

CAROLINA STEEL FABRICATION INC.  
NASH COUNTY PLANT

VERMONT PROJECT: VT# BRO 1445 (29)		CSC JOB NO.: 18382H25			
BRIDGE: #42 East Street (TH #4)					
REFERENCE SPECS: AWS D1.5-02, VT-DOT STD SPECS - 2001					
STRUCTURE: BRIDGE IN HUNTINGTON VT					
<b>JOINT WELDING PROCEDURE SPECIFICATION</b>					
MATERIAL SPECIFICATION: M270-50W					
WELDING PROCESS: SHIELDED METAL ARC WELDING (SMAW)					
MANUAL OR MACHINE: MANUAL					
POSITION OF WELDING: 1F-FLAT & 2F-HORIZONTAL					
FILLER METAL SPECIFICATION: AWS A5.5					
FILLER METAL CLASSIFICATION: E8018-C3					
FLUX: NA		SHIELDING GAS: NA			
FLOW RATE: NA		SINGLE OR MULTIPLE PASS: (SEE BELOW)			
SINGLE OR MULTIPLE ARC: SINGLE					
WELDING CURRENT: AC					
WELDING PROGRESSION: NA					
ROOT TREATMENT: PER AWS D1.5 PARAGRAPH 3.2.1					
PREHEAT & INTERPASS TEMPERATURE: PER AASHTO TABLE 4.4					
MAXIMUM INTERPASS TEMPERATURE: 300 F					
PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	VOLTS	TRAVEL SPEED IPM	JOINT DETAIL FILLETS
ALL	5/32"	140-225	23-27	NA	3/16" TO 3/8"
ALL	3/16"	230-305	23-27	NA	3/16" TO 3/8"
ALL	7/32"	270-365	23-27	NA	3/16" TO 3/8"
ALL	1/4"	315-400	23-27	NA	3/16" TO 3/8"
* THE MAXIMUM SIZE SINGLE PASS FILLET WELD SHALL BE 5/16" FOR THE HORIZONTAL POSITION AND 3/8" FOR THE FLAT POSITION. *					
*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.: 3N6-10 REV. 0.		APPROVED BY: <i>[Signature]</i>			
WPQR REFERENCE NO.: NA		QUALITY CONTROL SUPERVISOR			
PREHEAT		RECEIVED			
THICKNESS	TEMP.	OK'D BY: <i>[Signature]</i> OCT 11 2006			
UP TO 3/4"	50F	RESUBMIT: _____ APPROVED: _____			
OVER 3/4" TO 1-1/2"	70F	DATE 10-30-06			
OVER 1-1/2" TO 2-1/2"	150F				
OVER 2-1/2"	225F				