

**WELDING PROCEDURE SPECIFICATION**

PQR ELDERLEE #3

Material Specification ASTM A500 GR. B / ASTM A709 GR. 36 CVN  
 Welding Process FCAW-G  
 Manual or Machine SEMAUTOMATIC  
 Position of Welding FLAT/HORIZONTAL  
 Filler Metal Specification A5.29  
 Filler Metal Classification E81T1-Ni1C-JH4  
 Flux N/A  
 Shielding Gas CO 2 Dew Point -40DEG F Flow Rate 50CFH  
 Single or Multiple Pass SINGLE  
 Single or Multiple Arc SINGLE  
 Welding Current DC  
 Polarity REVERSE ELECTRODE POSITIVE  
 Welding Progression STRINGER  
 Root Treatment PER D1.5  
 Preheat and Interpass Temperature PER D1.5  
 Postheat Temperature NONE  
 Heat Input Min \_\_\_\_\_ Max \_\_\_\_\_

Vermont Agency of Transportation  
**RECEIVED**  
 CK'D BY \_\_\_\_\_ OK'D BY RF \_\_\_\_\_  
 February 11, 2016  
 RESUBMIT NO \_\_\_\_\_ Approved \_\_\_\_\_  
 BY KH \_\_\_\_\_ DATE 02/16/2016

**WELDING PROCEDURE**

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	310	25	11	
Variable	LIMITS	341	27	12	
		TO 269	TO 23	TO 10	

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

Procedure No. 3037  
 Revision No. \_\_\_\_\_

Contractor Elderlee, Inc.  
 Authorized By RANDY SCOTT  
 Date 12/1/2014