



Identification #	480	Rev.
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AWS D1.5

Single Pass Fillet weld in 1F position, No bigger than 3/8 in a single pass
Single Pass Fillet weld in 2F, 4F position, No bigger than 5/16 in a single pass
Single Pass Fillet weld in 3F position, No bigger than 1/2 in a single pass

For thickness 1/8 to 3/4(in.): 50°F). Preheat to 70(°F) if the base metal temperature is below 32(°F).
Over 3/4 thru 1-1/2(in.): 70(°F).
Over 1-1/2 thru 2-1/2(in.): 150(°F).
Over 2-1/2(in.): 225(°F).

ALL VERTICAL WELDING SHALL BE DONE UPWARD
DO NOT USE E 3/16 ELECTRODE FOR VERTICAL WELDS

IF A GAP FROM 1/16 TO 3/16 IS EVIDENT, INCREASE WELD SIZE 1/16 FOR EACH 1/16 GAP

EX 1/16 GAP IS +1/16 FROM DETAILED SIZE
1/8 GAP IS +1/8 FROM DETAILED SIZE
3/16 GAP IS +3/16 FROM DETAILED SIZE

Vermont Agency of Transportation
RECEIVED

CK'D BY _____ OK'D BY Rob Young

February 16, 2017

RESUBMIT Approved AsNoted
BY Rob Young DATE 03/06/2017

TH1 FAS RT 0211 Huntington River
Rural Major Collector
BR 8 Proj BF-0211(32) CBSS 695