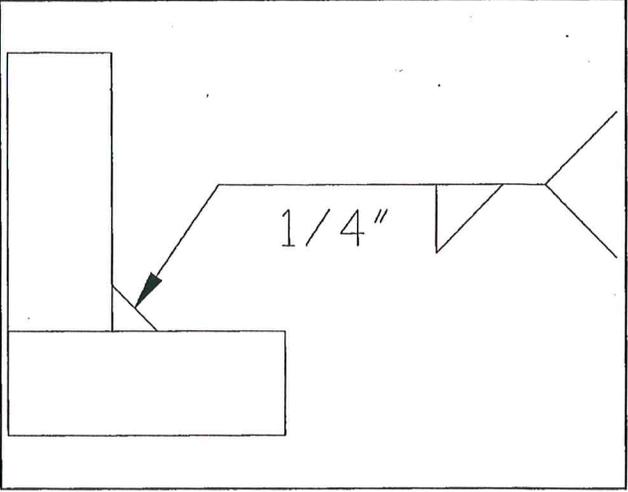


WELDING PROCEDURE SPECIFICATION

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	D1.5		
Preheat and Interpass Temperature	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	24	12.6	
		TO 330	TO 28	TO 15.4	

Vermont Agency of Transportation
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 February 20, 2014

RESUBMIT no Approved
 BY KH DATE 3-12-2014

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

Contractor Elderlee, Inc.

Revision No. _____

Authorized By RANDY SCOTT

Date 5/22/2013

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
Single or Multiple Pass	SINGLE		(45 TO 63 CFM)
Single or Multiple Arc	N/A		
Welding Current	DC		
Polarity	DCEP		
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	3/32	390	27	12	
Variable	LIMITS	351	25	11	
		TO	TO	TO	
		429	29	13	

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Procedure No. 3008

Contractor Elderlee, Inc.

Revision No. _____

Authorized By RANDY SCOTT

Date 5/29/2013

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	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	24	12.6	
		TO 330	TO 28	TO 15.4	

Vermont Agency of Transportation
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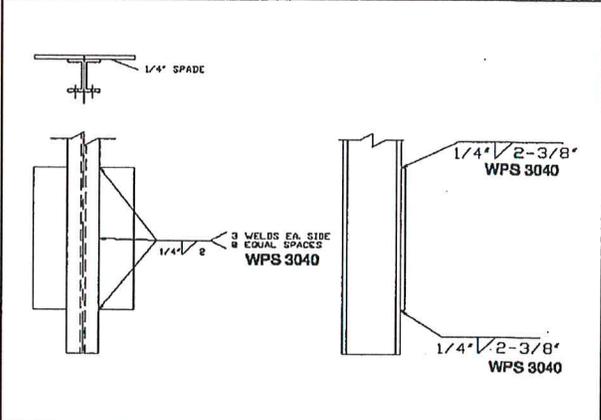
Procedure No. 3007
 Revision No. _____

Contractor Elderlee, Inc.
 Authorized By RANDY SCOTT
 Date 5/29/2013

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		Travel speed	Joint detail
		Amperes	Volts		
Variable	.052	430	32	13	
	LIMITS	387	29	12	
		TO	TO	TO	
		473	34		

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February 20, 2014

RESUBMIT no Approved
BY KH DATE 3-12-2014

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

Contractor Elderlee, Inc.

Revision No. _____

Authorized By RANDY SCOTT

Date 12/20/2011