

WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE #3

Material Specification A709 TO A500 GR B
 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 D1.5
 Preheat and Interpass Temperature D1.5
 Postheat Temperature NONE
 Heat Input Min _____ Max _____

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. 3009

Contractor Elderlee, Inc.

Revision No. _____

Authorized By RANDY SCOTT

Date 3/20/2014

Vermont Agency of Transportation
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 CK'D BY GL OK'D BY JS
 January 9, 2015
 RESUBMIT no _____ Approved
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