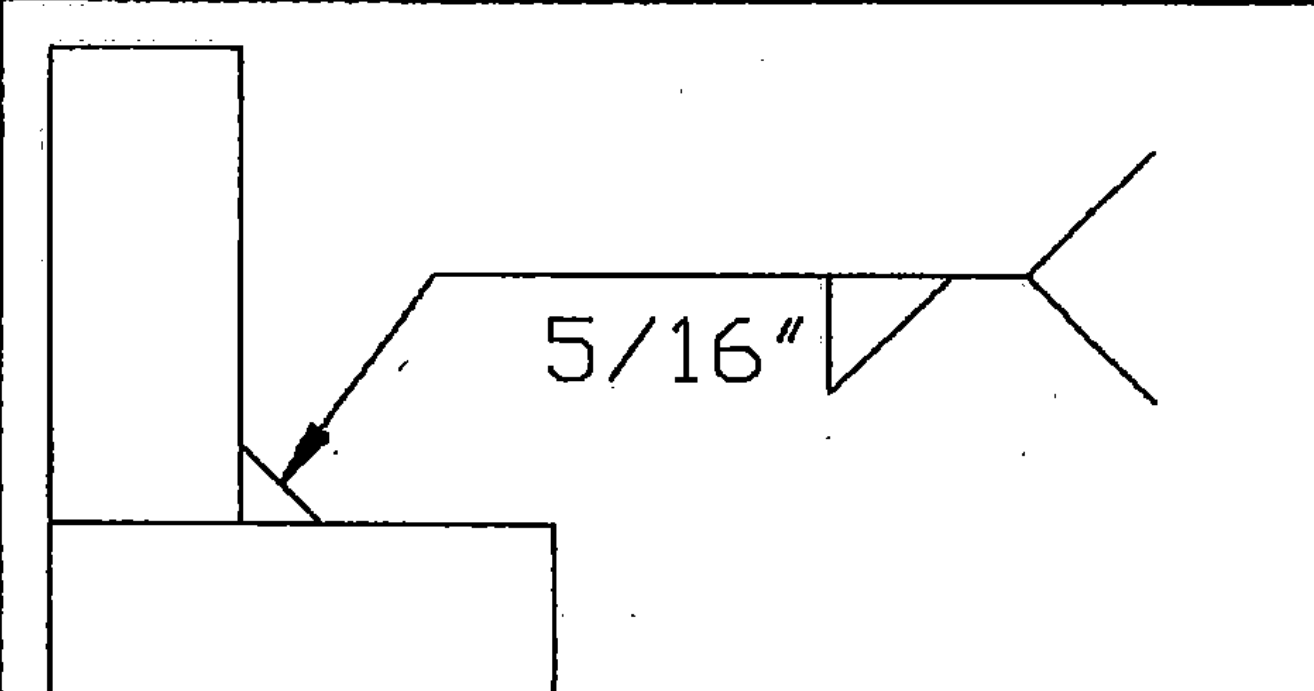


192 BRIDGE
RAILING

WELDING PROCEDURE SPECIFICATION

Material Specification	A572 TO A572
Welding Process	FCAW
Manual or Machine	SEMAUTOMATIC
Position of Welding	FLAT
Filler Metal Specification	A5.20 - 95
Filler Metal Classification	E71T-1H8 E71T-9H8 LINCOLN ULTRACORE
Flux	N/A
Shielding Gas	CO 2 Dew Point -40DEG F Flow Rate 50CFH
Single or Multiple Pass	SINGLE
Single or Multiple Arc	SINGLE
Welding Current	DC ELECTRODE POSITIVE
Polarity	REVERSE
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	 <p>ITEM 568 POST TO BASE PLATE</p>
Variable	LIMITS	270	24	12.6	
		TO 330	TO 28	TO 15.4	

Vermont Agency of Transportation
RECEIVED
 CK'D BY JWC OK'D BY TCF
 8:12am, Jun 29, 2010
 RESUBMIT APPROVED X
 BY KMH DATE 7-22-10

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

Procedure No. 3002 Contractor Elderlee, Inc.
 Revision No. _____ Authorized By RANDY SCOTT
 Date 4/5/2010