

**WELDING PROCEDURE SPECIFICATION**

PQR ELDERLEE #3 COLCHESTER STP 5600(12), Bridge 12

Material Specification	ASTM-A500-A53-GRADE B TO A36
Welding Process	FCAW-G
Manual or Machine	SEMAUTOMATIC
Position of Welding	1G
Filler Metal Specification	A5.29
Filler Metal Classification	E81T1-Ni1C-JH4
Flux	N/A
Shielding Gas	CO 2 Dew Point -40DEG F FLOW RATE 50 CFH
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	310	25	11	
Variable	LIMITS	341	27	12	
		TO 269	TO 23	TO 10	

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

Procedure No. 3012 Contractor Elderlee, Inc.  
 Revision No. \_\_\_\_\_ Authorized By RANDY SCOTT  
 Date 3/20/2014

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