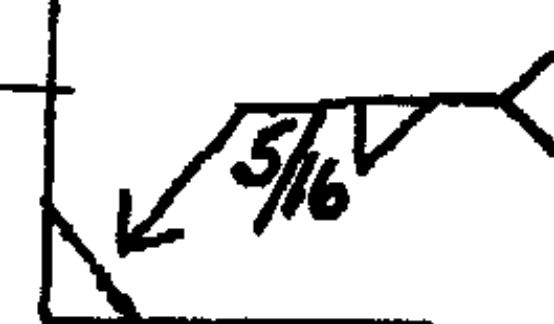


WELDING PROCEDURE SPECIFICATION

Material Specification A500 GR B A36
 Welding Process FCAW
 Manual or Machine SEMAUTOMATIC
 Position of Welding FLAT
 Filler Metal Specification A5 20 - 95
 Filler Metal Classification E71T-1H8 E71T-9H8 LINCOLN ULTRACORE
 Flux N/A
 Shielding Gas CO 2 Dew Point -40DEG F Flow Rate 50CFH
 Single or Multiple Pass SINGLE
 Single or Multiple Arc SINGLE
 Welding Current DC
 Polarity (REVERSE) ELECTRODE POSITIVE
 Welding Progression STRINGER
 Root Treatment CLEAN AS PER SECTION 603 OF THE NYSSCM
 Preheat and Interpass Temperature PREHEAT AS PER TABLE 708 OF THE NYSSCM
 Postheat Temperature NONE
 Heat Input Min _____ Max _____

WELDING PROCEDURE

| Pass no | Electrode size | Welding Current | | Travel speed | Joint detail |
|----------|----------------|-----------------|----------|--------------|--|
| | | Amperes | Volts | | |
| 1 | 1/16 | 300 | 26 | 14 |  |
| Variable | LIMITS | 270 | 24 | 12.6 | |
| | | TO 330 | TO 28 | TO 14 | |

RECEIVED
 JUL 15 2009
 OK'D BY JWC
 APPROVED
 DATE 7-22-09

NYSDOT METALS ENGINEERING REVIEW
 APPROVED AS NOTED
 DISAPPROVED
 E. Vignarella
 1/12/09

ITEM 568
 POST TO BASE R

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

Procedure No 1037 Contractor Elderlee, Inc
 Revision No _____ Authorized By RANDY SCOTT
 Date 12/4/2008