

WELDING PROCEDURE SPECIFICATION

MATERIAL SPECIFICATION A572 GR 50, A709 GR 50, AASHTO M270-50
WELDING PROCESS FCAW
MANUAL, SEMIAUTOMATIC, AUTOMATIC SEMIAUTOMATIC
POSITON OF WELDING 1F (FLAT)
FILLERMETAL SPECIFICATIONS AWS 5.20
FILLER METAL CLASSIFICATION E71T-1
ELECTRODE & MANUFACTURE Ultracore 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
PREHEATAND 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	Bridge post
		Max 330	Max 29	Max 12.7	
		Min 270	Min 25	Min 10.5	
CK'D BY _____ OK'D BY <u>JWC</u>					Illustrated in the horizontal position for clarity only welding to be completed in the flat position.
APR 23 2010					
RESUBMIT _____ APPROVED <u>✓</u>					
BY _____ DATE <u>5/4/10</u>					

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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QC1 EXP. 03/01/11

038 Bridge Rail