

STATE OF VERMONT
AUTHORITY OF TRANSPORTATION
PROJ. NO. HP 0283(8)S
MONTGOMERY, VT

COSMEC INC.
WELDING PROCEDURE SPECIFICATION

VTRAAS
RECEIVED

SPECIFICATIONS AND CODE: D1.6 (D1.3)
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
TRADENAME:
FLOW RATE 45 CFH

RESUBMIT APPROVED
BY DATE 4/4/06

OK'D BY OK'D BY
APR 03 2006

WELDING PROCEDURE

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

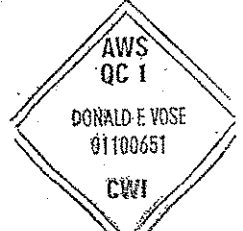
16 GA THRU 10 GA
BM THICKNESS

PREHEAT TEMPS. ***PREHEAT UNTIL NO MOISTURE PRESENT
THICKNESS TTEMP.
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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