

STATE OF VERMONT
AGENCY OF TRANSPORTATION
PROJECT BHF-020019

ROUTE NO. 17 (MAJOR COLLECTOR)
BELT NO. 36
TOWN OF FAIRVIEW

COSMEC INC.

WELDING PROCEDURE SPECIFICATION

SPECIFICATIONS AND CODE: D1.8
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
MANUFACTURER: HARRIS WELCO
FLUX: INTERNAL
SHIELDING GAS: ARGON
SINGLE OR MULTIPLE PASSES: 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 INPUT: MIN. MAX.

CLASSIFICATION: A5.9
TRADE NAME:
FLOW RATE: 45 CFH
RESUBMIT BY: DATE: 10-31-06

VTRANS RECEIVED

OCT 18 2006

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	TRAVEL SPEED VOLTS	JOINT DETAIL
ALL	3/32"	130-155	14-17	LAP JOINT

PREHEAT TEMPS. ***PREHEAT UNTIL NO MOISTURE PRESENT
THICKNESS T 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
CW#01100651

REVISION NO. 1
DATE: 2/1/2005



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