

WELDING PROCEDURE SPECIFICATION

Material Specification ASTM-A500-A53-GRADE B TO A36
 Welding Process FCAW
 Manual or Machine SEMAUTOMATIC
 Position of Welding 5G
 Filler Metal Specification A5.20
 Filler Metal Classification E71T-1/T-1M ESAB DUAL SHIELD 7000
 Flux N/A
 Shielding Gas CO 2 Dew Point -40DEG F FLOW RATE 50 CFH
 Single or Multiple Pass SINGLE
 Single or Multiple Arc SINGLE
 Welding Current DC
 Polarity REVERSE ELECTRODE POSITIVE
 Welding Progression STRINGER
 Root Treatment PER D1.1
 Preheat and Interpass Temperature PER D1.1
 Postheat Temperature NONE
 Heat Input Min _____ Max _____

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	.035	110	21	6IPM	
Variable	LIMITS	121	23	7	
		TO 99	TO 19	TO 5	

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure No. 3013
 Revision No. _____

Contractor Elderlee, Inc.
 Authorized By RANDY SCOTT
 Date 6/21/2012

Form III-2

Vermont Agency of Transportation
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