

PREDQUALIFIED JOINT WELDING PROCEDURE
PROCEDURE SPECIFICATION

Material specification (AASHTO M270 GRADE 345) 50 KSI
 Welding process SMAW
 Manual or machine MANUAL
 Position of welding HORIZONTAL / VERTICAL / OVERHEAD 4F
 Filler metal specification AUS B51
 Filler metal classification E 7018
 Flux N/A
 Shielding gas N/A Flow rate N/A
 Single or multiple pass MULTIPLE PASS FOR 3/8" SINGLE FOR 5/16"
 Single or multiple arc SINGLE
 Welding current DC
 Polarity REVERSE
 Welding progression WIRE BRUSH AREA
 Root treatment 50° MIN
 Preheat and interpass temperature 50° MIN
 Postheat treatment N/A

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amps	Volts		
1	1/8	125	30	10 I	
2	OR MORE	±10%	±7%	10M	

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

Procedure no. SPLICE PLATE Contractor WINTERSET INC.
 Revision no. 0 Authorized by GLENN A. LAVOIE, P.E.
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 PROJECT: MORRISTOWN - MIDDLESSEX
BRS 0284/14