

VERMONT AGENCY OF TRANSPORTATION
 PROJECT NAME: BETHEL
 PROJECT NUMBER: BRF-022-1(14)
 HLMR POT BEARING

WELDING PROCEDURE SPECIFICATION

Material Specification: ASTM A-588 to A-588 P1 to P1
 Welding Process: F.C.A.W.
 Manual or Machine: Manual
 Position of Welding: 1F or 2F
 Filler Metal Specification: A5.29
 Filler Metal Classification: E80T1-W
 Flux: ESAB Dual Shield
 Shielding Gas: Carbon Dioxide Flow Rate: 25-30 CFH
 Single or Multiple Pass: Multiple
 Single or Multiple Arc: Single
 Welding Current: Direct
 Polarity: Reverse
 Welding Progression: Flat
 Root Treatment: Remove scale, Grease, Etc. from weld preparation face
 Preheat and Interpass Temp: 200°F
 Post weld Heat Treatment: N/A
 Heat Input Min. _____ Max. _____

RECEIVED
 OK'D BY SSS OK'D BY Juc
 OCT 13 2011
 RESUBMIT _____ APPROVED
 BY _____ DATE 10/14/11

Pass No.	Electrode Size	Welding Current		Weld Size	Joint Detail
		Amperes	Volts		
1	.06	200-225	27-28	1/8	
2	.06	200-225	27-28	1/8	
3	.06	200-225	27-28	1/8	

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.
 Procedure No.: 59343 Contractor: Amscot Structural-Products Corp.
 Revision No.: 1 Authorized By: [Signature]
 Date: 10/6/11