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Vermont Agency of Transportation
RECEIVED
Colchester Bearings Field Welding Procedure.pdf
CK'D BY JWC OK'D BY JWC
August 11, 2015
RESUBMIT No Approved
BY DATE 8/13/2015

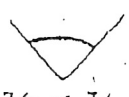
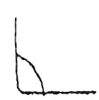
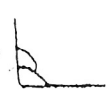
WELDING PROCEDURE SPECIFICATION

Material specification ASTM 709-Gr 36-50-50W (250-345-345W)
Welding process Shielded Metal Arc welding (SMAW)
Manual or machine Manual
Position of welding Flat (1F), Horizontal (2F)
Filler metal specification AWSI/AWS A5.1 - A5.5
Filler metal classification E7018 - 8018 C1/C3 - 7028
Flux NA
Shielding gas NA Flow rate NA
Single or multiple pass Single and multiple
Single or multiple arc Single
Welding current AC / DC
Polarity Straight / Reverse
Welding progression
Root treatment Meet AWS specification
Preheat and interpass temperature To 3/4 (19) 50F (10C) 3/4 (19) To 1 1/2 (38) 70F (20C) 1 1/2 (38) To 2 1/2 (63.5) 150F (65C) over 2 1/2 (63.5) 225F (110C)
Postheat temperature NA
Heat Input Min NA Max NA

Colchester STP 5600 (12)

WELDING PROCEDURE

(Metric)

Pass no.	Electrode size	Welding current Amperes	Welding current Volts	Travel speed	AWS D1.5 Joint detail Fillet
	7018				1F
	1/8 (3.2)	70-170	22-26		
AS	5/32 (3.9)	120-225	22-26	AS	
REQ.	3/16 (4.8)	170-300	24-27	REQ	3/16 To 3/8 (5 To 10) 3/8 To 1/2 (10 To 13) 1/2 To 5/8 (13 To 16)
	8018				2F
	1/8 (3.2)	90-160	22-26		
	5/32 (3.9)	120-225	22-26		
	3/16 (4.8)	180-290	24-27		 
	7028				
	5/32 (3.9)	170-270	22-26		3/16 To 5/16 (5 To 8) 3/8 (10) 7/16 To 5/8 (11 To 16)
	3/16 (4.8)	210-330	24-27		

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in applicable A.W.S. codes or contract specifications

Procedure no. 401
Revision no.
Form III-2

Contractor A.L. St. Onge Contractor, Inc
Authorized By Randy St. Onge
Date 8/10/15