



**WELDING PROCEDURE** NO. RB-GW-002 SHEET: 4 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: 2G  
 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

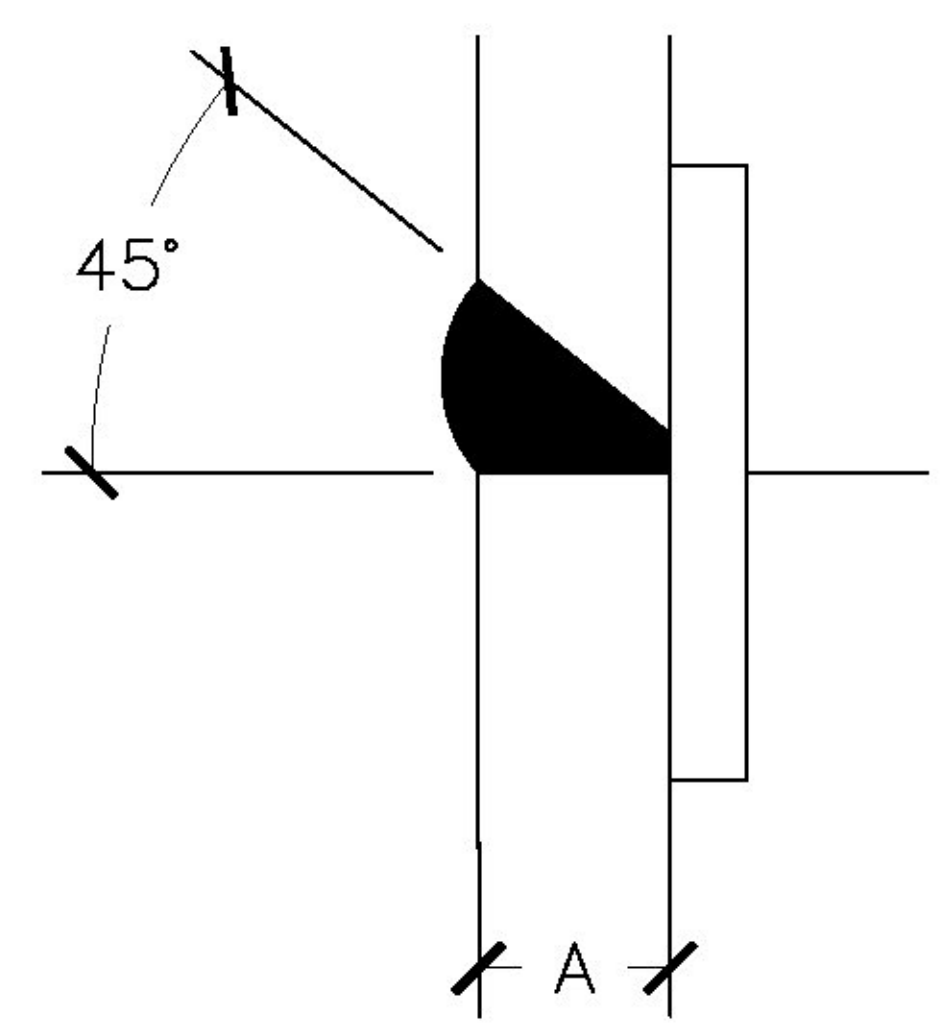
Vermont Agency of Transportation  
**RECEIVED**  
 CK'D BY MJC OK'D BY JWC  
 May 30, 2014  
 RESUBMIT No Approved  
 BY M. J. Chenette DATE 06/05/2014

WELDING CURRENT: DC  
 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: N/A  
 ELECTRODE STICKOUT: N/A

APPROVAL STAMP

PASS NO.	ELECTRODE SIZE:	WELDING CURRENT		TRAVEL SPEED
		AMPS	VOLTS	
AS REQ.	3/32"	70-110		ADJUST AS REQ.
	1/8"	70-170		

JOINT DETAIL: HP 14X89 PILE SPLICE



NOTES:  
 ALL MATERIAL TO BE A572 GR. 50  
 ROOT OPENING- 1/8" MIN.  
 1/4"X2" BACKING STRIP

A- VARIES (ADJUST PREHEAT TEMP AS REQ.)

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