

PREQUALIFIED JOINT WELDING PROCEDURE  
PROCEDURE SPECIFICATION

Material specification (AASHTO M270 GRADE 345) A50  
 Welding process SMW  
 Manual or machine MANUAL  
 Position of welding HORIZONTAL  
 Filler metal specification ER5-A5U  
 Filler metal classification E 7018  
 Flux N/A  
 Shielding gas N/A Flow rate N/A  
 Single or multiple pass MULTIPLE  
 Single or multiple arc SINGLE  
 Welding current DC  
 Polarity REVERSE  
 Welding progression SEE JOINT DETAIL  
 Root treatment NONE  
 Preheat and interpass temperature 50° MIN  
 Postheat treatment NA

\* OPERATOR MUST BE CERTIFIED IN POSITION USED  
WELDING PROCEDURE

| Pass no  | Electrode size | Welding current |       | Travel speed | Joint detail |
|----------|----------------|-----------------|-------|--------------|--------------|
|          |                | Ampere          | Volts |              |              |
| 1        | 1/8            | 90-170          | 22-26 | AS REQ'D     |              |
| As Req'd | 3/16           | 170-250         | 24-27 | AS REQ'D     |              |

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 SPLICE Contractor WINTERSET, INC.  
 Revision no. 0 Authorized by GLENN A. LAVOIE, P.E.  
 Date AUGUST 25, 2008  
 PROJECT: MORRISTOWN - MIDDESEX  
B125 0284 (14)