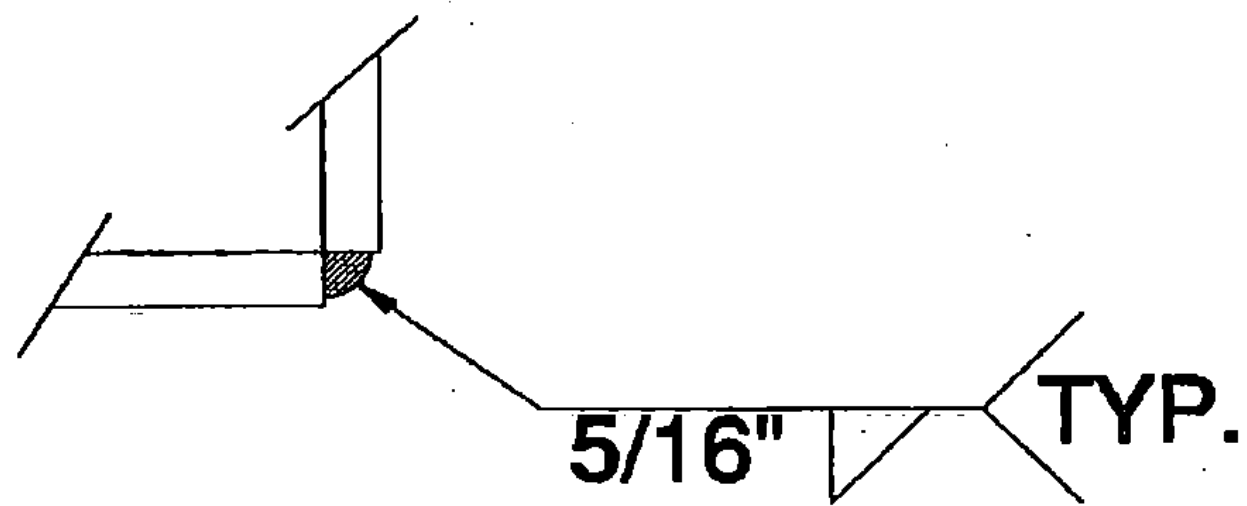


194 BRIDGE RAILING

WELDING PROCEDURE SPECIFICATION

Material Specification	PQR# ELDERLEE #1		
Welding Process	ASTM A572 GR. 50 CVN		
Manual or Machine	FCAW		
Position of Welding	SEMAUTOMATIC		
Filler Metal Specification	FLAT		
Filler Metal Classification	A5.20 - 95		
Flux	E71T-1H8 E71T-9H8 LINCOLN ULTRACORE		
Shielding Gas	CO 2	Dew Point	-40DEG F Flow Rate 50CFH
Single or Multiple Pass	SINGLE		
Single or Multiple Arc	SINGLE		
Welding Current	DC		
Polarity	REVERSE ELECTRODE POSITIVE		
Welding Progression	STRINGER		
Root Treatment	CLEAN AS PER SECTION 603 OF THE NYSSCM		
Preheat and Interpass Temperature	PREHEAT AS PER TABLE 708 OF THE NYSSCM		
Postheat Temperature	NONE		
Heat Input	Min	_____	Max _____

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	300	26	14	
Variable	LIMITS	270	24	12.6	
		TO 330	TO 28	TO 15.4	

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

Procedure No. <u>3005</u>	Contractor <u>Elderlee, Inc.</u>
Revision No. _____	Authorized By <u>RANDY SCOTT</u>
	Date <u>6/21/2010</u>