

Welding Procedure Specification

Base Material specification _A709 Gr 50, A653 Gr 40-50_ Base metal thickness __0.1084"__
 Welding process __SMAW__
 Manual, semi-automatic, or automatic __Manual__
 Joint type _Fillet__ Backing material __None__ Backgouging method _N/A__
 Position of welding __Horizontal / Vertical Up__
 Filler metal specification AWS _A 5.1_
 Filler metal classification __E7018__
 Electrode and manufacturer __Murex (Lincoln Electric) 7018__
 Flux and manufacturer __N/A__
 Shielding gas __N/A__ Dew point __N/A__ Flow rate __N/A__
 Single or multiple pass __Single__ Single or multiple arc __Single__
 Welding current __DC__ Polarity __Reverse (DCEP)__
 Welding progression __Forward__
 Root treatment __Free of rust, dirt, oil and moisture__
 Heat treatment __None__
 Pre-heat and inter-pass temperature __None__
 Post-heat treatment __None__

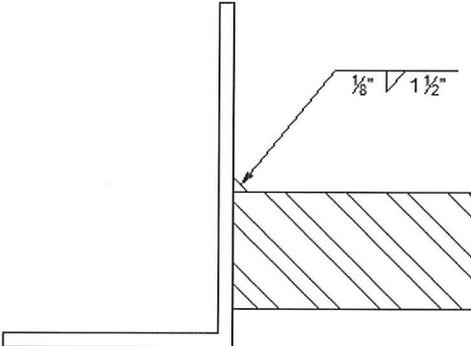
Vermont Agency of Transportation

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CK'D BY J Clark OK'D BY D Bonneau

May 5, 2015

RESUBMIT No Approved
 BY D Bonneau DATE 05/05/15

Pass no.	Electrode size	Welding Current		Travel speed (IPM)	Weld Size	Joint Detail
		Amperes	Volts			
All	3/32"	90-110		6"	1/8"	 <p style="text-align: center;">For fillet welds at SIPCMF support angle</p>

Procedure no. __BB-SIP-02__
 Revision no. __00__

Contractor __Beck and Bellucci, Inc.____
 Authorized by *[Signature]*
 Date __5-5-2015__