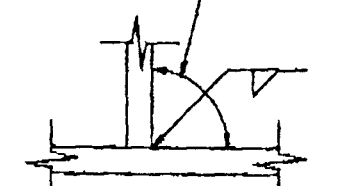


Submission Date: 2/7/96 NATIONAL EASTERN CORPORATION Sht 2 of 3  
 Revision No: 0 WELDING PROCEDURE SPECIFICATION - 105 Page 1 of 1  
 Issue Date: 2/7/96 Project RANDOLPH, VT BSS 0147 (14) Job No: 15644  
 Welding Process: Submerged Arc AWS Joint No: Fillet Manual Machine X  
 Code Requirements: AASHTO/AWS D15-95 Base Metal: BELDW Position: 1F/2F  
 Filler Metal Specs: AS17 Filler Metal Classification: EM12K L6L Flux: F7A2 (860)  
 Shielding Gas: N/A Flow Rate: N/A S or M Pass: Single S or M Arc: Single  
 Minimum Preheat and Interpass Temperature To Be Maintained During Welding:

Thickness of Thickest Part at Point of Welding	A709-36, 50, 50W	60° TO 135°
t ≤ 3/4	50	
3/4 < t ≤ 1-1/2	70	
1-1/2 < t ≤ 2-1/2	150	
t > 2-1/2	225	



Base Metal (cont) A709-36, 50, 50W

For Joint Configuration and Weld Size see Detail Drawings

Pass No.	Fillet Size	Electrode Size	±10% Amps	±7% Volts	Current	±15% Travel (IPM)	Notes
1	1/4	3/32	410	31	DCSP	19	
1	5/16	3/32	410	31	DCSP	18	
RECEIVED			LIMITATION OF VARIABLES				
BY: [Signature]			370-450	29-33		15-21	
FEB 7 1996							
RESUBMIT APPROVED [Signature]							
DATE 2-7-96							

WP024 (43.05k)

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the limitations of variables given in 4B, 4C, or 4D of AWS D15 Bridge Welding Code