

VERMONT
AGENCY OF TRANSPORTATION
HUNTINGTON
PROJECT BRO 1445 (29)

COSMEC INC.
WELDING PROCEDURE SPECIFICATION

SPECIFICATIONS AND CODE: AASHTO-AWS D1.5
MATERIAL SPECIFICATION ASTM A709 GR 50W, GR 50, GR 35
WELDING PROCESS-----FCAW-G
MANUAL OR MACHINE-----SEMI-AUTOMATIC
POSITION OF WELDING-----1F & 2F
FILLER METAL SPECIFICATION AWS 5.20 CLASSIFICATION: E71T
MANUFACTURER: LINCOLN ELECTRIC TRADENAME: E71T OUTERSHIELD
FLUX-----INTERNAL
SHIELDING GAS-----CO2 FLOW RATE 45 CFH
SINGLE OR MULTIPLE PAS S MULTIPLE
SINGLE OR MULTIPLE ARC SINGLE
WELDING CURRENT-----DC
POLARITY: REVERSE (EP)
WELDING PROGRESSION-----
ROOT TREATMENT-----CLEANED & PREPARED BRIGHT METAL
PREHEAT AND INTERPASS TEMPERATURE-----SEE BELOW
POSTHEAT TEMPERATURE N/A
HEAT INPUT MIN.----- MAX.-----

WELDING PROCEDURE

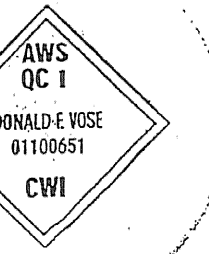
PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	TRAVEL SPEED	JOINT DETAIL
ALL	0.045	190-230	27-29	8-9

PREHEAT TEMPS.
THICKNESS T TEMP.
UP TO 3/4" 50 DEG. F
OVER 3/4" TO 1 1/2" 70 DEG. F
OVER 1 1/2" TO 2 1/2" 150 DEG. F
OVER 2 1/2" 225 DEG. F
INTERPASS TEMP: 400 DEG. F

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

PROCEDURE NO. FCAW-FILLET
SUPPORTING PQR: FCAW-1.0-05
REVISION NO.
CONTRACTOR: COSMEC INC.
AUTHORIZED BY: DONALD VOSE

VTRANS
RECEIVED
DATE: 12-18-06
BY: JWC



DATE: 1/31/2005