

**PREQUALIFIED JOINT WELDING PROCEDURE
PROCEDURE SPECIFICATION**

Material specification Grade 50
 Welding process SMAW
 Manual or machine Manual
 Position of welding all Positions
 Filler metal specification A5.1
 Filler metal classification E7018
 Flux N/A
 Weld metal grade* —
 Shielding gas N/A Flow rate —
 Single or multiple pass Multiple
 Single or multiple arc Single
 Welding current DC
 Polarity Reverse
 Welding progression Tack 1" 3 locations on flange then stringer head alternating flanges
 Root treatment Grind and wire brush
 Preheat and interpass temperature Per AWS D1.5
 Postheat treatment none

*Applicable only when filler metal has no AWS classification.

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
A11	5/32	180	30	4"/min	Pile Point welding Detail (see attached)

Vermont Agency of Transportation

RECEIVED

CK'D BY _____ OK'D BY JC

February 19, 2015

RESUBMIT NO **Approved**
 BY KH DATE 3-9-2015

CONTRACTOR:
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