

CAROLINA STEEL FABRICATION INC.
NASH COUNTY PLANT

VERMONT PROJECT: VT# BRO 1445 (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
 POSITION OF WELDING: 1F-FLAT
 FILLER METAL SPECIFICATION: AWS A5.23
 FILLER METAL CLASSIFICATION: F7A4 EM12K - H8 LINCOLN L-81
 ELECTRODE STICKOUT: 1" SHIELDING GAS: NA
 FLUX: LINCOLN F7A4 AXXX10 SINGLE OR MULTIPLE PASS: SINGLE
 SINGLE OR MULTIPLE ARC: MULTIPLE
 WELDING CURRENT: DC - (REVERSE)
 WELDING CURRENT: DC (LEAD), AC (TRAIL)
 ROOT TREATMENT: PER AWS D1.5 PARAGRAPH 3.2.1
 PREHEAT & INTERPASS TEMPERATURE: PER AASHTO TABLE 4.4
 HEAT INPUT: MAXIMUM 112.2 MINIMUM: 87.3
 MAXIMUM INTERPASS TEMPERATURE: 316°C / 600 F

PASS NO.	ELECTRODE SIZE	WELDING CURRENT		TRAVEL SPEED IPH	JOINT DETAIL FILLETS
		AMPERES	VOLTS		
1	3/16"	DC 750 - 850	30 - 32	30 - 40	1/4"
	3/16"	AC 725 - 825	32 - 35		
1	3/16"	DC 750 - 850	30 - 32	30 - 40	5/16"
	3/16"	AC 725 - 825	32 - 35		

STICKOUT: _____ ARC SPACING: _____
 DC 1" TO 1-1/2" 5/8" TRACTOR WELDER
 AC 1" TO 1-1/2" 5/8" WITH 10 DEGREE TILT

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.: 3N43 REV. 0 APPROVED BY: *[Signature]*
 WPQR REFERENCE NO.: CSC 208 - FC & CSC 143 A QUALITY CONTROL SUPERVISOR

THICKNESS	TEMP.
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

RECEIVED
 OCT 11 2006
 DATE 10-30-06

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