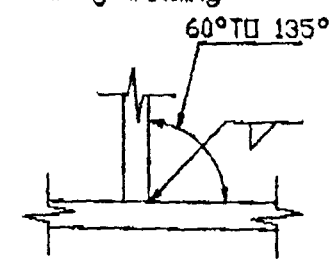


Submission Date: 2/7/96 NATIONAL EASTERN CORPORATION Sht 3 of 3  
 Revision No: 0 WELDING PROCEDURE SPECIFICATION - 202 Page 1 of 1  
 Issue Date: 2/7/96 Project: RANDOLF, VT BRS 0147 (14) Job No: 15644  
 Welding Process: SMAW AWS Joint No: Fillet Manual X Machine -  
 Code Requirements: AASHTO/AWS D1.5-95 Base Metal: BELDW Position: All  
 Filler Metal Specs: AS.5 Filler Metal Classification: E8018-C3  
 Shielding Gas: N/A Flow Rate: N/A S or M Pass: M, S or M Arc: S  
 Minimum Preheat and Interpass Temperature To Be Maintained During Welding:

Thickness of Thickest Part at Point of Welding		A709-50W
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): A709-50W

For Joint Configuration and Weld Size see Detail Drawings

Note: Weathering Projects

Pass	Max Layer	Fillet Size	Electrode Size	Amps	± 7% Volts	Current	Position
Root	(1)	3/16 to 3/4	3/32	70-100	19-21	DCRP-AC	All
Root	(1)	3/16 to 3/4	1/8	90-150	20-24	DCRP-AC	All
Root	(1)	3/16 to 3/4	5/32	130-190	21-25	DCRP-AC	All
Root	(1)	3/16 to 3/4	3/16	200-280	21-25	DCRP-AC	1F & 2F
Subseq	3/16 (2)	3/16 to 3/4	3/32	70-100	19-21	DCRP-AC	All
Subseq	3/16 (2)	3/16 to 3/4	1/8	90-150	20-24	DCRP-AC	All
Subseq	3/16 (2)	3/16 to 3/4	5/32	130-190	21-25	DCRP-AC	All
Subseq	3/16 (2)	3/16 to 3/4	3/16	200-280	21-25	DCRP-AC	1F & 2F
Subseq	3/16 (2)	3/16 to 3/4	7/32	250-330	21-25	DCRP-AC	1F & 2F
(1)	3/8	For Flat (1F)					
(1)	5/16	For Horizontal (2F)					
(1)	1/2	For Vertical (3F)					
(1)	5/16	For Overhead (4F)		CKD BY	CKD BY	KBM	
(2)	1/8	For Flat (1F)					

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 D1.5 Bridge Welding Code

RESUBMIT \_\_\_\_\_ APPROVED   
 BY 7/2 DATE 2-7-96