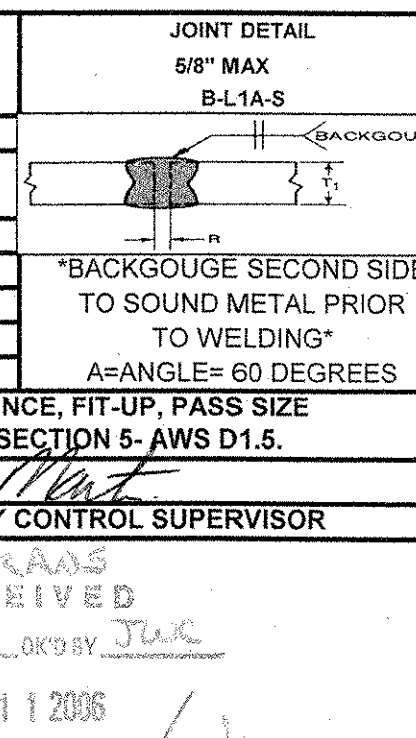


CAROLINA STEEL FABRICATION INC.
NASH COUNTY PLANT

VERMONT PROJECT: VT# BR0 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			
MANDUAL OR MACHINE: MACHINE AND SEMI-AUTO			
POSITION OF WELDING: TG (FLAT GROOVE)			
FILLER METAL SPECIFICATION: AWS A5.23			
FILLER METAL CLASSIFICATION: F7A4-EM12K-H8 (LINCOLN L-61)			
FLUX: F7A4-LINCOLN AXXX10		SHIELDING GAS: NA	
ELECTRODE STICKOUT: 3/4"		SINGLE OR MULTIPLE PASS: MULTIPLE	
SINGLE OR MULTIPLE ARC: SINGLE			
WELDING CURRENT: DC-REVERSE			
WELDING PROGRESSION: NA			
ROOT TREATMENT: PER AWS D1.5 PARAGRAPH 3.2.1			
PREHEAT & INTERPASS TEMPERATURE: PER AASHTO TABLE 4.4(SEE BELOW)			
HEAT INPUT MAXIMUM & MINIMUM: 57.6			
MAXIMUM INTERPASS TEMPERATURE: 318°C / 600 F			
PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	VOLTS
ALL	3/32"	430-500	29-32
			TRAVEL SPEED IPM
			10 - 13
* POSITION FLAT GROOVE *			
T1= BASE METAL	R= ROOT	R= ROOT FACE	
OVER 1/2" TO 1"	0	1/4" MINIMUM	
OVER 1" TO 1-1/2"	0	3/8" MINIMUM	
OVER 1-1/2" TO 2"	0	1/2" MINIMUM	
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.: 3N47 REV. 0		APPROVED BY: <i>[Signature]</i>	
WPQR REFERENCE NO.: CSC 207 - FC		QUALITY CONTROL SUPERVISOR	
PREHEAT			
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		

BY _____ DATE 10-30-06



TRANS RECEIVED
OCT 11 2006
RESUBMIT APPROVED