

Filler Metal Classification E71T-1H8 E71T-9H8 LINCOLN ULTRACORE
 Flux N/A
 Shielding Gas CO 2 Dew Point -40DEG F Flow Rate 50CFH
 Single or Multiple Pass SINGLE
 Single or Multiple Arc SINGLE
 Welding Current DC
 Polarity REVERSE ELECTRODE POSITIVE
 Welding Progression STRINGER
 Root Treatment CLEAN AS PER SECTION 603 OF THE NYSSCM
 Preheat and Interpass Temperature PREHEAT AS PER TABLE 708 OF THE NYSSCM
 Postheat Temperature NONE
 Heat Input Min _____ Max _____

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	300	26	14	
Variable	LIMITS	270	24	12.6	
		TO 330	TO 28	TO 15.4	

NYSDOT
 METALS ENGINEERING
 REVIEW
 X APPROVED
 APPROVED AS NOTED
 DISAPPROVED
 R. Rinkenella
 1/12/09

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

Procedure No. 1025
 Revision No. _____

Contractor Elderlee, Inc.
 Authorized By RANDY SCOTT
 Date 12/4/2008

RECEIVED
 VTRANS

CK'D BY _____ OK'D BY JWC

Form III-2

Form III-2-Sample Welding Procedure Specification

OCT 05 2009

REQUESTED _____ APPROVED
 BY _____ DATE _____