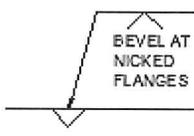


Welding Procedure Specification

Base Material specification A709 Grade 50 or 36 Base metal thickness 1" min.
 Welding process SMAW
 Manual, semi-automatic, or automatic Manual
 Joint type Bevel Backing material None Backgouging method N/A
 Position of welding Flat
 Filler metal specification AWS A 5.1
 Filler metal classification 7018 H4R
 Electrode and manufacturer Murex (Lincoln Electric) 7018 MR
 Flux and manufacturer N/A
 Shielding gas N/A Dew point N/A Flow rate N/A
 Single or multiple pass Multiple Single or multiple arc Single
 Welding current DC Polarity Reverse
 Welding progression Forward
 Root treatment Free of rust, dirt, oil and moisture
 Heat treatment None
 Pre-heat and inter-pass temperature 70°F preheat; 70 – 450°F interpass
 Post-heat treatment None

Pass no.	Electrode size	Welding Current		Travel speed (IPM)	Weld Size	Joint Detail
		Amperes	Volts			
All	5/32"	125-145	22-27	4"-8"	Varies	<div style="text-align: right; color: green; font-weight: bold;"> Vermont Agency of Transportation RECEIVED <small>WELDED BY BECK AND BELLUCCI, INC.</small> </div> <div style="display: flex; justify-content: space-between; margin-top: 5px;"> CK'D BY <u>J Clark</u> OK'D BY <u>D Bonneau</u> </div> <div style="text-align: right; margin-top: 5px; color: blue;"> May 1, 2015 </div> <div style="display: flex; justify-content: space-between; margin-top: 5px;"> RESUBMIT <u>No</u> Approved AsNoted </div> <div style="display: flex; justify-content: space-between; margin-top: 5px;"> BY <u>D Bonneau</u> DATE <u>05/04/15</u> </div> <div style="margin-top: 10px;">  <p style="margin-left: 20px;">Bevel to depth of damage, 3/8" max.</p> <p style="margin-left: 20px;">Grind welds flush with girder, with grinding marks longitudinal along beam.</p> </div>

Procedure no. BB-FLANGE-01 Contractor Beck and Bellucci, Inc.
 Revision no. 00 Authorized by *[Signature]*
 Date 5-1-2015