

STATE OF VERMONT  
 AGENCY OF TRANSPORTATION  
 ROUTE NO. VT 12 (MAJOR COLLECTOR),  
 BRIDGE NO. 42 PROJECT BR-0241(29)  
 ORANGE COUNTY TOWN OF RANDOLPH  
 WINTERSSET, INC.

COSMEC INC.

**WELDING PROCEDURE SPECIFICATION**

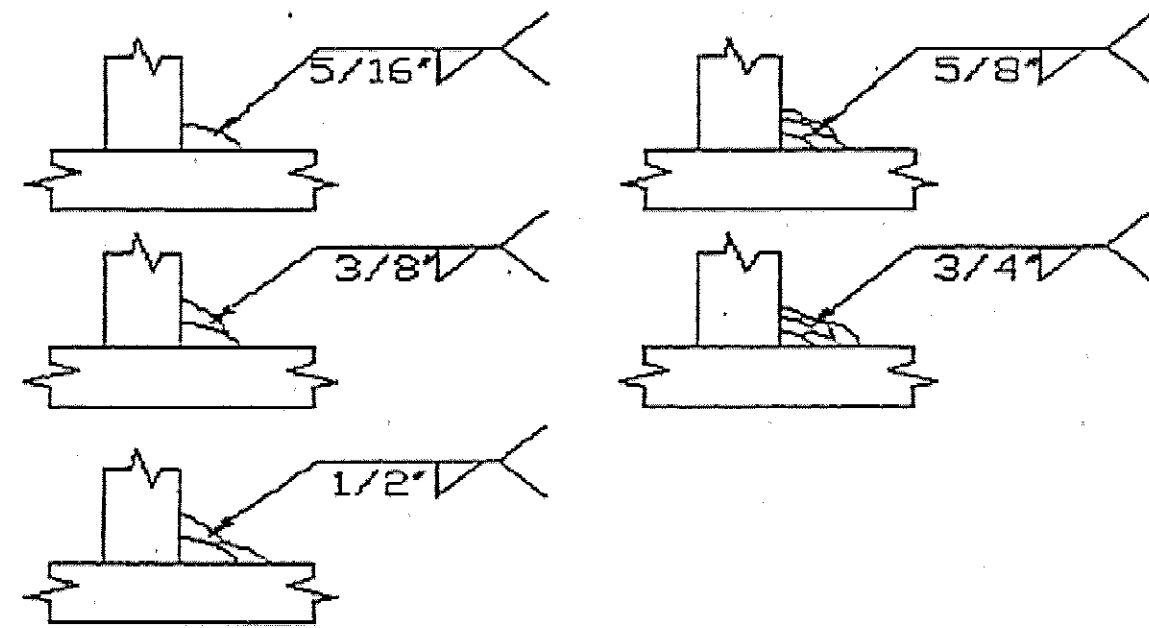
SPECIFICATIONS AND CODE: AASHTO--AWS D1.5  
 MATERIAL SPECIFICATION ASTM A709 GR 50W, GR 50, GR 36  
 WELDING PROCESS----- FCAW-G  
 MANUAL OR MACHINE----- SEMI-AUTOMATIC  
 POSITION OF WELDING----- 1F & 2F  
 FILLER METAL SPECIFICATION AWS 5.20 CLASSIFICATION: E71T  
 MANUFACTURER: LINCOLN ELECTRIC TRADENAME: E71T OUTERSHIELD  
 FLUX----- INTERNAL  
 SHIELDING GAS----- CO2 FLOW RATE 45 CFH  
 SINGLE OR MULTIPLE PASSES MULTIPLE  
 SINGLE OR MULTIPLE ARC SINGLE  
 WELDING CURRENT----- DC  
 POLARITY: REVERSE (EP)  
 WELDING PROGRESSION-----  
 ROOT TREATMENT----- CLEANED & PREPARED BRIGHT METAL  
 PREHEAT AND INTERPASS TEMPERATURE----- SEE BELOW  
 POSTHEAT TEMPERATURE N/A  
 HEAT INPUT MIN.----- MAX.-----

**WELDING PROCEDURE**

PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	VOLTS	TRAVEL SPEED	JOINT DETAIL
ALL	0.045	190-230	27-29	8-9	

**PREHEAT TEMPS.**

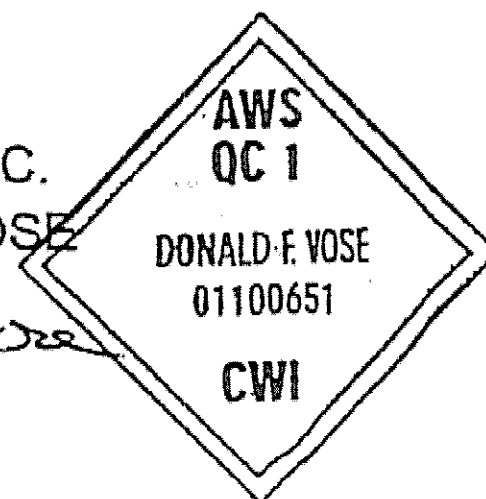
THICKNESS	TEMP.
UP TO 3/4"	50 DEG. F
OVER 3/4" TO 1 1/2"	70 DEG. F
OVER 1 1/2" TO 2 1/2"	150 DEG. F
OVER 2 1/2"	225 DEG. F
<b>INTERPASS TEMP:</b>	400 DEG. F



THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC.  
 WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5.

PROCEDURE NO. FCAW-FILLET  
 SUPPORTING PQR: FCAW-1.0-05  
 REVISION NO.

CONTRACTOR: COSMEC INC.  
 AUTHORIZED BY: DONALD VOSE



DATE: 1/31/2005

TRANS RECEIVED

CK'D BY \_\_\_\_\_ OK'D BY JUC

FEB 26 2007

RESUBMIT \_\_\_\_\_ APPROVED ✓

BY \_\_\_\_\_ DATE 3-9-07