

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

COSMEC INC.

**WELDING PROCEDURE SPECIFICATION**

SPECIFICATIONS AND CODE: D1.6

MATERIAL SPECIFICATION ASTM A240 TYPE 304 TO ASTM A709 GR 50W

WELDING PROCESS-----GTAW

MANUAL OR MACHINE-----MANUAL

POSITION OF WELDING-----1F & 2F

FILLER METAL SPECIFICATION ER309L

CLASSIFICATION: A5.9

MANUFACTURER: HARRIS WELCO

TRADENAME:

FLUX-----INTERNAL

SHIELDING GAS-----ARGON

FLOW RATE 45 CFH

SINGLE OR MULTIPLE PAS S SINGLE

SINGLE OR MULTIPLE ARC SINGLE

WELDING CURRENT-----DC

POLARITY: REVERSE (EN)

WELDING PROGRESSION-----

ROOT TREATMENT-----CLEANED & PREPARED BRIGHT METAL

PREHEAT AND INTERPASS TEMPERATURE-----SEE BELOW

POSTHEAT TEMPERATURE N/A

HEAT IMPUT MIN.-----MAX.---

**WELDING PROCEDURE**

PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	VOLTS	TRAVEL SPEED	JOINT DETAIL
ALL	3/32"	130-155	14-17	6.75-8.5	LAP JOINT
16 GA THRU 10 GA BM THICKNESS					

THICKNESS	PREHEAT TEMP.
UP TO 3/4"	100 DEG.
OVER 3/4" TO 1 1/2"	100 DEG.
OVER 1 1/2" TO 2 1/2"	100 DEG.
OVER 2 1/2"	100 DEG.

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

SUPPORTING PQR: GTAW-WF-05  
 PROCEDURE NO. GTAW-WF

CONTRACTOR: COSMEC INC.  
 AUTHORIZED BY: DONALD VOSE  
 CWI#:01100651

*Donald Vose*

REVISION NO. 1

DATE:--- 2/1/2005

TRANS RECEIVED

OK'D BY \_\_\_\_\_ OK'D BY *JWC*

FEB 26 2007

RESUBMIT \_\_\_\_\_ APPROVED

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

