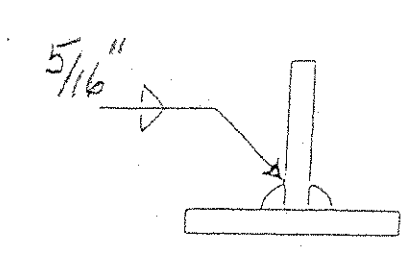


EASTERN BRIDGE, LLC
WELDING PROCEDURE SPECIFICATION

WPS NUMBER: 2005-3-2				ISSUE DATE: 5/15/06											
PROJECT: VT AOT BRO 1443(35)				EB JOB NO.: 6085											
BASE METAL: ASTM A709 GR 50W															
WELDING PROCESS: SUBMERGED ARC WELDING															
FILLER METAL SPEC: AWS A5.23 LINCOLN LA75															
FLUX / SHIELDING GAS: LINCOLN 960															
CURRENT AND POLARITY: DCEP				ELEC STICKOUT: 1" +/- 1/4"											
WELDING POSITION: 2F															
PREHEAT AND INTERPASS TEMP.: AWS D1.5 TABLE 4.4				WPS QUALIFICATION: AWS D1.5 / 5.13											
HEAT INPUT: 50.68 - 73.92 KILOJouLES				SUPPORTING PQR#: 2005-3											
ELECTRODE SIZE	WELDING AMPS	CURRENT VOLTS	TRAVEL SPEED	5/16" FILLET											
3/32"	396 - 440	28.8 - 31.5	11.25 - 13.5												
NOTES:															
FOR WELDING GR 50W TO 50W															
<div style="display: flex; justify-content: space-between;"> <div> <p>DESIGNED BY: <u> </u></p> <p>DATE: <u> </u></p> </div> <div> <p>APPROVED BY: <u> </u></p> <p>DATE: <u>6-2-06</u></p> </div> </div>															
<p>MIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS:</p> <p>MAXIMUM INTERPASS TEMPERATURE SHALL BE 450F</p> <table border="1"> <thead> <tr> <th>THICKNESS OF THICKEST PART AT POINT OF WELDING</th> <th>TEMPERATURE, F</th> </tr> </thead> <tbody> <tr> <td>UP TO 3/4"</td> <td>50F</td> </tr> <tr> <td>3/4" TO 1 1/2"</td> <td>125F</td> </tr> <tr> <td>1 1/2" TO 2 1/2"</td> <td>175F</td> </tr> <tr> <td>OVER 2 1/2"</td> <td>225F</td> </tr> </tbody> </table>						THICKNESS OF THICKEST PART AT POINT OF WELDING	TEMPERATURE, F	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
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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															

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