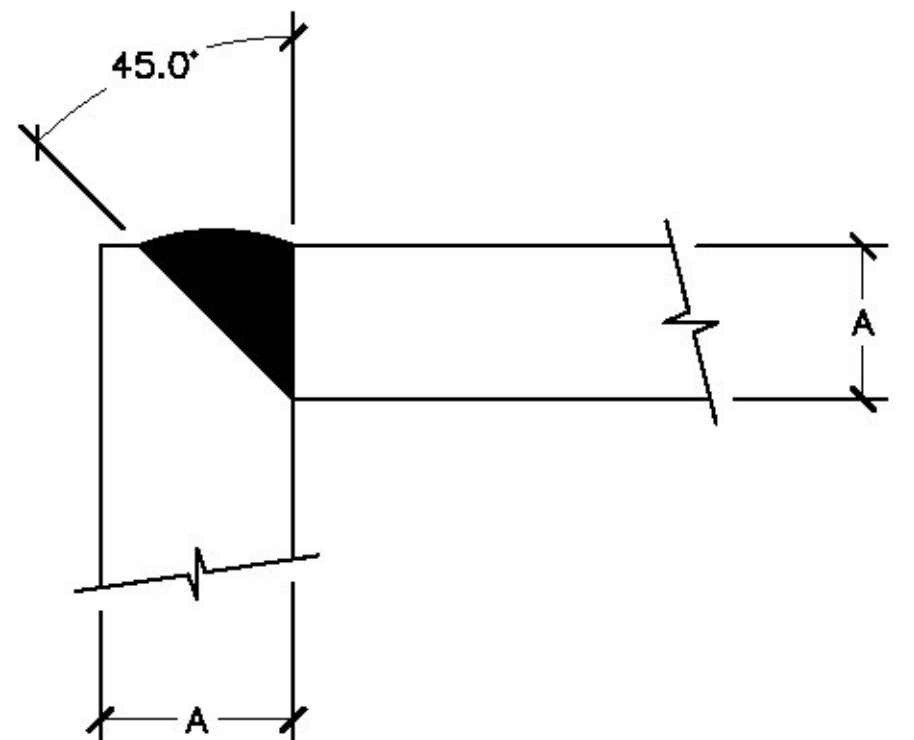
	WELDING PROCEDURE		NO. RB-GW-001	SHEET: 1 OF 4	
	DATE: 4/8/2014	PROJECT NAME: GUILFORD			
BY: A. DUNKLEE	PROJECT NO. BRO 1442(36)				
283 FT. BRIDGMAN RD. VERNON VT., 05354 PH. (802)257-7383 FAX (802)257-7308	AWS CODE:	PQR REF. NO: N/A			
MATERIAL SPECIFICATION:		ASTM 709 GR. 36-50			
WELDING PROCESS:		SMAW			
MANUAL, SEMI-AUTOMATIC OR AUTOMATIC:		MANUAL			
WELDING POSITION:		1G			
FILLER METAL SPECIFICATION:		ANSI/AWS A5.1-A5.5			
FILLER METAL CLASSIFICATION:		E7018			
FLUX:		N/A			
SHIELDING GAS:		N/A	FLOW RATE:	N/A	
SINGLE OR MULTIPLE PASS:		MULTIPLE			
SINGLE OR MULTIPLE ARC:		SINGLE			
WELDING CURRENT:		DC		APPROVAL STAMP	
WELDING POLARITY:		ELECTRODE POSITIVE			
WELDING PROGRESSION:		N/A			
ROOT TREATMENT:		REMOVE ALL IMPURITIES & GALV.			
PREHEAT & INTERPASS TEMPERATURE:		$\geq 1\frac{1}{2}" = 70^{\circ}\text{F}$ $1\frac{1}{2}" - 2\frac{1}{2}" = 150^{\circ}\text{F}$ OVER $2\frac{1}{2}" = 225^{\circ}\text{F}$			
POSTHEAT TREATMENT:		N/A			
HEAT INPUT:		MIN:	N/A		MAX:
ELECTRODE STICKOUT:		N/A			
PASS NO.	ELECTRODE SIZE:	WELDING CURRENT AMPS	WELDING CURRENT VOLTS	TRAVEL SPEED	JOINT DETAIL: HP14X89 PILE POINT
AS REQ.	3/32" 1/8"	70-110 70-170		ADJUST AS REQ.	
NOTES:					
MIN. WELD SIZE- 5/16" GRIND ALL BURRS, ENSURE FLUSH POINT FIT. PILE GRADE: A572-50					
A- VARIES (ADJUST PREHEAT TEMP AS REQ.)					

Vermont Agency of Transportation
RECEIVED
 CK'D BY MJC OK'D BY JWC
 May 30, 2014
 RESUBMIT No Approved
 BY M. J. Chenette DATE 06/05/2014

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