

WELDING PROCEDURE SPECIFICATION

Material Specification	PQR ELDERLEE #4		
Welding Process	A36/A572 GR. 36 / 50 / A709 GR. 36 / 50		
Manual or Machine	GMAW		
Position of Welding	SEMAUTOMATIC ROBOTIC		
Filler Metal Specification	FLAT		
Filler Metal Classification	A5.18		
Flux	L-56 ER70S-6 LINCOLN		
Shielding Gas	N/A		
Single or Multiple Pass	90% ARGON / 10% CO2	Dew Point	-40DEG F Flow Rate 45CFH
Single or Multiple Arc	SINGLE		
Welding Current	SINGLE		
Polarity	DC		
Welding Progression	REVERSE ELECTRODE POSITIVE CTWD 3/4"		
Root Treatment	STRINGER		
Preheat and Interpass Temperature	ROOT SHALL BE CLEAN AND FREE OF FOREIGN MATTER		
Postheat Temperature	MIN PREHEAT 50 DEG ≤ 0.75" 70 DEG > 0.75" MAX INTERPASS 400 DEG		
Heat Input	Min	10.56	Max 15.84

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	.045	190	22	19	
		171	20	18	
		TO	TO	TO	
		200	23	21	

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

Procedure No. 8001 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.

CLD Consulting Engineers 540 Commercial Street Manchester, NH 03101 603-688-8223	Job Number: <u>140116</u> Reviewed by: <u>S. Beaumont</u> Date: <u>02/27/2017</u>
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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