

WELDING PROCEDURE SPECIFICATION

Material Specification A36 TO A500 COLCHESTER STP 5600(12), Bridge 12
 Welding Process FCAW
 Manual or Machine SEMAUTOMATIC
 Position of Welding FLAT / HORIZONTAL
 Filler Metal Specification A5.20 - 95
 Filler Metal Classification E81T1-Ni1C-JH4
 Flux N/A
 Shielding Gas CO 2 Dew Point -40DEG F Flow Rate 50CFH
 Single or Multiple Pass SINGLE
 Single or Multiple Arc SINGLE
 Welding Current DC
 Polarity REVERSE ELECTRODE POSITIVE
 Welding Progression STRINGER
 Root Treatment PER D1.5
 Preheat and Interpass Temperature PER D1.5
 Postheat Temperature NONE
 Heat Input Min _____ Max _____

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	300	26	14	
Variable	LIMITS	270	24	12.6	
		TO 330	TO 28	TO 15.4	

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure No. 3006
 Revision No. _____

Contractor Elderlee, Inc.
 Authorized By RANDY SCOTT
 Date 8/4/2014

Vermont Agency of Transportation

RECEIVED

CK'D BY FDB OK'D BY HIS

August 5, 2015

RESUBMIT No Approved
 BY Carolyn Carlson DATE 05/08/05