

**WELDING PROCEDURE SPECIFICATION**

Material Specification PQR ELDERLEE #3  
 A36/A500GR.B/A53/A572GR.36/50/A709GR.36/50/A108  
 Welding Process FCAW  
 Manual or Machine SEMAUTOMATIC  
 Position of Welding FLAT  
 Filler Metal Specification A5.29  
 Filler Metal Classification E81T1-Ni1C-JH4 LINCOLN ULTERCORE 81i1C-H  
 Flux N/A  
 Shielding Gas CO 2 Dew Point -40DEG F Flow Rate 50CFH  
 Single or Multiple Pass SINGLE (45 TO 63 CFH)  
 Single or Multiple Arc SINGLE  
 Welding Current DC  
 Polarity REVERSE ELECTRODE POSITIVE CTWD 3/4"  
 Welding Progression STRINGER  
 Root Treatment ROOT SHALL BE CLEAN AND FREE OF FOREIGN MATTER  
 Preheat and Interpass Temperature MIN PREHEAT 50 DEG ≤ 0.75" 70 DEG > 0.75" MAX INTERPASS 400 DEG  
 Postheat Temperature NONE  
 Heat Input Min 33.92 Max 50.42

**WELDING PROCEDURE**

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	310	25	11	
		320	26	12.1	
		TO 285	TO 24	TO 9.9	

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

Procedure No. 8005 Contractor Elderlee, Inc.  
 Revision No. 1 Authorized By RANDY SCOTT  
 Date 2/7/2017

**SHOP DRAWING REVIEW**

REVIEWED AS REQUIRED BY THE CONSTRUCTION CONTRACT DOCUMENTS AND APPROVED, BUT ONLY FOR COMPLIANCE TO THE DESIGN CONCEPT OF THE WORK, AND SUBJECT TO FURTHER LIMITATIONS AND REQUIREMENTS CONTAINED IN THE CONSTRUCTION CONTRACT DOCUMENTS.

REJECTED  REVISE AND RESUBMIT  APPROVED AS NOTED

CORRECTIONS OR COMMENTS MADE ON THE SHOP DRAWINGS DURING THIS REVIEW DID NOT RELIEVE CONTRACTOR FROM COMPLIANCE WITH REQUIREMENTS OF THE DRAWINGS AND SPECIFICATIONS. THIS CHECK IS ONLY FOR REVIEW OF GENERAL CONFORMANCE WITH THE DESIGN CONCEPT OF THE PROJECT AND GENERAL COMPLIANCE WITH THE INFORMATION GIVEN IN THE CONTRACT DOCUMENTS. THE CONTRACTOR IS RESPONSIBLE FOR CONFIRMING AND CORRELATING ALL QUANTITIES AND DIMENSIONS; SELECTING FABRICATION PROCESSES AND TECHNIQUES OF CONSTRUCTION; COORDINATING THEIR WORK WITH THAT OF ALL OTHER TRADES; AND PERFORMING THEIR WORK IN A SAFE AND SATISFACTORY MANNER.

CLD Consulting Engineers  
 240 Commercial Street  
 Manchester, NH 03101  
 603-668-6225

Job Number: 140116  
 Reviewed by: S. Beaumont  
 Date: 02/27/2017

Vermont Agency of Transportation  
**RECEIVED**

CK'D BY CLD/Ryan OK'D BY WPELLETIER  
 February 27, 2017

RESUBMIT nO Approved AsNoted  
 BY WPELLETIER DATE 03/02/2017