

WELDING PROCEDURE SPECIFICATION

MATERIAL SPECIFICATION A572 GR 50, A709 GR 50, AASHTO M270-50
 WELDING PROCESS FCAW
 MANUAL, SEMIAUTOMATIC, AUTOMATIC SEMIAUTOMATIC
 POSITION OF WELDING 1F (FLAT)
 FILLER METAL SPECIFICATIONS AWS 5.20
 FILLER METAL CLASSIFICATION E71T-1
 ELECTRODE & MANUFACTURE Ultacore 71C (Lincoln)
 FLUX & MANUFACTURE N/A
 SHIELDING GAS 100% CO2 DEW POINT -40°F FLOW RATE MIN 49.5 CFH MAX 60 CFH
 SINGLE OR MULTIPLE PASS SINGLE
 SINGLE OR MULTIPLE ARC N/A
 WELDING CURRENT DC POLARITY DCEP (REVERSE)
 WELDING PROGRESSION N/A
 ROOT TREATMENT CLEAN TO REMOVE ALL CONTAMINANTS
 PREHEAT AND INTERPASS 3/4 TO 1 1/2 = 70°F, 1 1/2 TO 2 1/2 = 150°F > 2 1/2 = 225°F
350°F MAX INTERPASS TEMP.
 POSTHEAT TREATMENT NONE

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	AMPS	VOLTS	TRAVEL SPEED IN/MIN	JOINT DETAIL
ALL	1/16"	300	27	11.6	<p>Bridge post</p>
		Max 330 Min 270	Max 29 Min 25	Max 12.7 Min 10.5	

PROCEDURE NO: DI-01 FABRICATOR DL HIGHWAY SIGN & STRUCTURE

OUR JOB NO. V04-02 Bridge Post AUTHORIZED BY [Signature]

PQR REF NO. DI-01-09a

DATE 4/23/10



JOEL W. SIMS
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 QCI EXP. 03/01/11

038 Bridge Rail