

STATE OF VERMONT
 DEPT. OF TRANSPORTATION
 WIND BRADFORD ORANGE COUNTY
 OBJECT NO. STP 144728 ITEM 531.10
 EDGE NO. 13
 STIN CONSTRUCTION, INC.

COSMEC INC.

WELDING PROCEDURE SPECIFICATION

SPECIFICATIONS AND CODE: D1.5
 MATERIAL SPECIFICATION: ASTM A240 TYPE 304 TO ASTM A709 GR 50W
 WELDING PROCESS: GTAW
 MANUAL OR MACHINE: MANUAL
 POSITION OF WELDING: 1F & 2F
 FILLER METAL SPECIFICATION: ER308L
 MANUFACTURER: HARRIS WELCO
 FLUX: INTERNAL
 SHIELDING GAS: ARCON
 SINGLE OR MULTIPLE PASSES: SINGLE
 SINGLE OR MULTIPLE ARC: SINGLE
 WELDING CURRENT: DC
 POLARITY: REVERSE (EN)
 WELDING PROGRESSION: CLEANED & PREPARED BRIGHT METAL
 ROOT TREATMENT: SEE BELOW
 PREHEAT AND INTERPASS TEMPERATURE: SEE BELOW
 POSTHEAT TEMPERATURE: N/A
 HEAT INPUT: MIN. MAX.

CLASSIFICATION: A5.9
 TRADENAME:
 FLOW RATE: 45 CFH
 RESUBMIT: APPROVED
 BY: DATE: 3-22-07

RECEIVED
 MAR 12 2007

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	VOLTS	TRAVEL SPEED	JOINT DETAIL
ALL	3/32"	130-155	14-17	8.75-0.5	LAP JOINT

PREHEAT TEMPS.
 THICKNESS
 UP TO 3/4" 100 DEG.
 OVER 3/4" TO 1 1/2" 100 DEG.
 OVER 1 1/2" TO 2 1/2" 100 DEG.
 OVER 2 1/2" 100 DEG.

THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC. WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5.

SUPPORTING FOR: GTAW-WF-06
 PROCEDURE NO. GTAW-WF
 REVISION NO. 1
 CONTRACTOR: COSMEC INC.
 AUTHORIZED BY: DONALD VOSE
 CW#01100851

DATE: 2/12/2005



BRG 1