

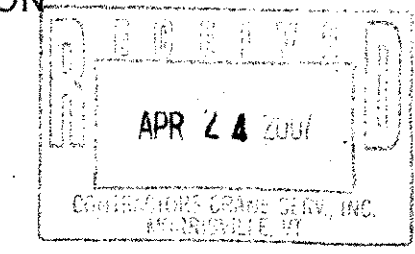
STATE OF VERMONT
GEN. OF TRANSPORTATION
R.S. NO. 248-670-2095(L)
TE. NO. 747-1, CL3 BRIDGE NO. 26
E. W. AVENUE & WYBEGIDGE
DODSON COUNTY

COSMEC INC.
CONTRACTOR: COSMEC INC.
138 Munson Avenue
Morrisville, VT 05661
Ph: 802-888-7701 f: 802-888-4746

WELDING PROCEDURE SPECIFICATION

SPECIFICATIONS AND CODE: D1.6
MATERIAL SPECIFICATION ASTM A240 TYPE 304 TO ASTM A709 GR 50W
WELDING PROCESS GTAW
MANUAL OR MACHINE MANUAL
POSITION OF WELDING 1F & 2F
FILLER METAL SPECIFICATION ER309L
MANUFACTURER: HARRIS WELCO
FLUX INTERNAL
SHIELDING GAS ARGON
SINGLE OR MULTIPLE PAS S SINGLE
SINGLE OR MULTIPLE ARC SINGLE
WELDING CURRENT DC
POLARITY: REVERSE (EN)
WELDING PROGRESSION
ROOT TREATMENT CLEANED & PREPARED BRIGHT METAL
PREHEAT AND INTERPASS TEMPERATURE SEE BELOW
POSTHEAT TEMPERATURE N/A
HEAT INPUT MIN. MAX.

CLASSIFICATION: A5.9
TRADENAME:
FLOW RATE 45 CFH



WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	TRAVEL SPEED VOLTS	JOINT DETAIL
ALL	3/32"	130-155	14-17	LAP JOINT

16 GA THRU 10 GA
BM THICKNESS

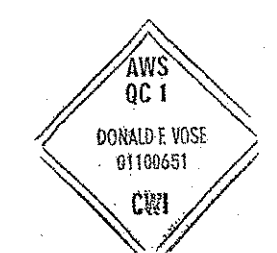
PREHEAT TEMPS. ***PREHEAT UNTIL NO MOSITURE PRESENT
THICKNESS TTEMP.
UP TO 3/4" 100 DEG.
OVER 3/4" TO 1 1/2" 100 DEG.
OVER 1 1/2" TO 2 1/2" 100 DEG.
OVER 2 1/2" 100 DEG.

THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC.
WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5.
SUPPORTING POR: GTAW-WF-05
PROCEDURE NO. GTAW-WF

REVISION NO. 1
CONTRACTOR: COSMEC INC.
AUTHORIZED BY: DONALD VOSE
CW# 01100651

DATE: 2/1/2005

TRADE RECEIVED
OK'D BY JWC
APR 25 2007
RESUBMIT APPROVED
BY DATE 5-3-07



054-BBWP