

**WELDING PROCEDURE SPECIFICATION**

Material Specification PQR ELDERLEE # 3  
 A36/A500GR.B/A53/A572GR.36/50/A709GR.36/50/A108 / A307/A325/A563/A449  
 Welding Process FCAW  
 Manual or Machine SEMAUTOMATIC  
 Position of Welding FLAT/HORIZONTAL  
 Filler Metal Specification A5.29  
 Filler Metal Classification E81T1-Ni1C-JH4 LINCOLN ULTERCORE 81i1C-H  
 Flux N/A  
 Shielding Gas CO 2 Dew Point -40DEG F Flow Rate 50CFH  
 Single or Multiple Pass SINGLE (45 TO 63 CFH)  
 Single or Multiple Arc SINGLE  
 Welding Current DC  
 Polarity REVERSE ELECTRODE POSITIVE CTWD 3/4"  
 Welding Progression STRINGER  
 Root Treatment ROOT SHALL BE CLEAN AND FREE OF FOREIGN MATTER  
 Preheat and Interpass Temperature MIN PREHEAT 50 DEG ≤ 0.75" 70 DEG > 0.75" MAX INTERPASS 400 DEG  
 Postheat Temperature NONE  
 Heat Input Min 33.92 Max 50.42

**WELDING PROCEDURE**

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	310	25	11	
		320	26	12.1	
		TO	TO	TO	
		285	24	9.9	

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

Procedure No. 8000 Contractor Elderlee, Inc.  
 Revision No. 1 Authorized By RANDY SCOTT  
 Date 2/7/2017

Vermont Agency of Transportation  
**RECEIVED**  
 CK'D BY \_\_\_\_\_ OK'D BY Rob Young  
 February 15, 2017  
 RESUBMIT No Approved AsNoted  
 BY Rob Young DATE 02/22/2017