

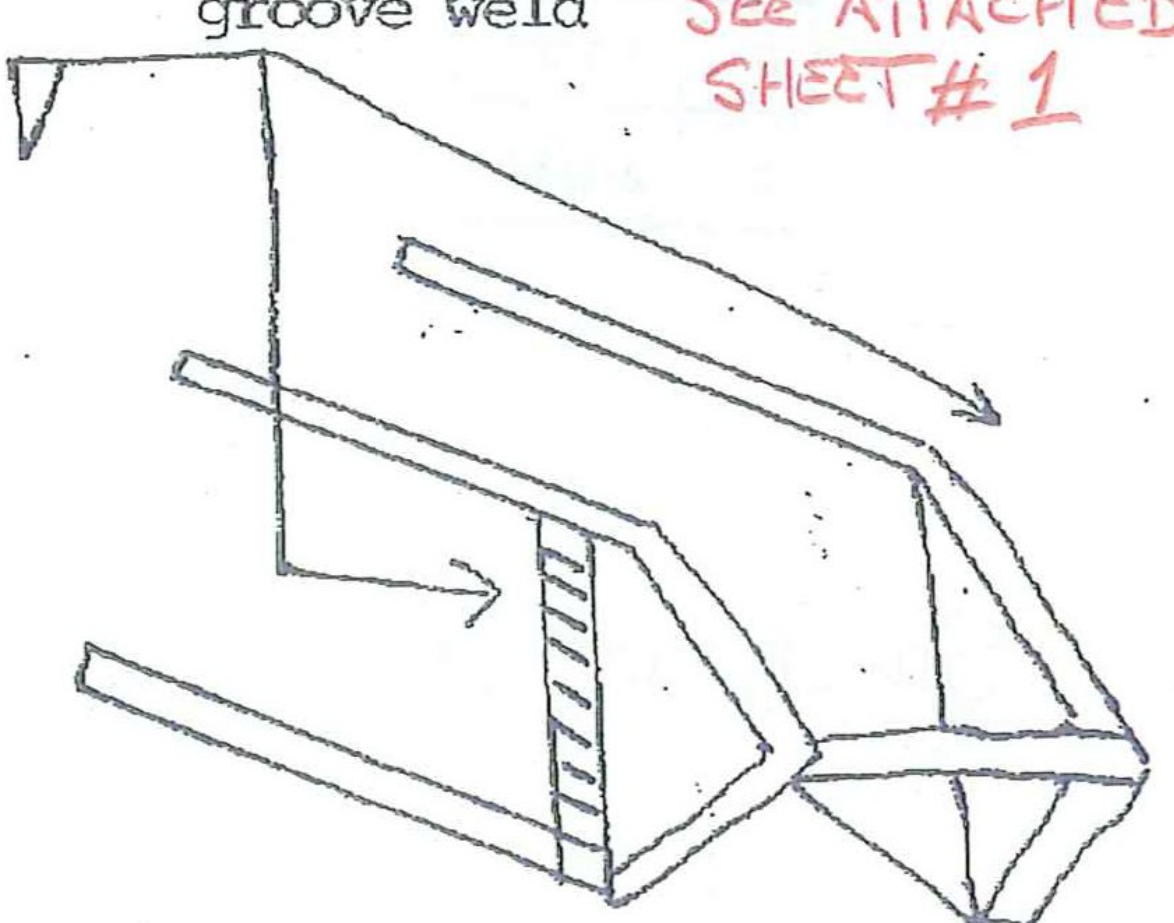
Submitted by: Ralph A. Darrah Welding Contractor  
Telephone #802-748-5599

154/Appendix IV

**JOINT WELDING  
PROCEDURE SPECIFICATION**

Material specification A-36  
 Welding process flux core wire  
 Manual or machine semi automatic  
 Position of welding flat  
 Filler metal specification NR-311  
 Filler metal classification AWS A5.20 E 70T-7  
 Flux core  
 Shielding gas n/a Flow rate n/a  
 Single or multiple pass as required  
 Single or multiple arc single  
 Welding current D-C R-P  
 Polarity R-P  
 Welding progression As required  
 Root treatment none  
 Preheat and interpass temperature 50-175  
 Postheat treatment n/a

**WELDING PROCEDURE**

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
1	5/64	350	28	n/a	groove weld <b>SEE ATTACHED SHEET # 1</b> 

**VTRANS RECEIVED**

CK'D BY \_\_\_\_\_ OK'D BY JWC

**MAY 18 2010**

RESUBMIT \_\_\_\_\_ APPROVED  **AS NOTED**

BY JEL DATE 5/20/10

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

Procedure no. \_\_\_\_\_ Contractor SD Ireland, Inc.  
 Revision no. \_\_\_\_\_ Authorized by \_\_\_\_\_  
 Form E-2. Date \_\_\_\_\_