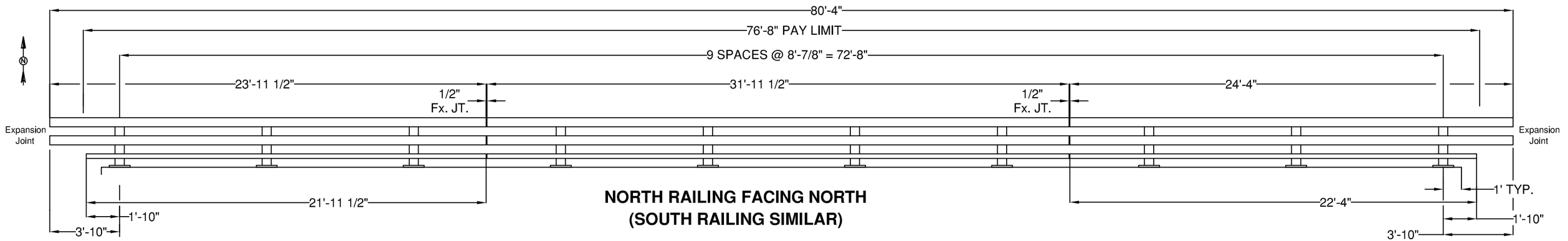
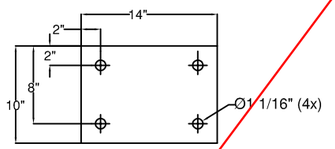


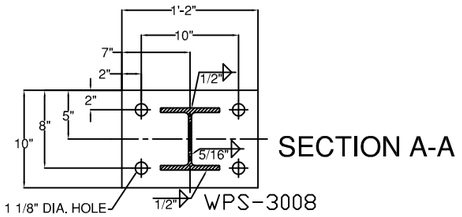
NORTH RAILING FACING NORTH
(SOUTH RAILING SIMILAR)

BILL OF MATERIAL		
QTY	DESCRIPTION	ASTM DESIGNATION
20	W6x25, THREE RAIL POST @ 2'-9" DA ON 1 1/4x10x1'-2" B.P.	A572 Gr. 50
2	HSS 3" X 5" X 1/4" RAIL @ 21'-11 1/2"	A500 Gr. B
2	HSS 3" X 5" X 1/4" RAIL @ 31'-11 1/2"	A500 Gr. B
2	HSS 3" X 5" X 1/4" RAIL @ 22'-4"	A500 Gr. B
4	HSS 6" X 6" X 3/16" RAIL @ 23'-11 1/2"	A500 Gr. B
4	HSS 6" X 6" X 3/16" RAIL @ 31'-11 1/2"	A500 Gr. B
4	HSS 6" X 6" X 3/16" RAIL @ 24'-4"	A500 Gr. B
4	2-1/8" X 4-1/4" FIX. SPLICE BAR @ 2'-3"	A572 Gr. 50
8	HSS 5" X 5" X 5/16" FIX. SPLICE TUBE @ 2'-3"	A500 Gr. B, A572 Gr. 50
20	3/8" X 10" X 14" ANCHOR PLATES (END POST)	A572 Gr. 50
20	1/8" X 10" X 14" FABRIC PAD	AASHTO M251
80	Ø 1" X 13" ANCHOR STUDS, W/ 2 1/4" THD. EACH END	A449 Gr. 1, CLASS 8.8
160	Ø 1" HEAVY HEX NUTS & FLAT WASHERS	A563 & F436
80	Ø 1" HEX JAM NUTS	A563
80	Ø 7/8" X 8" ROUND HEAD BOLT, NUT, SQ. WASHER, L.W.	A449, A563, F436, ASME B18.21.1
20	Ø 3/4" X 8" HEX BOLT, NUT, (2) F.W., & L.W.	A325, A563, F436, & ASME B18.21.1
40	Ø 3/4" X 2-3/4" HEX BOLT, NUT, (2) F.W., & L.W.	A325, A563, F436, & ASME B18.21.1
32	Ø 3/4" X 7-1/2" HEX BOLT, NUT, & (2) F.W.	A325, A563, & F436
16	Ø 3/4" X 4-1/2" HEX BOLT, NUT, & (2) F.W.	A325, A563, & F436
20	Ø 5/8" X 1-1/2" HEX BOLT, NUT, & (2) F.W.	A325, A563, & F436
20	L5" X 5" X 5/8" RAILING ANGLE @ 6'	A572 Gr. 50
TBD	DELINEATORS	(SUPPLIED BY F.R. LAFAYETTE)

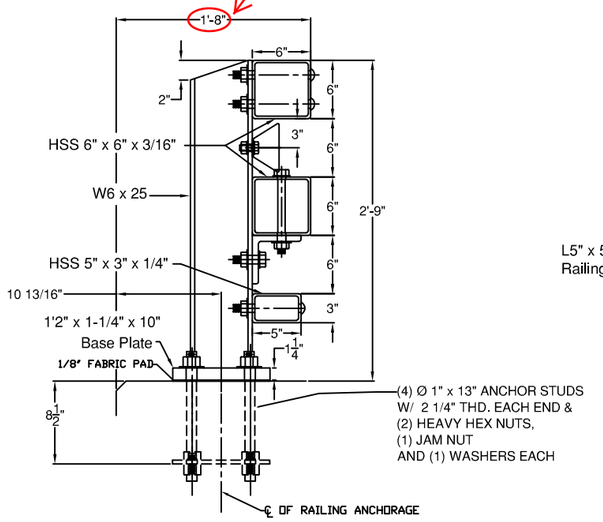
Vermont Agency of Transportation
RECEIVED
Hancock Bridg Rail Revised 3-12-2013.pdf
CK'D BY GML/WDL OK'D BY JTS
March 8, 2013
RESUBMIT Approved AsNoted
BY KMH DATE 03/12/13



1/8" FABRIC PAD



SECTION A-A



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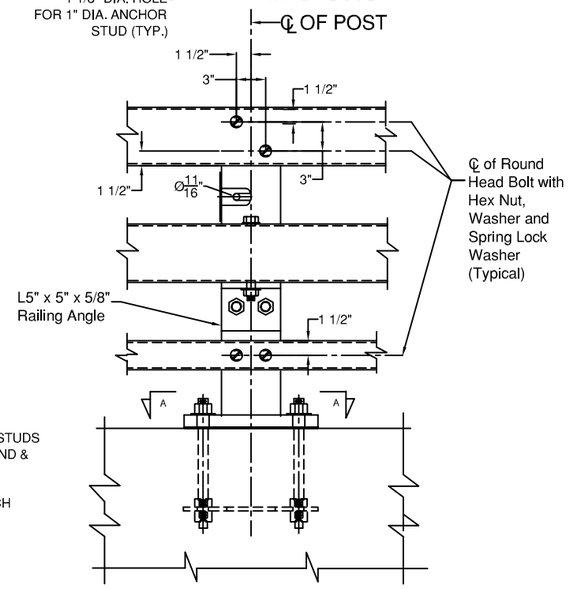


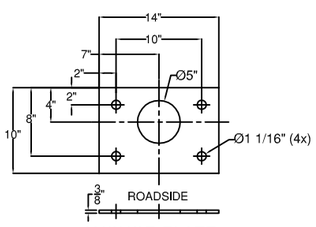
ELEVATION

STEEL BRIDGE RAILING

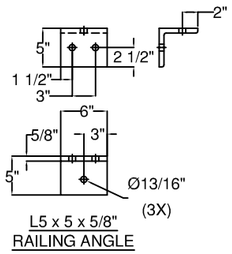
GENERAL NOTES:

1) ALL RAILING IS TO BE FABRICATED AND ERECTED ACCORDING TO SECTION 525 OF THE STANDARD SPECIFICATIONS.
2) PRIOR TO GALVANIZING THE ASSEMBLED POST, GRIND ALL EDGES TO A MINIMUM RADIUS OF 1/16".
3) BOLTS SHALL BE TORQUED SNUG TIGHT (APPROXIMATELY 100 FT-LB).
4) RAIL TUBE EXPANSION JOINTS SHALL BE PROVIDED IN ANY RAIL BAY SPANNING THE END OF AN INTEGRAL ABUTMENT BRIDGE AND AT ALL SUPER STRUCTURE EXPANSION JOINTS. EXPANSION JOINT WIDTH SHALL BE 4"@ 68°F AND WILL BE ADJUSTED IN THE FIELD BY THE ENGINEER FOR OTHER TEMPERATURES.
5) RETROREFLECTIVE MATERIAL SHALL MEET THE REQUIREMENTS OF SUBSECTION 750.08 AND SHALL BE A .063" ALUMINUM BACKING WHITE OR YELLOW REFLECTOR. WHITE IS TO BE INSTALLED ON THE DRIVERS RIGHT, FOR ONE WAY BRIDGES . YELLOW IS TO BE INSTALLED ON THE DRIVERS LEFT.
6) PROTRUSIONS CAUSED BY WELDING OR GALVANIZING ARE NOT PERMITTED ON THE ADJOINING SURFACES OF THE BOX BEAM RAILS, SPLICE TUBES AND FILL PLATES.
7) THE MINIMUM DISTANCE FROM THE POST TO AN EXPANSION JOINT SHALL BE DETERMINED BY THE MINIMUM EDGE DISTANCE OF 5" FROM ANY ANCHOR STUD TO THE END OF THE SLAB, OR THE EXPANSION JOINT RECESS POUR, IF ONE IS USED.
8) ALL POST SHALL BE SET NORMAL TO GRADE. THE MAXIMUM CENTER TO CENTER SPACING OF BRIDGE RAIL POST IS 8'-3".
9) ANY BENDING OF RAIL SHALL BE DONE AT THE FABRICATION PLANT ACCORDING TO A PROCEDURE PROVIDED BY THE FABRICATOR.
10) STD. SPLICE HOLES ONLY IN BRIDGE RAIL TUBES. REST TO BE DRILLED BY CUSTOMER. FIELD DRILLED HOLES TO BE COATED WITH AN APPROVED ZINC-RICH PAINT PRIOR TO INSTALLATION.
11) THIS RAILING MEETS THE REQUIREMENTS FOR A TL-4 SERVICE LEVEL.

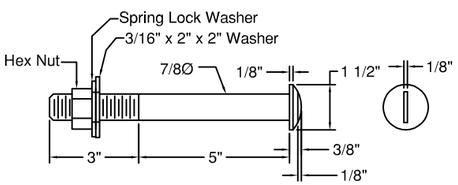
RAIL BENDING PROCEDURE:
RADII GREATER THAN 16' TO BE CURVED ON A TUBE BENDING MACHINE, RADII LESS THAN 16' TO BE 'PIE CUT' AND WELDED.



ANCHOR PLATE



L5 x 5 x 5/8" RAILING ANGLE



ROUND HEAD BOLT

ITEM #: 525.335

F.R. LAFAYETTE, HANCOCK

SHEET 1 OF 2

APPROVED BY:

BRIDGE RAIL DETAILS SHEET

HANCOCK, ER BRF 0174 (16), ROUTE VT 125, BRIDGE #23
TOWN OF HANCOCK, ADDISON COUNTY, VT

R E V	NO.	DATE	DESCRIPTION	BY
				E.P.

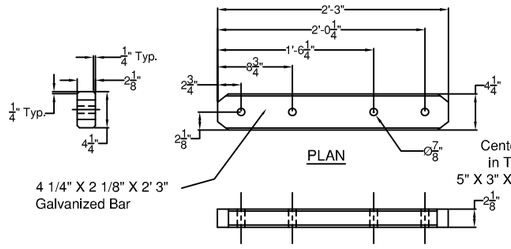
R E V	NO.	DATE	DESCRIPTION	BY

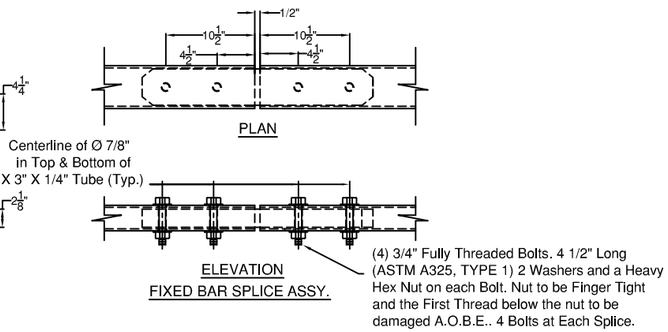
ELDERLEE, INC.
OAKS CORNERS, NEW YORK 14518
E-Mail: dlong@elderlee.com
Tel: 315-789-6670 Fax: 315-789-6615

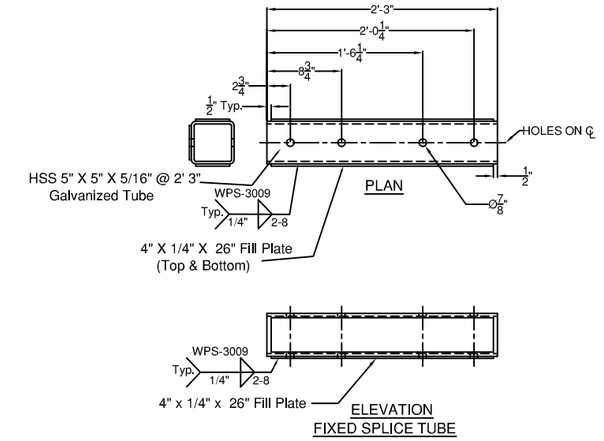
AISC CERTIFIED FABRICATOR

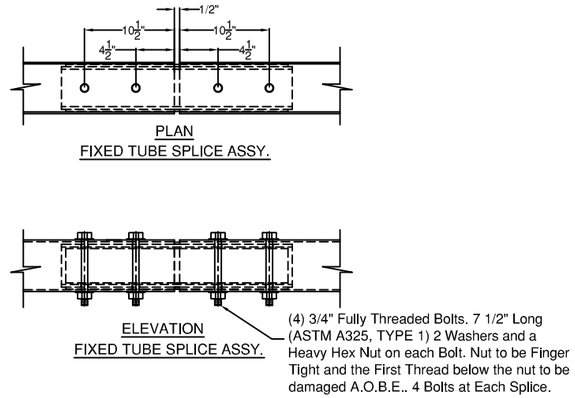
DRAWN	E.P.	2/19/13
CHECKED	D.L.	2/19/13
APPROVED	.	.
SCALE	SCHEMATIC	
DRAWING NO.	F.R. LAFAYETTE, HANCOCK	

SPLICE BAR - FIXED



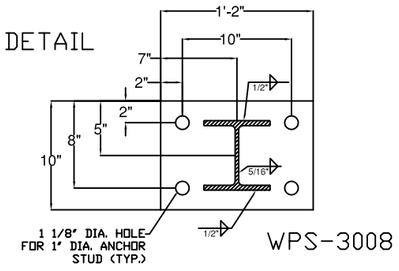




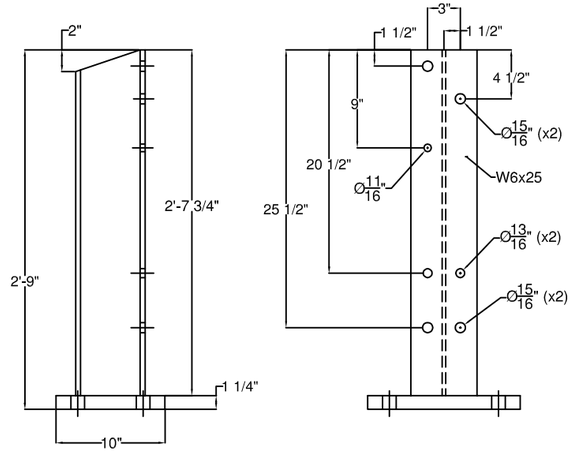


SPLICE TUBE - FIXED

BRIDGE POST DETAIL



WPS-3008



ITEM #: 525.335

F.R. LAFAYETTE, HANCOCK

SHEET 2 OF 2

APPROVED BY:

Vermont Agency of Transportation

RECEIVED

CK'D BY GML/WDL OK'D BY JTS

March 8, 2013

RESUBMIT Approved

BY KMH DATE 03/12/13

BRIDGE RAIL DETAILS SHEET

HANCOCK, ER BRF 0174 (16), ROUTE VT 125, BRIDGE #23

TOWN OF HANCOCK, ADDISON COUNTY, VT

REV	NO.	DATE	DESCRIPTION	BY

REV	NO.	DATE	DESCRIPTION	BY

ELDERLEE, INC.
OAKS CORNERS, NEW YORK 14518
E-Mail: dlong@elderlee.com
Tel: 315-789-6670 Fax: 315-789-6615

AISC CERTIFIED FABRICATOR

DRAWN	E.P.	2/19/13
CHECKED	D.L.	2/19/13
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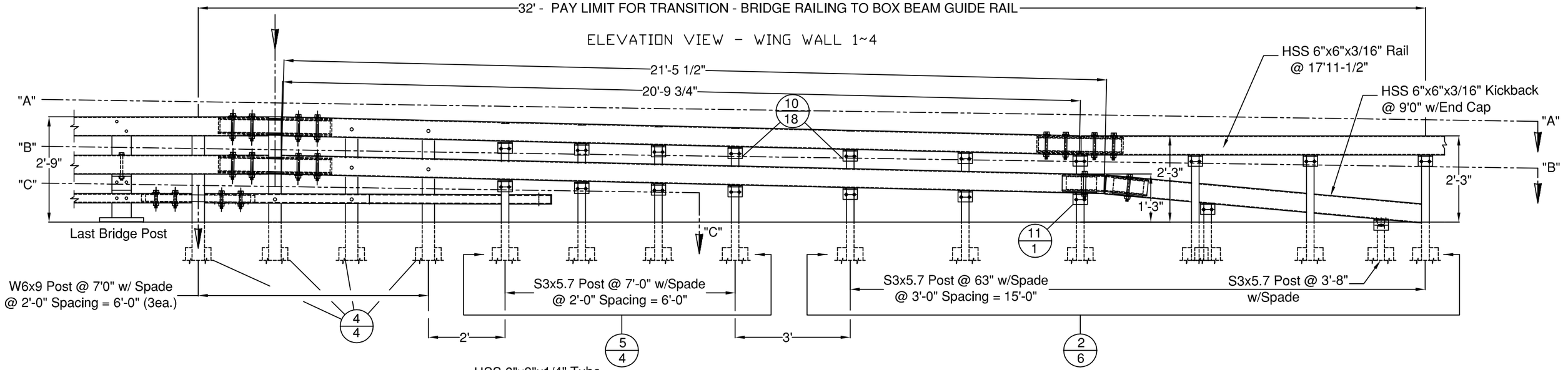
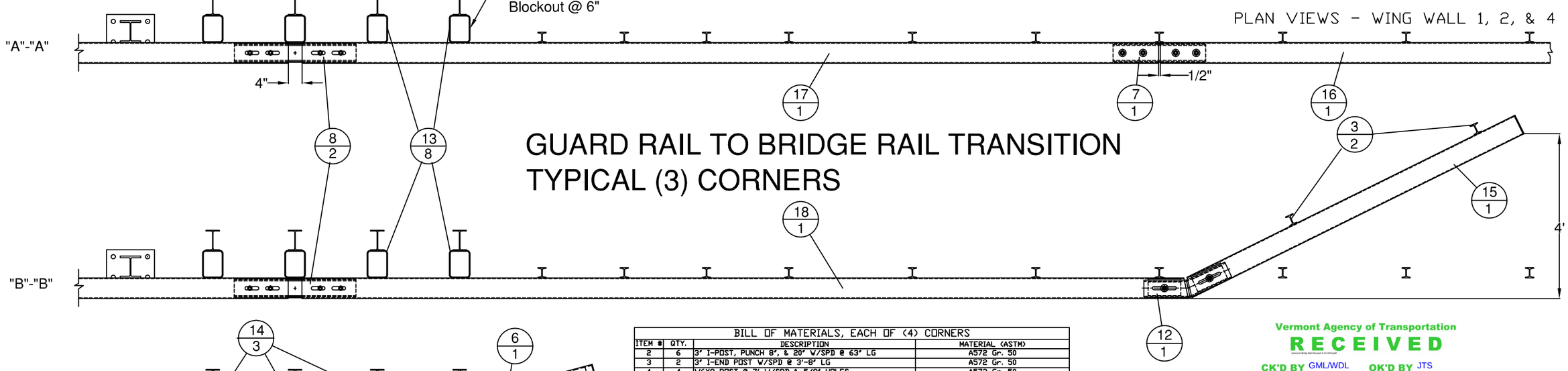
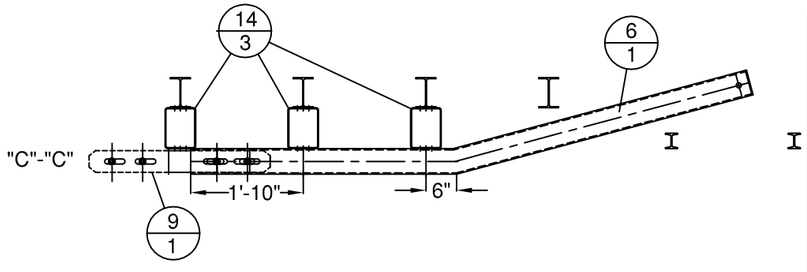
SCALE	SCHEMATIC	
DRAWING NO.	F.R. LAFAYETTE, HANCOCK	





GUARD RAIL TO BRIDGE RAIL TRANSITION
TYPICAL (3) CORNERS



HARDWARE NOTES	
ITEM #	FUNCTION
19	BOLT RAIL TO SHELF ANGLE (ITEM #10)
20	BOLT SHELF ANGLE (ITEM #'S 10 & 11) TO POST
21	BOLT BLOCK-OUTS (ITEM #'S 13 & 14) TO HEAVY POST
22	(4) PER SPLICE BAR (ITEM #9)
23	(4) PER SPLICE TUBING (ITEM #'S 7 & 8)
24	BOLT RAIL (ITEMS #'S 6,17, & 18 TO BLOCK-OUTS (ITEM #'S 13 & 14) [WHERE FASTENED]
25	BOLT DOUBLE BEND SPLICE TUBE (ITEM #12) TO RAIL (ITEM #18) & KICKBACK (ITEM #15) & ITEM #11)

BILL OF MATERIALS, EACH OF (4) CORNERS			
ITEM #	QTY.	DESCRIPTION	MATERIAL (ASTM)
2	6	3" I-POST, PUNCH 8", & 20" W/SPD @ 63" LG	A572 Gr. 50
3	2	3" I-END POST W/SPD @ 3'-8" LG	A572 Gr. 50
4	4	W6X9 POST @ 7' W/SPD & 5/8" HOLES	A572 Gr. 50
5	4	3" I-POST, PUNCH 8" & 20", W/8X32" SPADE @7'	A572 Gr. 50
6	1	HSS 3X5" BTM TRANS RAIL W/5'-0" KB, EXP END	A500 Gr. B
7	1	HSS 5X5 TUBE SPLICE @27" LG W/ 1/4" SHIMS	A500 Gr. B / A572 Gr 50
8	2	HSS 5x5 EXP TUBE SPLICE @ 36" LG W/ 1/4" SHIMS	A500 Gr. B / A572 Gr 50
9	1	BR EXP BAR SPLICE 2-1/8" X 4-1/4" @ 36" LG	A572 Gr. 50
10	18	REG BB SHELF ANGLES @ 4-1/2"	A572 Gr. 50
11	1	DWY BB SHELF ANGLES @ 4-1/2"	A572 Gr. 50
12	1	HSS 5X5 DBL BEND TUBE SPL @ 28" LG	A500 Gr. B / A572 Gr 50
13	8	HSS 6X8" TRANS. TUBE B/O @ 6" LG	A500 Gr. B
14	3	HSS 6X8" TRANS. TUBE B/O @ 3" LG	A500 Gr. B
15	1	HSS 6X6" BB @ 9'-0" KICKBACK, W/ CAP	A500 Gr. B / A36
16	0.5	HSS 6X6" BB @ 17'-11 1/2", DRILL 3" CC	A500 Gr. B
17	1	HSS 6X6" BB TOP TRANS @ 20'-9 3/4" LG W/EXP END	A500 Gr. B
18	1	HSS 6X6" BB BTM TRANS @ 21'-5 1/2" LG W/EXP END	A500 Gr. B
19	18	3/8" X 7 1/2" BOLT, NUT, & 2 FW	A307, A563, F436
20	19	1/2" x 1-1/2" BOLT, NUT, & FW	A307, A563, F436
21	22	1/2" x 1-1/2" BOLT, NUT, 2 FW & LW	A307, A563, F436
22	4	3/4" X 4-1/2" BOLT, NUT, 2 FW	A325, A563, F436
23	12	3/4" X 7-1/2" BOLT, NUT, 2 FW	A325, A563, F436
24	6	7/8" X 8" CARR BOLT, NUT, FW & LW	A307, A563, F436
25	2	3/4" X 8" BOLT, NUT, 2 FW, & LW	A325, A563, F436

NOTE: ITEMS 16 & 17 TO HAVE *25" RADIUS FOR WINGWALL #3
* - RADIUS TO BE FIELD VERIFIED PRIOR TO FABRICATION.

Vermont Agency of Transportation
RECEIVED
CK'D BY GML/WDL OK'D BY JTS
March 8, 2013
RESUBMIT Approved
BY KMH DATE 03/12/13

ITEM #: 621.725 F.R. LAFAYETTE, HANCOCK SHEET 1 OF 5

APPROVED BY:

GUARD RAIL TO BRIDGE RAIL TRANSITION DETAILS SHEET
HANCOCK, ER BRF 0174 (16), ROUTE VT 125, BRIDGE #23, ITEM# 621.725
TOWN OF HANCOCK, ADDISON COUNTY, VT

REV	NO.	DATE	DESCRIPTION	BY

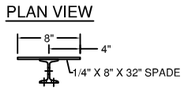
REV	NO.	DATE	DESCRIPTION	BY

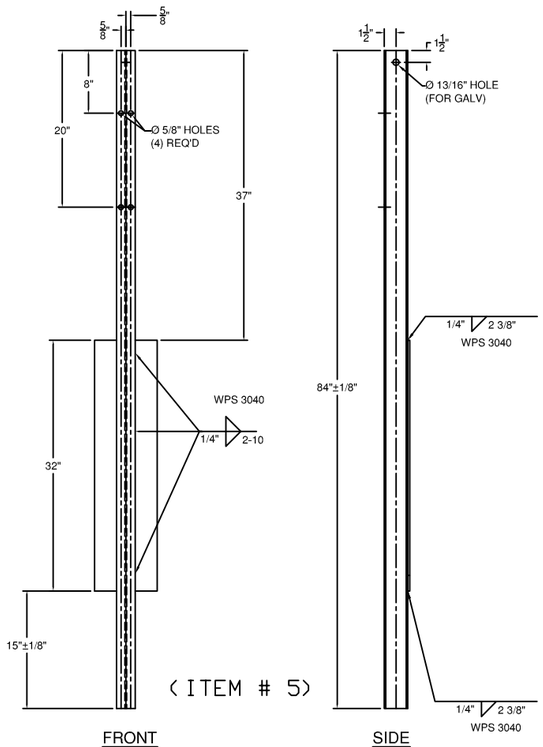
ELDERLEE, INC.
OAKS CORNERS, NEW YORK 14518
E-Mail: dlong@elderlee.com
Tel: 315-789-6670 Fax: 315-789-6615

AISC CERTIFIED FABRICATOR

DRAWN	E.P.	2/19/13
CHECKED	D.L.	2/19/13
APPROVED	.	.
SCALE	SCHEMATIC	
DRAWING NO.	F.R. LAFAYETTE, HANCOCK	

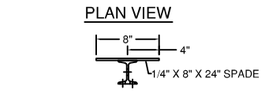
PLAN VIEW

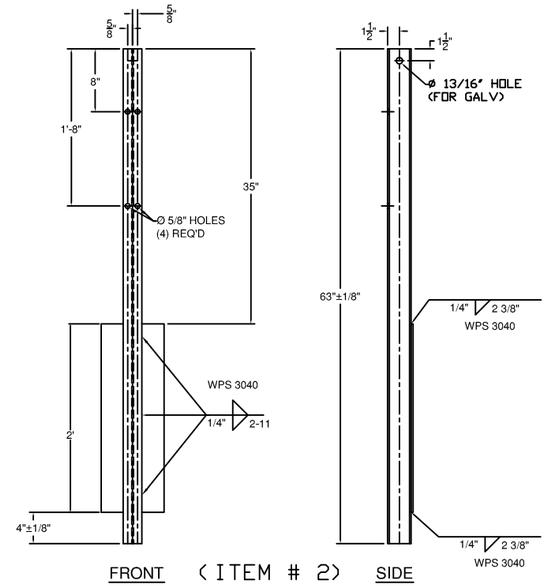




FRONT (ITEM # 5) SIDE

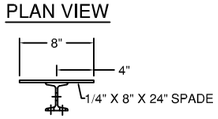
PLAN VIEW

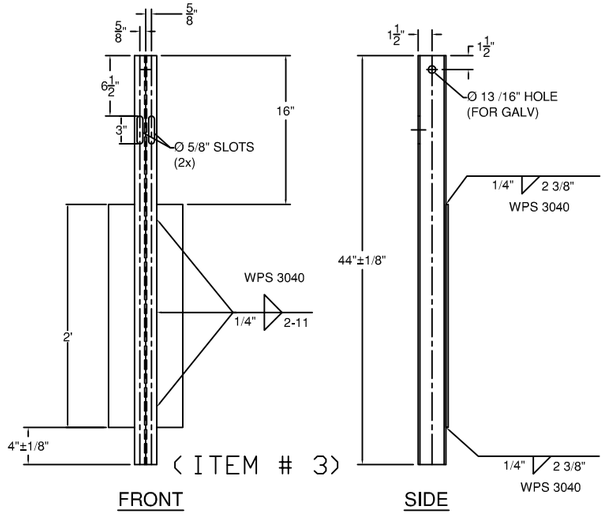




FRONT (ITEM # 2) SIDE

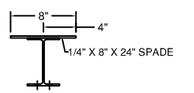
PLAN VIEW

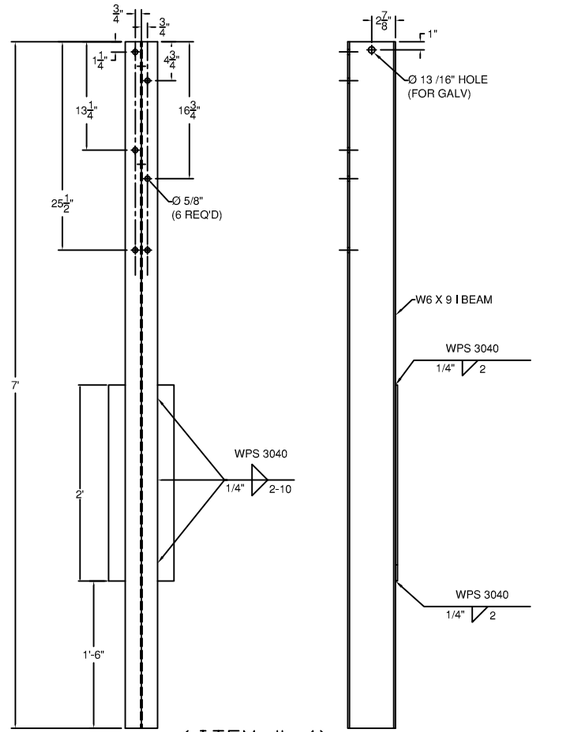




FRONT (ITEM # 3) SIDE

PLAN VIEW





FRONT (ITEM # 4) SIDE

ITEM #: 621.725

F.R. LAFAYETTE, HANCOCK

SHEET 2 OF 5

APPROVED BY:

Vermont Agency of Transportation

RECEIVED

CK'D BY GML/WDL OK'D BY JTS

March 8, 2013

RESUBMIT Approved

BY KMH DATE 03/12/13

GUARD RAIL TO BRIDGE RAIL TRANSITION DETAILS SHEET

HANCOCK, ER BRF 0174 (16), ROUTE VT 125, BRIDGE #23, ITEM# 621.725

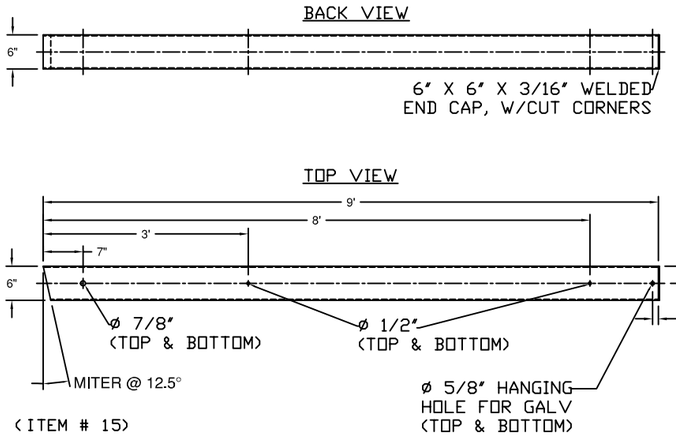
TOWN OF HANCOCK, ADDISON COUNTY, VT

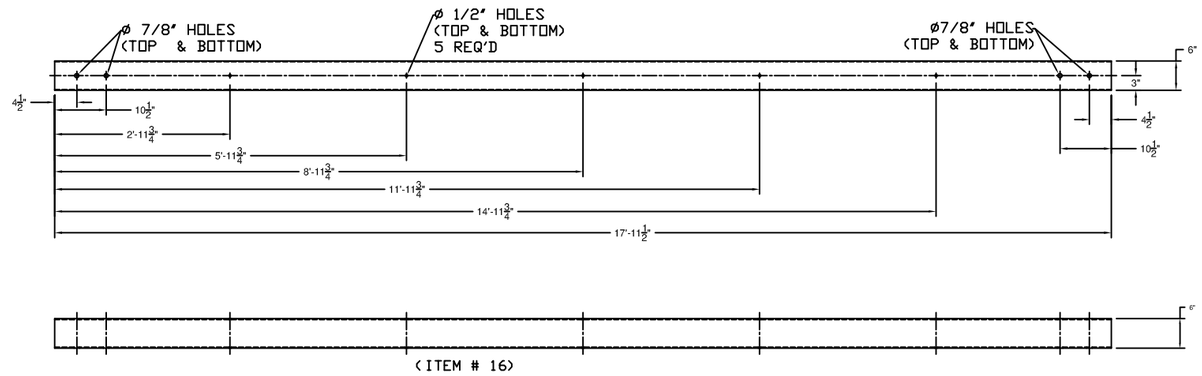
R E V	NO.	DATE	DESCRIPTION	BY	R E V	NO.	DATE	DESCRIPTION	BY

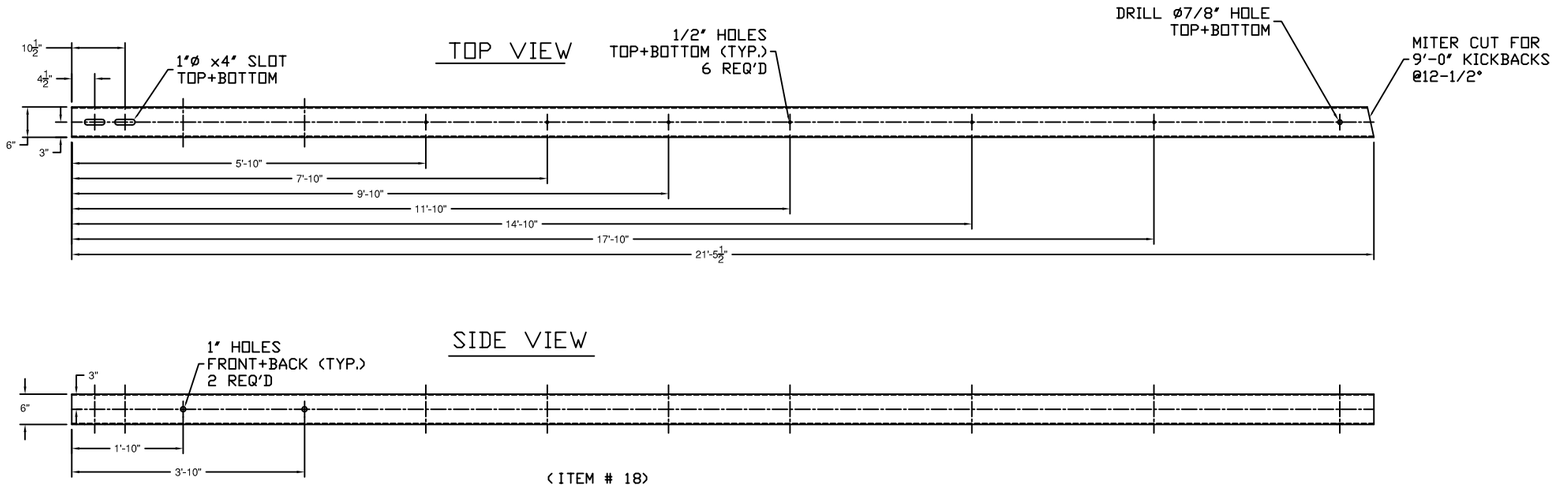
ELDERLEE, INC.
OAKS CORNERS, NEW YORK 14518
E-Mail: dlong@elderlee.com
Tel: 315-789-6670 Fax: 315-789-6615

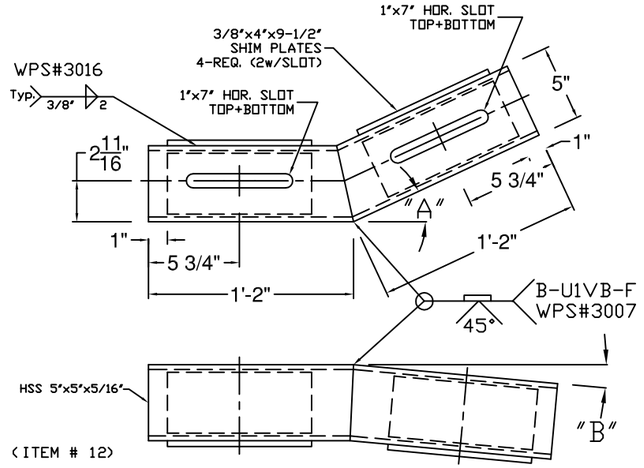
AISC CERTIFIED FABRICATOR

DRAWN	E.P.	2/19/13
CHECKED	D.L.	2/19/13
APPROVED	.	.
SCALE	SCHEMATIC	
DRAWING NO.	F.R. LAFAYETTE, HANCOCK	

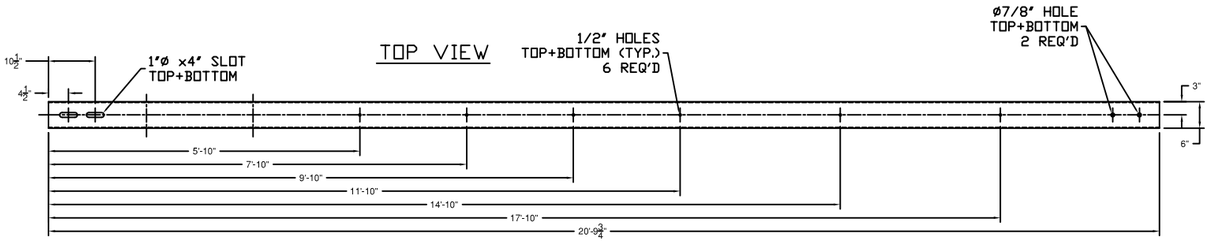


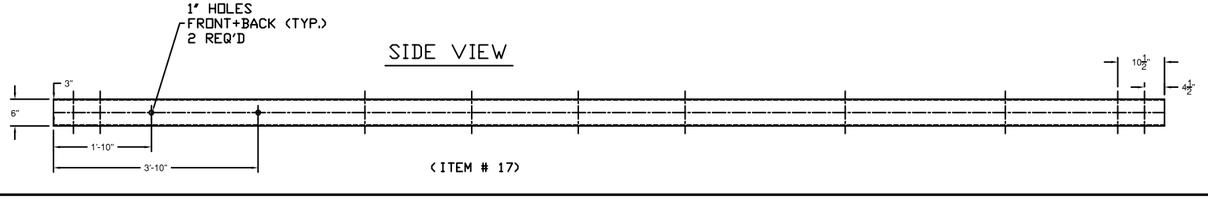






"A" - SEE PLAN FOR TURN BACK DISTANCE, SET ANGLE ACCORDINGLY.
"B" - TURN DOWN ANGLE SET BY THE 9" MEASURMENT AT THE END OF THE BOX BEAM.





GENERAL NOTES:

1) ALL RAILING IS TO BE FABRICATED AND ERECTED ACCORDING TO SECTION 525 OF THE STANDARD SPECIFICATIONS.
2) BOLTS SHALL BE TORQUED SNUG TIGHT (APPROXIMATELY 100 FT-LB).
3) PROTRUSIONS CAUSED BY WELDING OR GALVANIZING ARE NOT PERMITTED ON THE ADJOINING SURFACES OF THE BOX BEAM RAILS, SPLICE TUBES AND FILL PLATES.
4) BOX BEAM TUBE AND STEEL POST MATERIALS, DIMENSION SIZES AND NOTES SHALL BE THE SAME AS THOSE OF THE BRIDGE RAIL, UNLESS OTHERWISE NOTED.

ITEM #: 621.725

F.R. LAFAYETTE, HANCOCK

SHEET 3 OF 5

APPROVED BY:

Vermont Agency of Transportation

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March 8, 2013

RESUBMIT BY KMH

Approved

DATE 03/12/13

GUARD RAIL TO BRIDGE RAIL TRANSITION DETAILS SHEET

HANCOCK, ER BRF 0174 (16), ROUTE VT 125, BRIDGE #23, ITEM# 621.725

TOWN OF HANCOCK, ADDISON COUNTY, VT

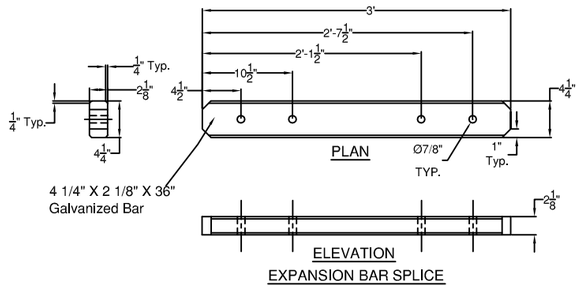
R E V	NO.	DATE	DESCRIPTION	BY	R E V	NO.	DATE	DESCRIPTION	BY

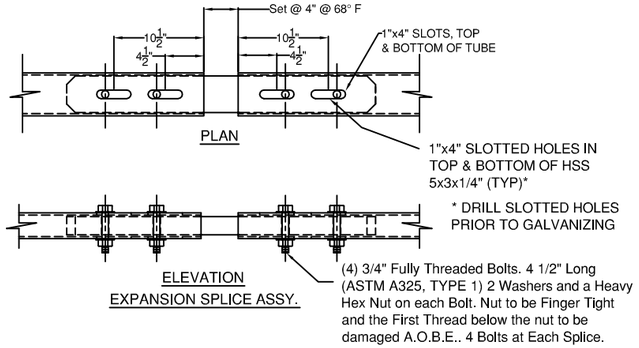
ELDERLEE, INC.
OAKS CORNERS, NEW YORK 14518
E-Mail: dlong@elderlee.com
Tel: 315-789-6670 Fax: 315-789-6615

AISC CERTIFIED FABRICATOR

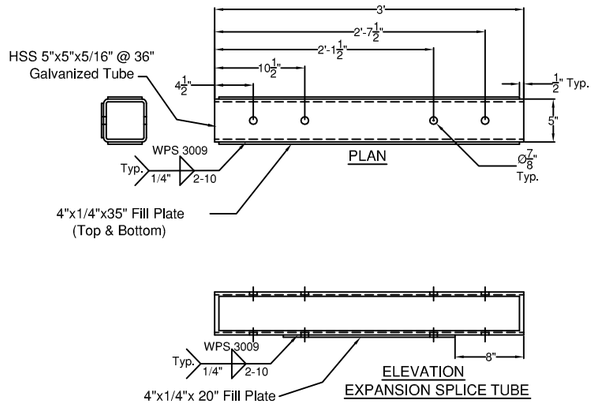
DRAWN	E.P.	2/19/13
CHECKED	D.L.	2/19/13
APPROVED	.	.
SCALE	SCHEMATIC	
DRAWING NO.	F.R. LAFAYETTE, HANCOCK	

SPLICE BAR - EXPANSION

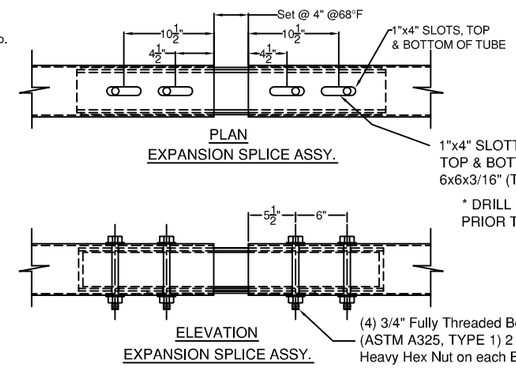




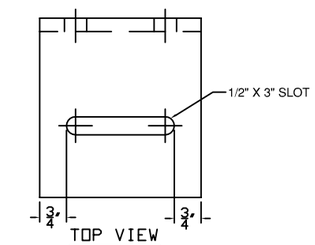
(ITEM # 9)



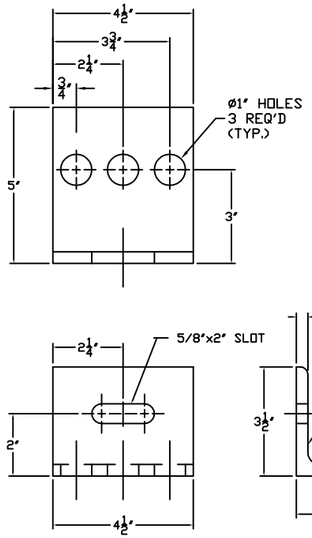
SPLICE TUBE - EXPANSION



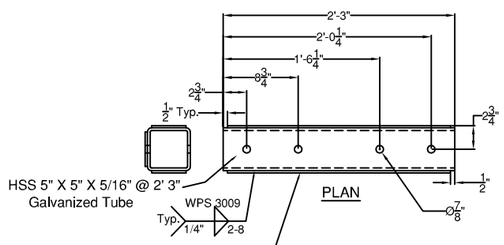
(ITEM # 8)

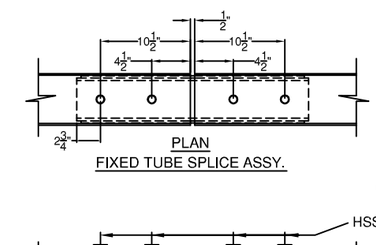


(ITEM # 10)



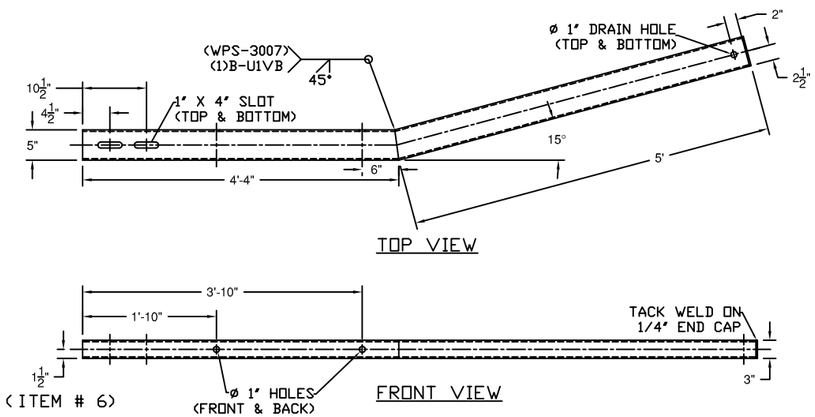
(ITEM # 11)



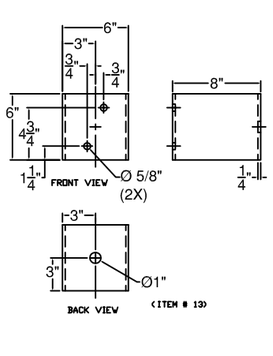


(ITEM # 7)

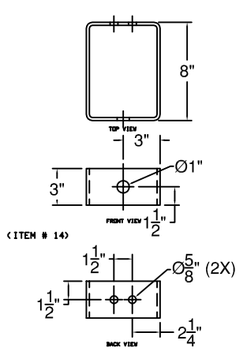
SPLICE TUBE - FIXED



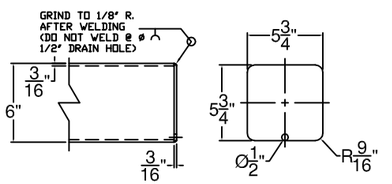
(ITEM # 6)



(ITEM # 13)



(ITEM # 14)



END COVER PLATE DETAIL

ITEM #: 621.725

F.R. LAFAYETTE, HANCOCK

SHEET 4 OF 5

APPROVED BY:

Vermont Agency of Transportation

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March 8, 2013

RESUBMIT _____ Approved

BY KMH DATE 03/12/13

GUARD RAIL TO BRIDGE RAIL TRANSITION DETAILS SHEET

HANCOCK, ER BRF 0174 (16), ROUTE VT 125, BRIDGE #23, ITEM# 621.725

TOWN OF HANCOCK, ADDISON COUNTY, VT

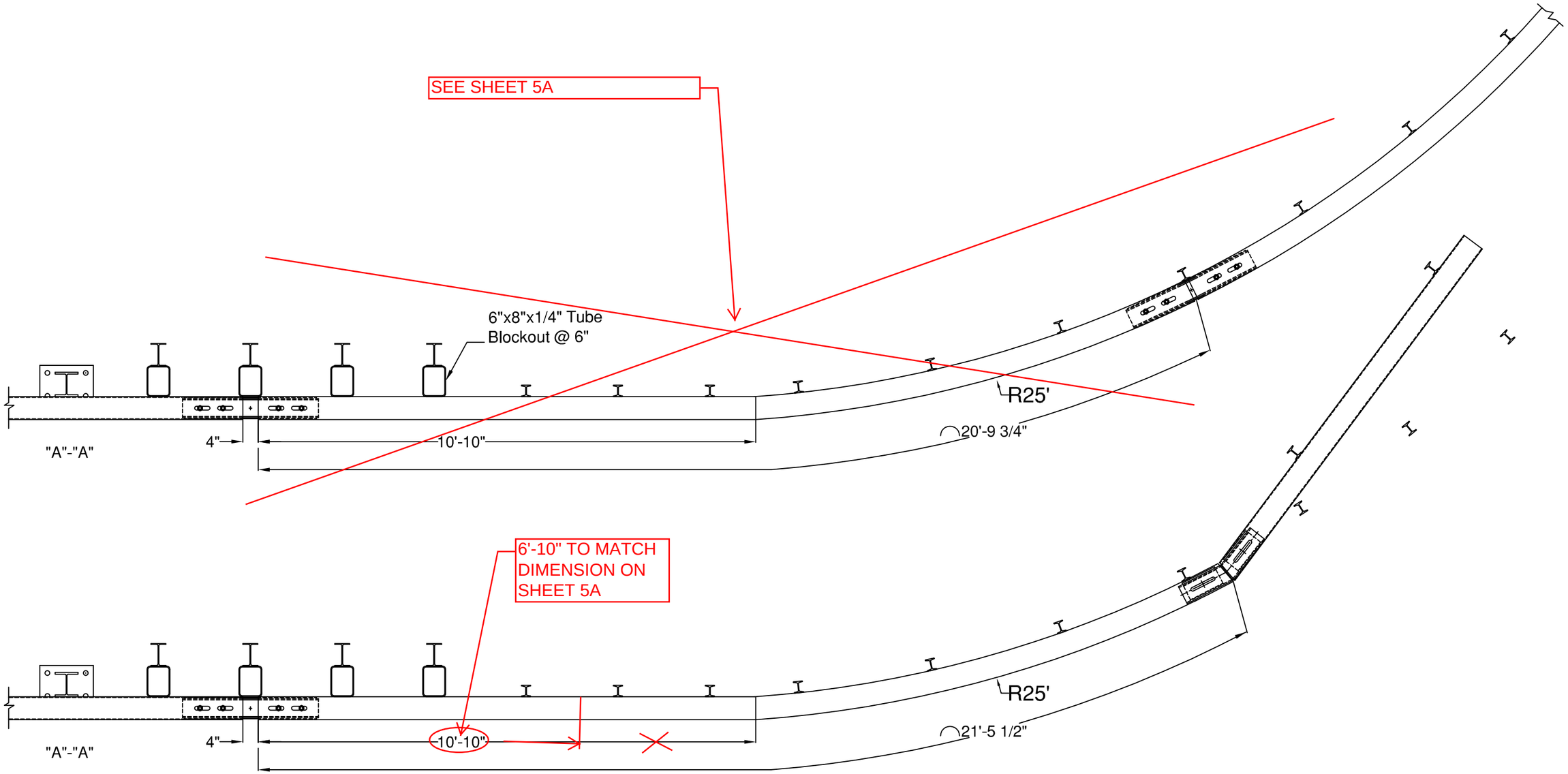
R E V	NO.	DATE	DESCRIPTION	BY	R E V	NO.	DATE	DESCRIPTION	BY

ELDERLEE, INC.
OAKS CORNERS, NEW YORK 14578
E-Mail: dlong@elderlee.com
Tel: 315-789-6670 Fax: 315-789-6615

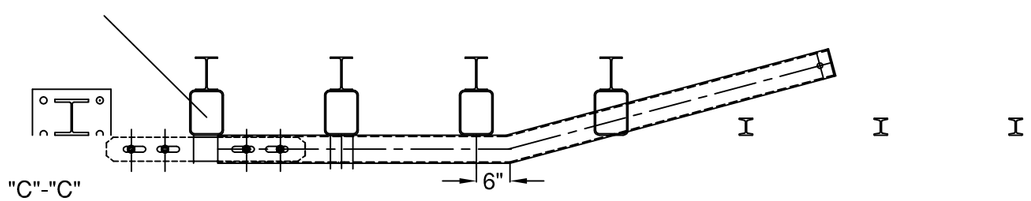
AISC CERTIFIED FABRICATOR

DRAWN	E.P.	2/19/13
CHECKED	D.L.	2/19/13
APPROVED	.	.
SCALE	SCHEMATIC	
DRAWING NO.	F.R. LAFAYETTE, HANCOCK	

SEE SHEET 5A



6'-10" TO MATCH DIMENSION ON SHEET 5A



ITEM #: 621.725

F.R. LAFAYETTE, HANCOCK

SHEET 5 OF 5

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Vermont Agency of Transportation
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BY KMH DATE 03/12/13

GUARD RAIL TO BRIDGE RAIL TRANSITION DETAILS SHEET

HANCOCK, ER BRF 0174 (16), ROUTE VT 125, BRIDGE #23, ITEM# 621.725
TOWN OF HANCOCK, ADDISON COUNTY, VT

REV	NO.	DATE	DESCRIPTION	BY

REV	NO.	DATE	DESCRIPTION	BY

ELDERLEE, INC.
OAKS CORNERS, NEW YORK 14518
E-Mail: dlong@elderlee.com
Tel: 315-789-6670 Fax: 315-789-6615

AISC CERTIFIED FABRICATOR

DRAWN	E.P.	2/19/13
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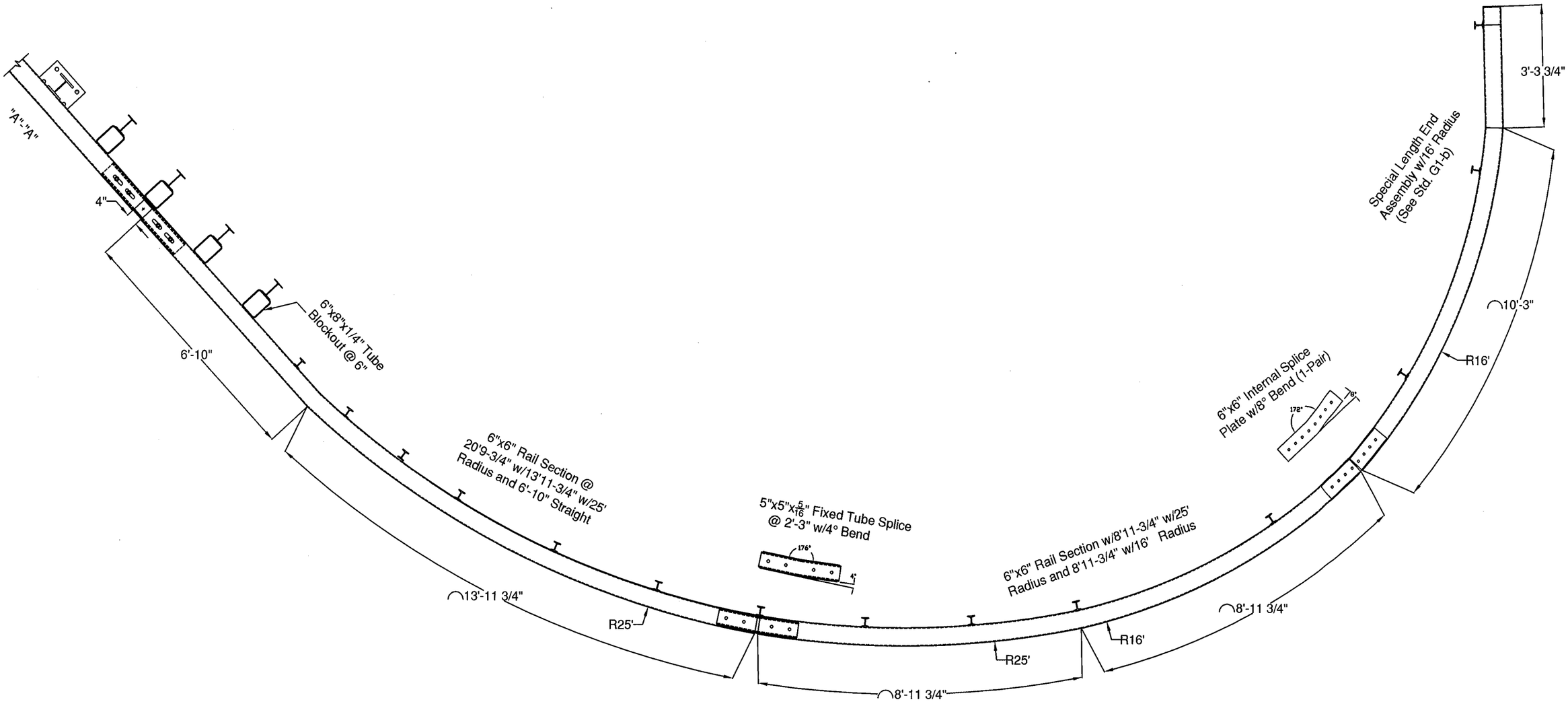
APPROVED	.	.
SCALE	SCHEMATIC	
DRAWING NO.	F.R. LAFAYETTE, HANCOCK	



ITEM #: 621.30

F.R. LAFAYETTE, HANCOCK

SHEET 5a OF 5

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March 12, 2013

RESUBMIT _____ Approved _____

BY KMH DATE 03/12/13

GUARD RAIL TRANSITION TO GUARD RAIL DETAILS SHEET

HANCOCK, ER BRF 0174 (16), ROUTE VT 125, BRIDGE #23, ITEM# 621.725

TOWN OF HANCOCK, ADDISON COUNTY, VT

R	NO.	DATE	DESCRIPTION	BY
E	1	3/7/13	Added Page 5a of 5 to Show Radius in Guard Rail Section	D.L.
V	2	3/12/13	Revised Start of Radius per Email from B.T. on 3/11/13	D.L.

R	NO.	DATE	DESCRIPTION	BY
E				
V				

ELDERLEE, INC.
OAKS CORNERS, NEW YORK 14518
E-Mail: dlong@elderlee.com
Tel:315-789-6670 Fax:315-789-6615

CERTIFIED FABRICATOR

DRAWN	E.P.	2/19/13
CHECKED	D.L.	2/19/13
APPROVED	.	.
SCALE	SCHEMATIC	
DRAWING NO.	F.R. LAFAYETTE, HANCOCK	

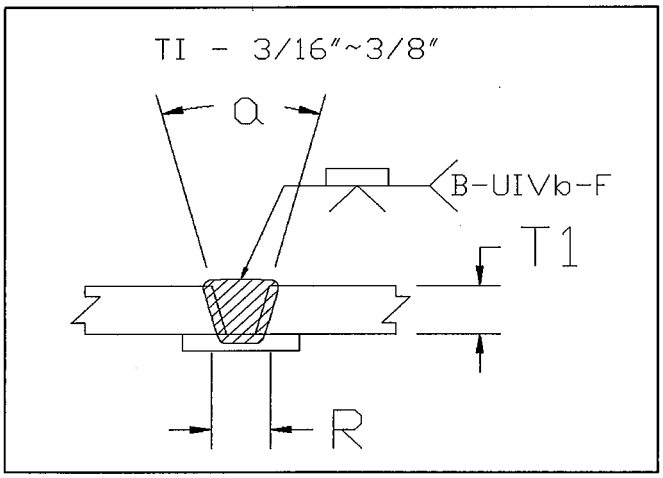
WELDING PROCEDURE SPECIFICATION

Material Specification	A500 GR B
Welding Process	FCAW
Manual or Machine	SEMAUTOMATIC
Position of Welding	FLAT
Filler Metal Specification	A5.20 - 95
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 TABLEL 708 OF THE NYSSCM
Postheat Temperature	NONE
Heat Input	Min _____ Max _____

WELDING PROCEDURE

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

Joint detail



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

Procedure No. 3007
Revision No. _____

Contractor Elderlee, Inc.
Authorized By RANDY SCOTT
Date 3/23/2011

Form III-2

Form III-2-Sample Welding Procedure Specification

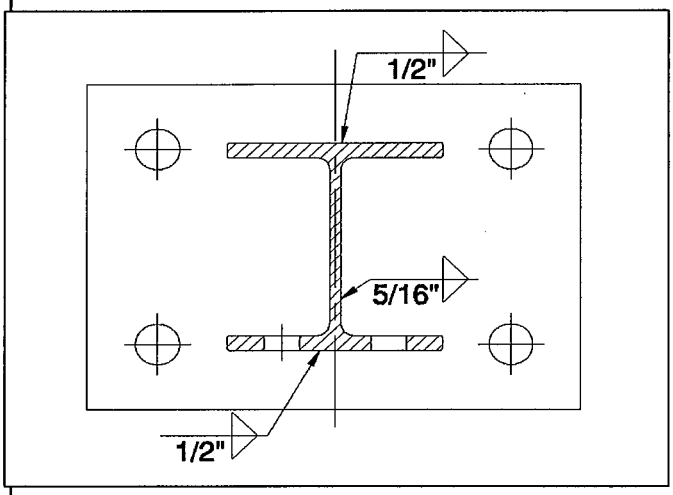
WELDING PROCEDURE SPECIFICATION

Material Specification	A572 GRD. 50 /A992-06a
Welding Process	FCAW
Manual or Machine	SEMAUTOMATIC
Position of Welding	FLAT
Filler Metal Specification	A5.20
Filler Metal Classification	E70 LINCOLN OUTERSHEILD
Flux	N/A
Shielding Gas	CO 2 Dew Point -40DEG F Flow Rate 50 CFM (45 TO 63 CFM)
Single or Multiple Pass	SINGLE
Single or Multiple Arc	N/A
Welding Current	DC
Polarity	DCEP
Welding Progression	STRINGER
Root Treatment	CLEAN AS PER SECTION 603 OF THE NYSSCM
Preheat and Interpass Temperature	PREHEAT AS PER TABLEL 708 OF THE NYSSCM
Postheat Temperature	NONE
Heat Input	Min _____ Max _____

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current Amperes	Welding Current Volts	Travel speed
1	3/32	390	27	12
Variable	LIMITS	351 TO 429	25 TO 29	11 TO 13

Joint detail



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March 8, 2013

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BY KMH DATE 03/12/13

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

Procedure No. 3008

Revision No. _____

Contractor Elderlee, Inc.

Authorized By RANDY SCOTT

Date 10/18/2011

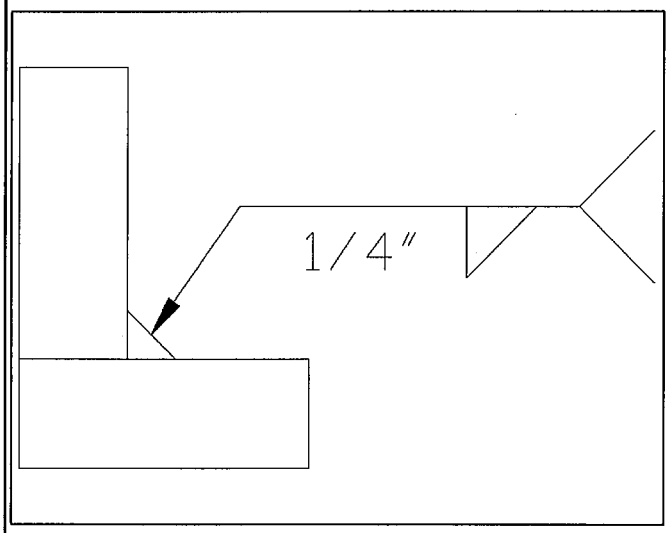
WELDING PROCEDURE SPECIFICATION

Material Specification	A709 TO A500 GR B
Welding Process	FCAW
Manual or Machine	SEMAUTOMATIC
Position of Welding	FLAT
Filler Metal Specification	A5.20 - 95
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 TABLEL 708 OF THE NYSSCM
Postheat Temperature	NONE
Heat Input	Min _____ Max _____

WELDING PROCEDURE

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

Joint detail



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March 8, 2013

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BY KMH DATE 03/12/13

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

Procedure No. 3009

Revision No. _____

Contractor Elderlee, Inc.

Authorized By RANDY SCOTT

Date 10/18/2011

Form III-2

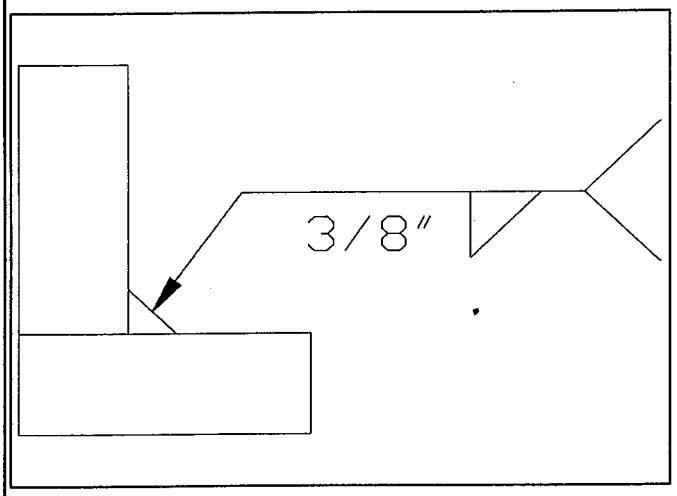
Form III-2-Sample Welding Procedure Specification

WELDING PROCEDURE SPECIFICATION

Material Specification	ASTM-A36 A709 GR 36 CVN
Welding Process	FCAW
Manual or Machine	SEMAUTOMATIC
Position of Welding	FLAT
Filler Metal Specification	A5.20- 95
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
Welding Progression	STRINGER
Root Treatment	PER D1.5
Preheat and Interpass Temperature	PER D1.5
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 TO 330	24 TO 28	12.6 TO 15.4	



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BY KMH DATE 03/12/13

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

Procedure No.	3016	Contractor	Elderlee, Inc.
Revision No.		Authorized By	RANDY SCOTT
		Date	1/3/2013

Form III-2

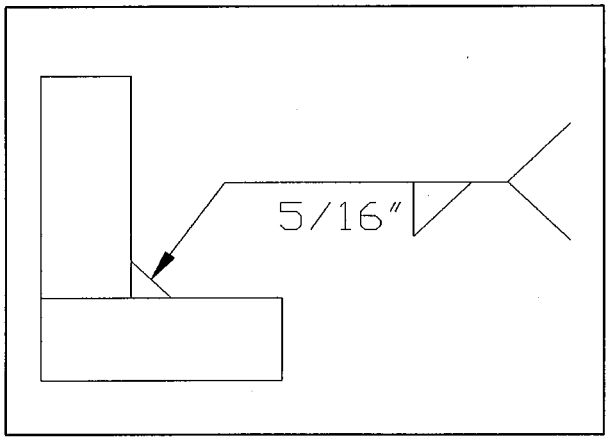
Form III-2-Sample Welding Procedure Specification

WELDING PROCEDURE SPECIFICATION

Material Specification	ASTM A572 GR. 50 CVN	A500 GR B
Welding Process	FCAW	
Manual or Machine	SEMAUTOMATIC	
Position of Welding	FLAT	
Filler Metal Specification	A5.20 - 95	
Filler Metal Classification	E71T-1H8 E71T-9H8 LINCOLN ULTRACORE	
Flux	N/A	
Shielding Gas	CO 2	Dew Point -40DEG F Flow Rate
Single or Multiple Pass	SINGLE	
Single or Multiple Arc	SINGLE	
Welding Current	DC	
Polarity	REVERSE ELECTRODE POSITIVE	
Welding Progression	STRINGER	
Root Treatment	PER D1.5	
Preheat and Interpass Temperature	PER D1.5	
Postheat Temperature	NONE	
Heat Input	Min	Max

WELDING PROCEDURE

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



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March 8, 2013
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BY KMH DATE 03/12/13

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

Procedure No.	3037	Contractor	Elderlee, Inc.
Revision No.		Authorized By	RANDY SCOTT
		Date	12/20/2011

Form III-2

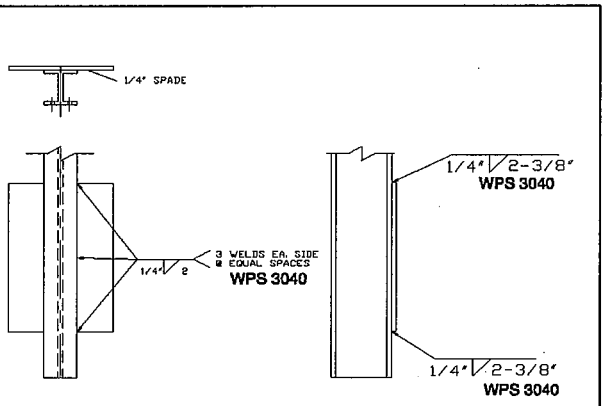
Form III-2-Sample Welding Procedure Specification

WELDING PROCEDURE SPECIFICATION

Material Specification	A36
Welding Process	GMAW
Manual or Machine	SEMAUTOMATIC
Position of Welding	FLAT
Filler Metal Specification	A5.18
Filler Metal Classification	L-50 .052 LINCOLN
Flux	N/A
Shielding Gas	90% ARGON /10% CO2 Dew Point -40DEG F Flow Rate 50 CFM
Single or Multiple Pass	SINGLE
Single or Multiple Arc	SINGLE
Welding Current	DC
Polarity	REVERSE
Welding Progression	STRINGER
Root Treatment	PER D1.5
Preheat and Interpass Temperature	PER D1.5
Postheat Temperature	NONE
Heat Input	Min _____ Max _____

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current Amperes	Welding Current Volts	Travel speed	Joint detail
	.052	430	32	13	
Variable	LIMITS	387 TO 473	29 TO 34	12 TO 14	



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March 8, 2013

RESUBMIT _____ Approved _____

BY KMH DATE 03/12/13

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

Procedure No. 3040

Revision No. _____

Contractor Elderlee, Inc.

Authorized By RANDY SCOTT

Date 12/20/2011

Form III-2

Form III-2-Sample Welding Procedure Specification