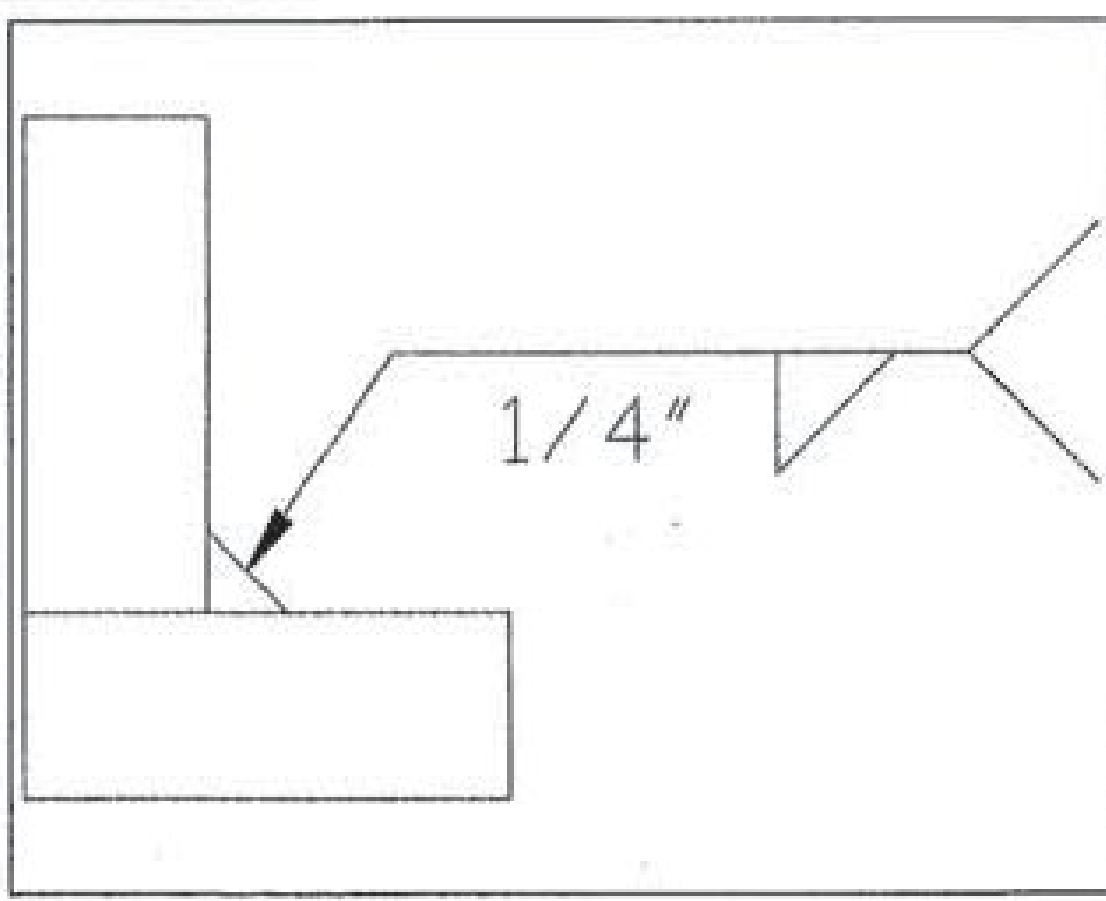


**WELDING PROCEDURE SPECIFICATION**

PQR ELDERLEE #4  
 A36/A572 GR. 36 / 50 / A709 GR. 36 / 50  
 GMAW  
 SEMAUTOMATIC ROBOTIC  
 FLAT  
 A5.18  
 L-56 ER70S-6 LINCOLN  
 N/A  
 90% ARGON / 10% CO2 Dew Point -40DEG F Flow Rate 45CFH  
 SINGLE  
 SINGLE  
 DC  
 REVERSE ELECTRODE POSITIVE CTWD 3/4"  
 STRINGER  
 ROOT SHALL BE CLEAN AND FREE OF FOREIGN MATTER  
 MIN PREHEAT 50 DEG ≤ 0.75" 70 DEG > 0.75" MAX INTERPASS 400 DEG  
 NONE  
 Min 10.56 Max 15.84

**WELDING PROCEDURE**

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	.045	190	22	19	
		171	20	18	
		TO	TO	TO	
		200	23	21	

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

Procedure No. 8001 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