

### Welding Procedure Specification

Material specification AST2 GRADE 50  
 Welding process SMAW  
 Manual or machine MANUAL  
 Position of welding HORIZONTAL & VERTICAL  
 Filler metal specification AWS A5.1  
 Filler metal classification E7018  
 Flux \_\_\_\_\_  
 Shielding gas N/A Flow rate \_\_\_\_\_  
 Single or multiple pass SINGLE  
 Single or multiple arc SINGLE  
 Welding current AC/DC  
 Polarity DCEP  
 Welding progression STINGER  
 Root treatment CLEAN TO REMOVE ALL CONTAMINANTS  
 Preheat and interpass temperature PRE-HEAT AS NEEDED  
 Postheat treatment \_\_\_\_\_

#### WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
	$\frac{1}{8}$ "	60-140	7-10	VARIES	<p style="text-align: center;">PILE TIP &amp; SPICE CONNECTOR</p>

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5. (of the AASHTO/AWS D1.5 Bridge Welding Code and latest revision)

Procedure no. \_\_\_\_\_ Contractor CCS CONSTRUCTIONS, INC  
 Revision no. \_\_\_\_\_ Authorized by Brian Hubbard  
 Welder \_\_\_\_\_ Date 12/30/15