

WELDING PROCEDURE SPECIFICATION

Material Specification ASTM-A500-A53-GRADE B TO A572 GRADE 50
 Welding Process FCAW
 Manual or Machine SEMAUTOMATIC
 Position of Welding FLAT VERTICAL OVERHEAD 5G
 Filler Metal Specification A5.20
 Filler Metal Classification E71T-1/T-1M ESAB DUAL SHIELD 7000
 Flux N/A
 Shielding Gas CO 2 Dew Point -40DEG F FLOW RATE 50 CFH
 Single or Multiple Pass SINGLE
 Single or Multiple Arc SINGLE
 Welding Current DC
 Polarity REVERSE ELECTRODE POSITIVE
 Welding Progression STRINGER
 Root Treatment PER D1.1
 Preheat and Interpass Temperature PER D1.1
 Postheat Temperature NONE
 Heat Input Min _____ Max _____

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	.035	110	21	6IPM	
Variable	LIMITS	121	23	7	
		TO 99	TO 19	TO 5	

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

Procedure No. 3036 Contractor Elderlee, Inc.
 Revision No. _____ Authorized By RANDY SCOTT
 Date 6/2/2016

SHOP DRAWING REVIEW	
<input checked="" type="checkbox"/> REVIEWED AS REQUIRED BY THE CONSTRUCTION CONTRACT DOCUMENTS AND APPROVED, BUT ONLY FOR CONFORMANCE TO THE DESIGN CONCEPT OF THE WORK, AND SUBJECT TO FURTHER LIMITATIONS AND REQUIREMENTS CONTAINED IN THE CONSTRUCTION CONTRACT DOCUMENTS.	
<input type="checkbox"/> REJECTED <input type="checkbox"/> REVISE AND RESUBMIT <input type="checkbox"/> APPROVED AS NOTED	
CORRECTIONS OR COMMENTS MADE ON THE SHOP DRAWINGS DURING THIS REVIEW DID NOT RELIEVE CONTRACTOR FROM COMPLIANCE WITH REQUIREMENTS OF THE DRAWINGS AND SPECIFICATIONS. THIS CHECK IS ONLY FOR REVIEW OF GENERAL CONFORMANCE WITH THE DESIGN CONCEPT OF THE PROJECT AND GENERAL COMPLIANCE WITH THE INFORMATION GIVEN IN THE CONTRACT DOCUMENTS. THE CONTRACTOR IS RESPONSIBLE FOR CONFIRMING AND CORRELATING ALL QUANTITIES AND DIMENSIONS; SELECTING FABRICATION PROCESSES AND TECHNIQUES OF CONSTRUCTION; COORDINATING THEIR WORK WITH THAT OF ALL OTHER TRADES; AND PERFORMING THEIR WORK IN A SAFE AND SATISFACTORY MANNER.	
	Job Number <u>150223</u> Reviewed by <u>SRB</u> Date <u>06/03/2016</u>

Vermont Agency of Transportation

RECEIVED

ON: June 2, 2016

and Checked for

CONFORMANCE

BY: Jennifer Fitch DATE: 06/03/16