

VERMONT
AGENCY OF TRANSPORTATION
MONTPELIER
PROJECT BRO 1445 (29)

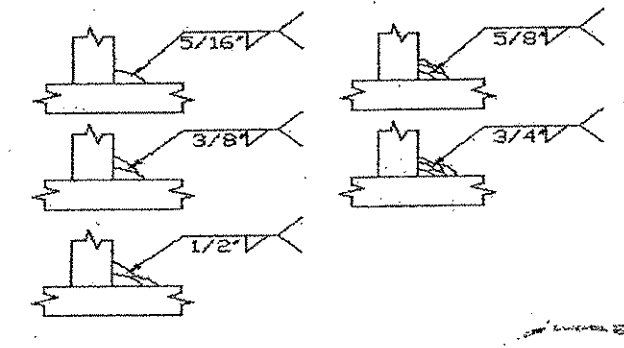
COSMEC INC.
WELDING PROCEDURE SPECIFICATION

SPECIFICATIONS AND CODE: AASHTO-AWS D1.5
MATERIAL SPECIFICATION ASTM A709 GR 50W, GR 50, GR 38
WELDING PROCESS FCAW-G
MANUAL OR MACHINE SEMI-AUTOMATIC
POSITION OF WELDING 1F & 2F
FILLER METAL SPECIFICATION AWS 5.20 CLASSIFICATION: E71T
MANUFACTURER: LINCOLN ELECTRIC TRADENAME: E71T OUTERSHIELD
FLUX INTERNAL FLOW RATE 45 CFH
SHIELDING GAS CO2
SINGLE OR MULTIPLE PASSES MULTIPLE
SINGLE OR MULTIPLE ARC SINGLE
WELDING CURRENT DC
POLARITY: REVERSE (EP)
WELDING PROGRESSION
ROOT TREATMENT CLEANED & PREPARED BRIGHT METAL
PREHEAT AND INTERPASS TEMPERATURE SEE BELOW
POSTHEAT TEMPERATURE N/A
HEAT INPUT MIN. MAX.

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	WELDING VOLTAGE VOLTS	TRAVEL SPEED	JOINT DETAIL
ALL	0.045	190-230	27-29	8-9	

PREHEAT TEMPS.
THICKNESS T TEMP.
UP TO 3/4" 50 DEG. F
OVER 3/4" TO 1 1/2" 70 DEG. F
OVER 1 1/2" TO 2 1/2" 150 DEG. F
OVER 2 1/2" 225 DEG. F
INTERPASS TEMP: 400 DEG. F



THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC. WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5.

PROCEDURE NO. FCAW-FILLET
SUPPORTING PQR: FCAW-1.0-05
REVISION NO.

CONTRACTOR: COSMEC INC.
AUTHORIZED BY: DONALD VOSE
DATE: 1/31/2005



TRANS RECEIVED
OK'D BY: JWC
DEC 14 2006
RESUBMIT APPROVED
BY: DATE 12-18-06

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