

**WELDING PROCEDURE SPECIFICATION**

Material Specification	ASTM A500 GRD. B A36	
Welding Process	FCAW	
Manual or Machine	SEMIAUTOMATIC	
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	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	3/32	390	27	12	
Variable	LIMITS	351	25	11	
		TO 429	TO 29	TO 13	

**Vermont Agency of Transportation**

**RECEIVED**

CK'D BY David Peterson OK'D BY JWC

**May 22, 2012**

RESUBMIT \_\_\_\_\_ APPROVED

BY C. CARLSON DATE 6/1/12

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

Procedure No. 3011  
 Revision No. \_\_\_\_\_

Contractor Elderlee, Inc.  
 Authorized By RANDY SCOTT  
 Date 5/7/2012