

WELDING PROCEDURE SPECIFICATION

| | | | |
|-----------------------------------|---|-----------|--------------------------|
| Material Specification | PQR ELDERLEE #3 | | |
| Welding Process | A36/A500GR.B/A53/A572GR.36/50/A709GR.36/50/A108 | | |
| Manual or Machine | FCAW | | |
| Position of Welding | SEMAUTOMATIC | | |
| Filler Metal Specification | FLAT | | |
| Filler Metal Classification | A5.29 | | |
| Flux | E81T1-Ni1C-JH4 LINCOLN ULTERCORE 81i1C-H | | |
| Shielding Gas | N/A | | |
| Single or Multiple Pass | CO 2 | Dew Point | -40DEG F Flow Rate 50CFH |
| Single or Multiple Arc | SINGLE (45 TO 63 CFH) | | |
| 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 | 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 | TO | TO | |
| | | 285 | 24 | 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 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
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 603-688-4223 Job Number: 120116
 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