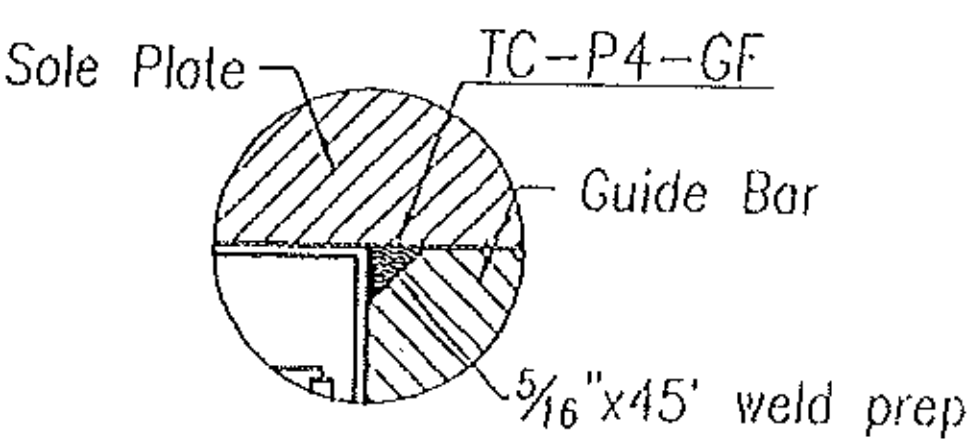


WELDING PROCEDURE SPECIFICATION   
 OR  
 PROCEDURE QUALIFICATION RECORD

Specification No.: 402919 BECK & BELLUCCI  
 Customer: Single Bevel Groove Partial Joint Penn. Customer P.O.#: BETHEL, VT.  
 Base Metals: A-588 P-NO.: 1 Group NO.: 1 to P-NO.: 1 Group NO.: 1  
 Material Specification Type & Grade: AASHTO M270 Gr. 50 to M270 Gr. 50  
 Welding Process: F.C.A.W.  
 Manual or Machine: Manual  
 Position of Welding: Flat 1-F  
 Filler Metal Specification: A 5.29  
 Filler Metal Classification: E-80T1-W, Esab Dual Shield 8100-W  
 Shielding Gas: CO<sup>2</sup> Rate: 25 CFH  
 Single or Multiple Pass: Single VTRANS RECEIVED  
 Single or Multiple Arc: Single OK'D BY SSS OK'D BY JWC  
 Welding Current: Direct OCT 13 2011  
 Polarity: Reverse RESUBMIT \_\_\_\_\_ APPROVED   
 Root Treatment: Remove all scale, grease, etc. from weld preparation face BY \_\_\_\_\_ DATE 10/14/11  
 Preheat and Interpass Temp: 200 Deg F. to 250 Deg F.  
 Post weld Heat Treatment: N/A  
 Travel Speed: 13-15 ipm

Pass No.	Electrode Size	Welding Current		Weld Size	Joint Detail
		Amperes	Volts		
1	.06	300-310	30-31	5/16"	SINGLE BEVEL GROOVE WELD - TC-P4-GF 

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

Manufacturer: Amscot Structural Products Authorized By: [Signature]  
 Date: 10/16/11