

**COSMEC INC.
WELDING PROCEDURE SPECIFICATION**

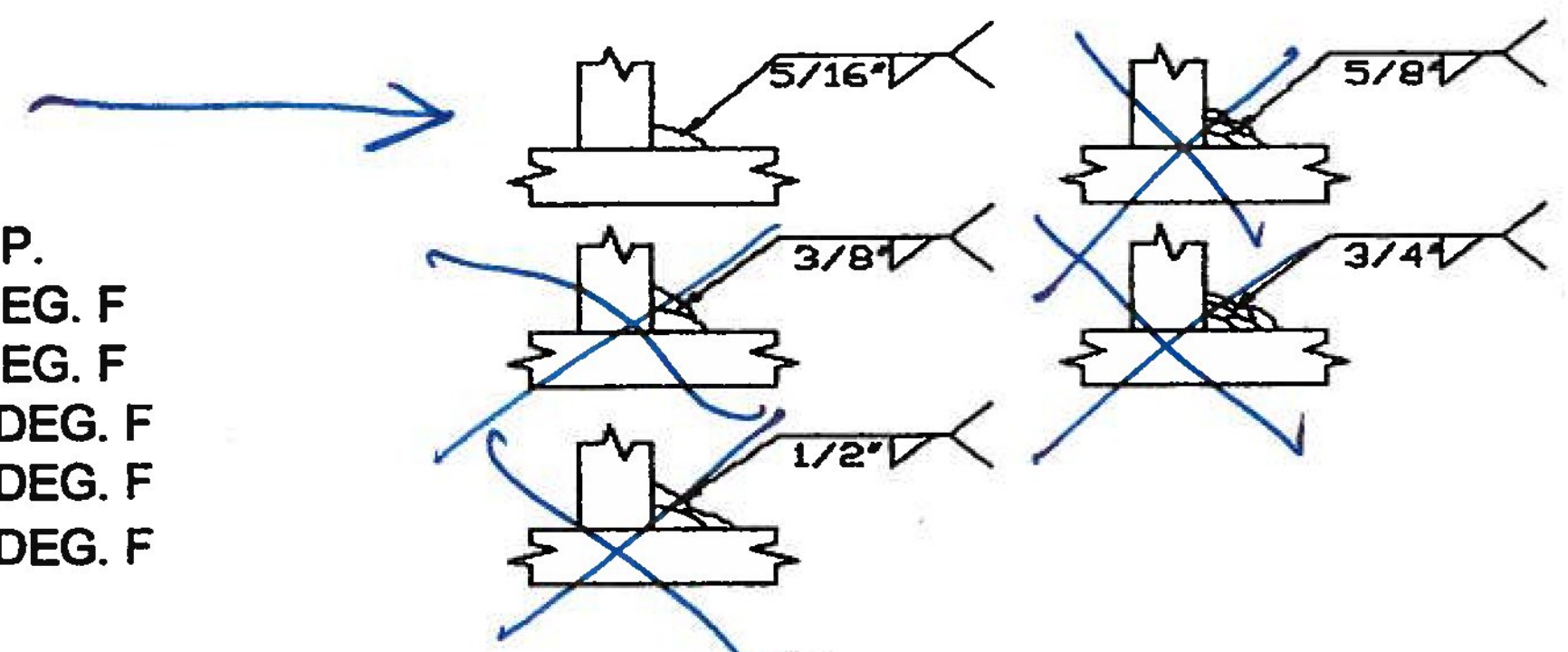
SPECIFICATIONS AND CODE: AASHTO-AWS D1.5 + ~~D1.1~~
 MATERIAL SPECIFICATION- ASTM A709 GR 50W, GR 50, GR 36
 WELDING PROCESS— FCAW-G
 MANUAL OR MACHINE— SEMI-AUTOMATIC
 POSITION OF WELDING— 1F & 2F
 FILLER METAL SPECIFICATION AWS 5.20 CLASSIFICATION: E71T
 MANUFACTURER: LINCOLN ELECTRIC TRADENAME: E71T OUTERSHIELD
 FLUX— INTERNAL FLOW RATE 45 CFH
 SHIELDING GAS— CO2
 SINGLE OR MULTIPLE PASSES MULTIPLE
 SINGLE OR MULTIPLE ARC SINGLE
 WELDING CURRENT— DC
 POLARITY: REVERSE (EP)
 WELDING PROGRESSION
 ROOT TREATMENT— CLEANED & PREPARED BRIGHT METAL
 PREHEAT AND INTERPASS TEMPERATURE— SEE BELOW
 POSTHEAT TEMPERATURE N/A
 HEAT INPUT MIN. _____ MAX. _____

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING CURRENT		TRAVEL SPEED	JOINT DETAIL
		AMPERES	VOLTS		
ALL	0.045	190-230	27-29	8-9	

PREHEAT TEMPS.

THICKNESS	TI TEMP.
UP TO 3/4"	50 DEG. F
OVER 3/4" TO 1 1/2"	70 DEG. F
OVER 1 1/2" TO 2 1/2"	150 DEG. F
OVER 2 1/2"	225 DEG. F
INTERPASS TEMP:	400 DEG. F



THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC.
 WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5.

PROCEDURE NO. FCAW-FILLET
 SUPPORTING PQR: FCAW-1.0-05
 REVISION NO.

CONTRACTOR: COSMEC INC.
 AUTHORIZED BY: DONALD VOSE

DATE: 12/28/2009

Vermont Agency of Transportation
RECEIVED

CK'D BY J.W.C. OK'D BY J.E.L.

Sept. 5, 2012

RESUBMIT APPROVED ✓
 BY J. LACROIX DATE 09-26-2012