

WELDING PROCEDURE SPECIFICATION   
OR  
PROCEDURE QUALIFICATION RECORD

Specification No.: 55928 A.L.St. Onge  
 Customer: Standard Fillet Weld Customer P.O.#: P.O. Signed Quote  
 Base Metals: ASTM A709 P-NO.: 1 Group NO.: 1 to P-NO.: 1 Group NO.: 1  
 Material Specification Type & Grade: AASHTO M270 Gr. 345 to M270 Gr. 345  
 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  
 Single or Multiple Arc: Single OCT-01-2012  
 Welding Current: Direct  
 Polarity: Reverse 10/3/12  
 Root Treatment: Remove all scale, grease, etc. from weld preparation face  
 Preheat and Interpass Temp: 200 Deg F. to 250 Deg F.  
 Post weld Heat Treatment: N/A  
 Travel Speed: 13-15 ipm

AMSCOT STRUCTURAL PRODUCTS CORP.  
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 RECEIVED  
 OCT 1 2012  
 CERTIFIED FOR CONSTRUCTION

Pass No.	Electrode Size	Welding Current		Weld Size	Joint Detail
		Amperes	Volts		
1	.06	300-310	30-31	5/16"	<p style="text-align: center;">FILLET WELD</p> <p>POT PLATE</p> <p>MASONRY PLATE</p>

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: 10/1/12