

CAROLINA STEEL FABRICATION INC.
NASH COUNTY PLANT

VERMONT PROJECT: VT # BR01445 (29)		CSC JOB NO.: 18362H25			
BRIDGE: #42 East Street (TH #4)					
REFERENCE SPECS: AWS D1.5-02, VT-DOT STD SPECS - 2001					
STRUCTURE: BRIDGE IN HUNTINGTON, VT.					
JOINT WELDING PROCEDURE SPECIFICATION					
MATERIAL SPECIFICATION: M270-50W					
WELDING PROCESS: SUBMERGED ARC WELDING					
MANUAL OR MACHINE: MACHINE (STIFFENER WELDER)					
POSITION OF WELDING: 2F-HORIZONTAL					
FILLER METAL SPECIFICATION: AWS A5.23					
FILLER METAL CLASSIFICATION: F7A4 EM12K - H8 LINCOLN L-61					
ELECTRODE STICKOUT: 3/4"		SHIELDING GAS: NA			
FLUX: F7A4-LINCOLN AXXX10		SINGLE OR MULTIPLE PASS: SEE BELOW			
SINGLE OR MULTIPLE ARC: SINGLE					
WELDING CURRENT: DC-(STRAIGHT)					
WELDING PROGRESSION: NA					
ROOT TREATMENT: PER AWS D1.5 PARAGRAPH 3.2.1					
PREHEAT & INTERPASS TEMPERATURE: PER AASHTO TABLE 4.4					
HEAT INPUT MAXIMUM: 72 MINIMUM: 43.2					
MAXIMUM INTERPASS TEMPERATURE: 316°C / 600 F					
PASS NO.	ELECTRODE SIZE	WELDING CURRENT		TRAVEL SPEED IPM	JOINT DETAIL FILLETS
		AMPERES	VOLTS		
1	3/32"	400 - 450	28 - 32	12 - 15	1/4"
1	3/32"	400 - 450	28 - 32	12 - 15	5/16"
*THE MAXIMUM SINGLE PASS FILLET WELD SHALL NOT EXCEED 5/16**					
NON-FCM PROCEDURE					
THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE ECT., WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5- AWS D1.5.					
PROCEDURE NO. 3N34 REV. 0		APPROVED BY: <i>[Signature]</i>			
WPQR REFERENCE NO.: 213-FC & CSC 142 B		QUALITY CONTROL SUPERVISOR			
PREHEAT					
THICKNESS	TEMP.	OCT 11 2006 RECEIVED VTRASS JWC OCT 11 2006 RESUBMIT APPROVED BY DATE 10/30/06			
UP TO 3/4"	50F				
OVER 3/4" TO 1-1/2"	70F				
OVER 1-1/2" TO 2-1/2"	150F				
OVER 2-1/2"	225F				