

**NYSDOT
METALS ENGINEERING
REVIEW**

**X APPROVED
APPROVED AS NOTED
DISAPPROVED**

R. P. Piniello
7/15/08

WELDING PROCEDURE SPECIFICATION

Material Specification STOCK PQR # ELDERLEE #1
 Welding Process A572 GRD 50 /A992-06a
 Manual or Machine FCAW
 Position of Welding SEMAUTOMATIC
 Filler Metal Specification FLAT
 Filler Metal Classification A5 20
 Flux E70 LINCOLN OUTERSHEILD
 Shielding Gas N/A
 Single or Multiple Pass CO 2 Dew Point -40DEG F Flow Rate 50 CFM
 Single or Multiple Arc SINGLE (45 TO 63 CFM)
 Welding Current N/A
 Polarity DC
 Welding Progression DCEP
 Root Treatment STRINGER
 Preheat and Interpass Temperature CLEAN AS PER SECTION 603 OF THE NYSSCM
 Postheat Temperature PREHEAT AS PER TABLE 708 OF THE NYSSCM
 Heat Input NONE
 Min _____ Max _____

WELDING PROCEDURE

Pass no	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	3/32	390	27	12	
Variable	LIMITS	351	25	11	
		TO 429	TO 29	TO 13	

CK'D BY _____ OK'D BY JWC
JUL 15 2008
 BY KML APPROVED ✓
 DATE 7-24-09

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

Procedure No 1010-1
 Revision No _____

Contractor Elderlee Inc
 Authorized By RANDY SCOTT
 Date 6/18/2008