

**WELDING PROCEDURE SPECIFICATION**

Material Specification	ASTM A36 / A572 / A709 GR. 36 / 50		
Welding Process	FCAW		
Manual or Machine	SEMI AUTOMATIC		
Position of Welding	FLAT		
Filler Metal Specification	A5.20		
Filler Metal Classification	E70 LINCOLN OUTERSHEILD E70T-1		
Flux	N/A		
Shielding Gas	CO 2	Dew Point	-40DEG F
Single or Multiple Pass	SINGLE	Flow Rate	50 CFM (45 TO 63 CFH)
Single or Multiple Arc	N/A		
Welding Current	DC		
Polarity	DCEP 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	42	Max 63.84

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	3/32	390	27	12	
		350	26	11	
		TO 418	TO 28	TO 13	

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

Procedure No. 8007  
Revision No. 1

Contractor Elderlee, Inc.  
Authorized By RANDY SCOTT  
Date 2/8/2017

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