

WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE # 3
 Material Specification A36/A500GR.B/A53/A572GR.36/50/A709GR.36/50/A108 / A307/A325/A563/A449
 Welding Process FCAW
 Manual or Machine SEMAUTOMATIC
 Position of Welding FLAT/HORIZONTAL
 Filler Metal Specification A5.29
 Filler Metal Classification E81T1-NI1C-JH4 LINCOLN ULTERCORE 8111C-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. 8000 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 CONFORMANCE 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.

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

Vermont Agency of Transportation

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CK'D BY CLD/RYAN OK'D BY WPELLETIER
February 27, 2017
 RESUBMIT nO **Approved AsNoted**
 BY WPELLETIER DATE 03/02/2017