

PREQUALIFIED JOINT WELDING PROCEDURE  
PROCEDURE SPECIFICATION

Material specification (AASHTO M270 GRADE 345) A50  
 Welding process SMAW  
 Manual or machine MANUAL  
 Position of welding HORIZONTAL 2G  
 Filler metal specification AWS A5.1  
 Filler metal classification E 7018  
 Flux NA  
 Shielding gas N/A Flow rate N/A  
 Single or multiple pass SINGLE  
 Single or multiple arc SINGLE  
 Welding current DC  
 Polarity REVERSE  
 Welding progression \_\_\_\_\_  
 Root treatment WIRE BRUSH AREA TO BE FREE OF LOOSE SCALE, RUST, MOISTURE  
 Preheat and interpass temperature 70° MIN OVER 3/0 T  
 Postheat treatment N/A

WELDING PROCEDURE

Pass no	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
1	1/8	125 ±10%	30 ±7%	10 IPM	
1	5/32	125 ±10%	30 ±7%	10 IPM	

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

Procedure no. PILE POINT Contractor: WINTERSET, INC.  
 Revision no. -0- Authorized by: GLENN A. LAVOIE, P.E.  
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 PROJECT: MORETOWN-MIDDLESEX