

WELDING PROCEDURE SPECIFICATION

STOCK PQR # ELDERLEE #1

Material Specification	ASTM A588	
Welding Process	FCAW	
Manual or Machine	SEMAUTOMATIC	
Position of Welding	FLAT	
Filler Metal Specification	A5.20	
Filler Metal Classification	E70 LINCOLN OUTERSHEILD	
Flux	N/A	
Shielding Gas	CO 2	Dew Point -40DEG F Flow Rate 50 CFM
Single or Multiple Pass	SINGLE	(45 TO 63 CFM)
Single or Multiple Arc	N/A	
Welding Current	DC	
Polarity	DCEP	
Welding Progression	STRINGER	
Root Treatment	CLEAN PER D1.5	
Preheat and Interpass Temperature	PER D1.5	
Postheat Temperature	NONE	
Heat Input	Min _____	Max _____

Seal All Welded Connections Prior To Galvanizing Where Possible

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Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	3/32	390	27	12	
Variable	LIMITS	351	25	11	
		TO 429	TO 29	TO 13	

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

Procedure No. 3035 Contractor Elderlee, Inc.
 Revision No. _____ Authorized By RANDY SCOTT
 Date 2/14/2014

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CK'D BY JC OK'D BY HIS

May 21, 2014

RESUBMIT No **Approved AsNoted**
 BY Carolyn Carlson **DATE** 6/19/2014