

Fairfield BRF 0231(25) & BRO 1448(41)

**Welding Procedure Specification**

Material specification Grade 50  
 Welding process SMAW  
 Manual or machine manual  
 Position of welding all positions  
 Filler metal specification NR311 AS-1  
 Filler metal classification E-7018  
 Flux N/A  
 Shielding gas N/A Flow rate N/A  
 Single or multiple pass as required  
 Single or multiple arc N/A  
 Welding current P.C  
 Polarity regular  
 Welding progression as required  
 Root treatment none  
 Preheat and interpass temperature 50-175  
 Postheat treatment N/A

**WELDING PROCEDURE**

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
As req	5/32	120-240	22-27	As req	<p>3/8 Groove Weld HP 12 x 84</p>

Vermont Agency of Transportation  
**RECEIVED**

CK'D BY \_\_\_\_\_ OK'D BY JC  
 May 29, 2015  
 RESUBMIT NO Approved  
 BY RY \_\_\_\_\_ DATE 6-1-2015

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5. (of the AASHTO/AWS D1.5 Bridge Welding Code and latest revision)

Procedure no. \_\_\_\_\_ Contractor AL St. Orge Contractor Inc  
 Revision no. \_\_\_\_\_ Authorized by Randy St. Orge  
 Welder \_\_\_\_\_ Date 5/29/15