

	WELDING PROCEDURE		NO. RB-FW-001	SHEET: 2 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 572 GR. 50				
WELDING PROCESS:	SMAW				
MANUAL, SEMI-AUTOMATIC OR AUTOMATIC:	MANUAL				
WELDING POSITION:	ALL				
FILLER METAL SPECIFICATION:	ANSI/AWS A5.1-A5.5				
FILLER METAL CLASSIFICATION:	E7018				
FLUX:	N/A				
SHIELDING GAS:	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:	≥1½"=70°F 1½"-2½"=150°F OVER 2½"=225°F				
POSTHEAT TREATMENT:	N/A				
HEAT INPUT:	MIN:	N/A	MAX:		N/A
ELECTRODE STICKOUT:	N/A				
PASS NO.	ELECTRODE SIZE:	WELDING CURRENT AMPS	WELDING CURRENT VOLTS	TRAVEL SPEED	
AS REQ.	3/32"	70-110		ADJUST AS REQ.	
	1/8"	70-170			
JOINT DETAIL: HP 14X89 PILE CAP 					
NOTES: ALL MATERIAL TO BE A572 GR. 50 PILE CAP SIZE: 1"X14"X14" GRIND SURFACES FLAT AND SMOOTH PRIOR TO WELDING A- VARIES (ADJUST PREHEAT TEMP AS REQ.)					