

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: 1G (FLAT GROOVE)			
FILLER METAL SPECIFICATION: AWS A5.23			
FILLER METAL CLASSIFICATION: F7A4-EM12K - H8 (LINCOLN L-81)			
FLUX: F7A4- LINCOLN XXXX10		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			
HEAT INPUT MAXIMUM 95 MINIMUM: 57.6			
MAXIMUM INTERPASS TEMPERATURE: 316°C / 600 F			
PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	TRAVEL SPEED IPM
		VOLTS	JOINT DETAIL
ALL	3/32"	430-500	28-32 10T013
"POSITION- 1G FLAT"			
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"			"BACKGOUGE SECOND SIDE TO SOUND METAL PRIOR TO WELDING" A=ANGLE= 60 DEGREES
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.: 3N48 REV. 0		APPROVED BY: <i>[Signature]</i>	
WIPOR 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	