

CR'D BY \_\_\_\_\_ DATE \_\_\_\_\_  
 CHECKED BY \_\_\_\_\_ DATE \_\_\_\_\_

NOV 02 2006

JOINT WELDING PROCEDURE SPECIFICATION  
 RESUBMIT \_\_\_\_\_ APPROVED   
 BY \_\_\_\_\_ DATE 11-14-06

MATERIAL SPECIFICATION ASTM A572 GR 50 & ASTM A36  
 WELDING PROCESS FLUX CORED ARC WELDING (FCAW)  
 MANUAL OR MACHINE MANUAL  
 POSITION OF WELDING FLAT (1F) OR HORIZONTAL (2F)  
 FILLER METAL SPECIFICATION AWS D5.20  
 FILLER METAL CLASSIFICATION LINCOLN ELECTRIC ULTACORE 71C E71T-1  
 FLUX NA  
 SHIELDING GAS CO<sub>2</sub> FLOW RATE 40 CFH  
 SINGLE OR MULTIPLE PASS BOTH  
 SINGLE OR MULTIPLE ARC SINGLE  
 WELDING CURRENT DC  
 POLARITY DCEP (DIRECT CURRENT ELECTRODE POSITIVE)  
 WELDING PROGRESSION NA  
 ROOT TREATMENT NA  
 PREHEAT AND INTERPASS TEMPERATURE AS PER TABLE 4.4 OF AWS D1.5-95  
 POSTHEAT TREATMENT NA

WELDING PROCEDURE REFERENCED TO  
 PQR OB#7 7-10-06

PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	VOLTS	TRAVEL SPEED	FILLET SIZE	JOINT DETAIL
1	.052	256-320	26-30	330-380	8	
2	.052	256-320	26-30	330-380	8	
OPTIMUM		290	29	330 mm/min		

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

PROCEDURE NO. 24 LM CONTRACTOR U.S. BRIDGE  
 REVISION NO. \_\_\_\_\_ AUTHORIZED BY David Morgan  
 DATE 10-20-06

BRIDGE No. 45  
 CAVENDISH, VERMONT