

WELDING PROCEDURE SPECIFICATION
 OR
 PROCEDURE QUALIFICATION RECORD

Specification No.: 55928
 Customer: Reed & Reed Inc. Customer P.O.#: P.O. #2398
 Base Metals: M270 Gr.50 P-NO.: 1 Group NO.: 1 to P-NO.: 1 Group NO.: 1
 Material Specification Type & Grade: AASHTO M270 Gr.50
 Welding Process: F.C.A.W.
 Manual or Machine: Manual
 Position of Welding: Flat 1-G
 Filler Metal Specification: A 5.29
 Filler Metal Classification: E-80T1-W, Esab Dual Shield 8100-W
 Shielding Gas: CO² Rate: 25 CFH
 Single or Multiple Pass: Single
 Single or Multiple Arc: Single
 Welding Current: Direct
 Polarity: Reverse
 Root Treatment: Remove all scale, grease, etc. from weld preparation face
 Preheat and Interpass Temp: 200 Deg F. to 250 Deg F.
 Post weld Heat Treatment: N/A

Pass No.	Electrode Size	Welding Current		Weld Size	Joint Detail
		Amperes	Volts		
1	.06	300-310	30-31	5/16	

Vermont Agency of Transportation

RECEIVED

CK'D BY David Peterson OK'D BY JWC

9:02 am, Feb 23, 2012

RESUBMIT _____ APPROVED
 BY _____ DATE 3/9/12

Manufacturer: Amscot Structural Products Authorized By: _____

Date: _____