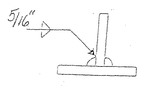
EASTERN BRIDGE, LLC
WELDING PROCEDURE SPECIFICATION

WPS NUMBER:SMAW PL#00-02	ISSUE DATE:5/15/08
PROJECT:VT AOT BRO 1443(35)	EB JOB NO.:6085
BASE METAL:A709 GR 50W	
WELDING PROCESS:SMAW	
FILLER METAL SPEC.:A5.5 , LINCOLN E8018 C3	
FLUX / SHIELDING GAS:N/A	
CURRENT AND POLARITY:DCEP	ELEC STICKOUT:N/A
WELDING POSITION:2F	
PREHEAT AND INTERPASS TEMP.:AWS D1.5 TABLE 4.4	WPS QUALIFICATION:PREQUALIFIED
HEAT INPUT:29.04 - 137.7 KILOJOULES	SUPPORTING PQR#:N/A

ELECTRODE SIZE	WELDING AMPS	CURRENT VOLTS	TRAVEL SPEED
1/8"	110-130	22-26	3-5 IPM
5/32"	130-170	22-26	3-5 IPM
3/16"	170-255	24-27	3-5 IPM

5/16" FILLET



VTRANS
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ENGINEERING SERVICES

NOTES:
Ckd by _____ Dkn by JWC
FOR WELDING
GR 50W TO GR 50W
RESUBMIT _____ APPROVED
BY _____ DATE 6-2-08

MIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS:
MAXIMUM INTERPASS TEMPERATURE SHALL BE 450F

THICKNESS OF THICKEST PART AT POINT OF WELDING	TEMPERATURE, F ASTM A709 GR 50W STEEL
UP TO 3/4"	50F
3/4" TO 1 1/2"	125F
1 1/2" TO 2 1/2"	175F
OVER 2 1/2"	225F

THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT UP, PASS SIZE, ETC. WITHIN THE LIMITS PROVIDED IN THE CONTRACT DOCUMENTS AND THE AWS D1.5 BRIDGE WELDING CODE.

09B SS