

VERMONT  
AGENCY OF TRANSPORTATION  
MONTPELIER  
PROJECT BRO 1445(29)

COSMEC INC.  
WELDING PROCEDURE SPECIFICATION

SPECIFICATIONS AND CODE: D1.5  
MATERIAL SPECIFICATION: ASTM A240 TYPE 304 TO ASTM A709 GR 50W  
WELDING PROCESS: GTAW  
MANUAL OR MACHINE: MANUAL  
POSITION OF WELDING: 1F & 2F  
FILLER METAL SPECIFICATION: ER309L CLASSIFICATION: A5.9  
MANUFACTURER: HARRIS WELCO TRADENAME:  
FLUX: INTERNAL FLOW RATE: 45 CFH  
SHIELDING GAS: ARGON  
SINGLE OR MULTIPLE PASSES: SINGLE  
SINGLE OR MULTIPLE ARC: SINGLE  
WELDING CURRENT: DC  
POLARITY: REVERSE (EN)  
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 VOLTS	JOINT DETAIL
ALL	3/32"	130-155	14-17	LAP JOINT

16 GA THRU 10 GA  
BM THICKNESS

**PREHEAT TEMPS.** \*\*\*PREHEAT UNTIL NO MOISTURE PRESENT  
THICKNESS T TEMP.  
UP TO 3/4" 100 DEG.  
OVER 3/4" TO 1 1/2" 100 DEG.  
OVER 1 1/2" TO 2 1/2" 100 DEG.  
OVER 2 1/2" 100 DEG.

THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC.  
WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5.  
SUPPORTING PQR: GTAW-WF-05  
PROCEDURE NO. GTAW-WF  
REVISION NO. 1

CONTRACTOR: COSMEC INC.  
AUTHORIZED BY: DONALD VOSE  
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DATE: 2/1/2005

*VTRAOS*  
RECEIVED  
DATE: 12-18-06

