

Material Specification

Welding Process

Manual or Machine

Position of Welding

Filler Metal Specification

Filler Metal Classification

Flux

Shielding Gas

Single or Multiple Pass

Single or Multiple Arc

Welding Current

Polarity

Welding Progression

Root Treatment

Preheat and Interpass Temperature

Postheat Temperature

Heat Input

A709 TO A500 GR B

FCAW-G

SEMAUTOMATIC

FLAT/HORIZONTAL

A5.29

E81T1-Ni1C-JH4

N/A

CO 2

Dew Point -40DEG F

Flow Rate 50CFH

SINGLE

SINGLE

DC

REVERSE ELECTRODE POSITIVE

STRINGER

D1.5

D1.5

NONE

Min

Max

SHOP DRAWING REVIEW

☐ REVIEWED AS REQUIRED BY THE CONSTRUCTION CONTRACT DOCUMENTS AND APPROVED, BUT ONLY FOR CONFORMANCE TO THE DESIGN CONCEPT OF THE WORK, AND SUBJECT TO FURTHER LIMITATIONS AND REQUIREMENTS CONTAINED IN THE CONSTRUCTION CONTRACT DOCUMENTS.

☐ REJECTED

☐ REVISE AND RESUBMIT

☒ APPROVED AS NOTED

CORRECTIONS OR COMMENTS MADE ON THE SHOP DRAWINGS DURING THIS REVIEW DID NOT RELIEVE CONTRACTOR FROM COMPLIANCE WITH REQUIREMENTS OF THE DRAWINGS AND SPECIFICATIONS. THIS CHECK IS ONLY FOR REVIEW OF GENERAL CONFORMANCE WITH THE DESIGN CONCEPT OF THE PROJECT AND GENERAL COMPLIANCE WITH THE INFORMATION GIVEN IN THE CONTRACT DOCUMENTS. THE CONTRACTOR IS RESPONSIBLE FOR: CONFIRMING AND CORRELATING ALL QUANTITIES AND DIMENSIONS; SELECTING FABRICATION PROCESSES AND TECHNIQUES OF CONSTRUCTION; COORDINATING THEIR WORK WITH THAT OF ALL OTHER TRADES; AND PERFORMING THEIR WORK IN A SAFE AND SATISFACTORY MANNER.

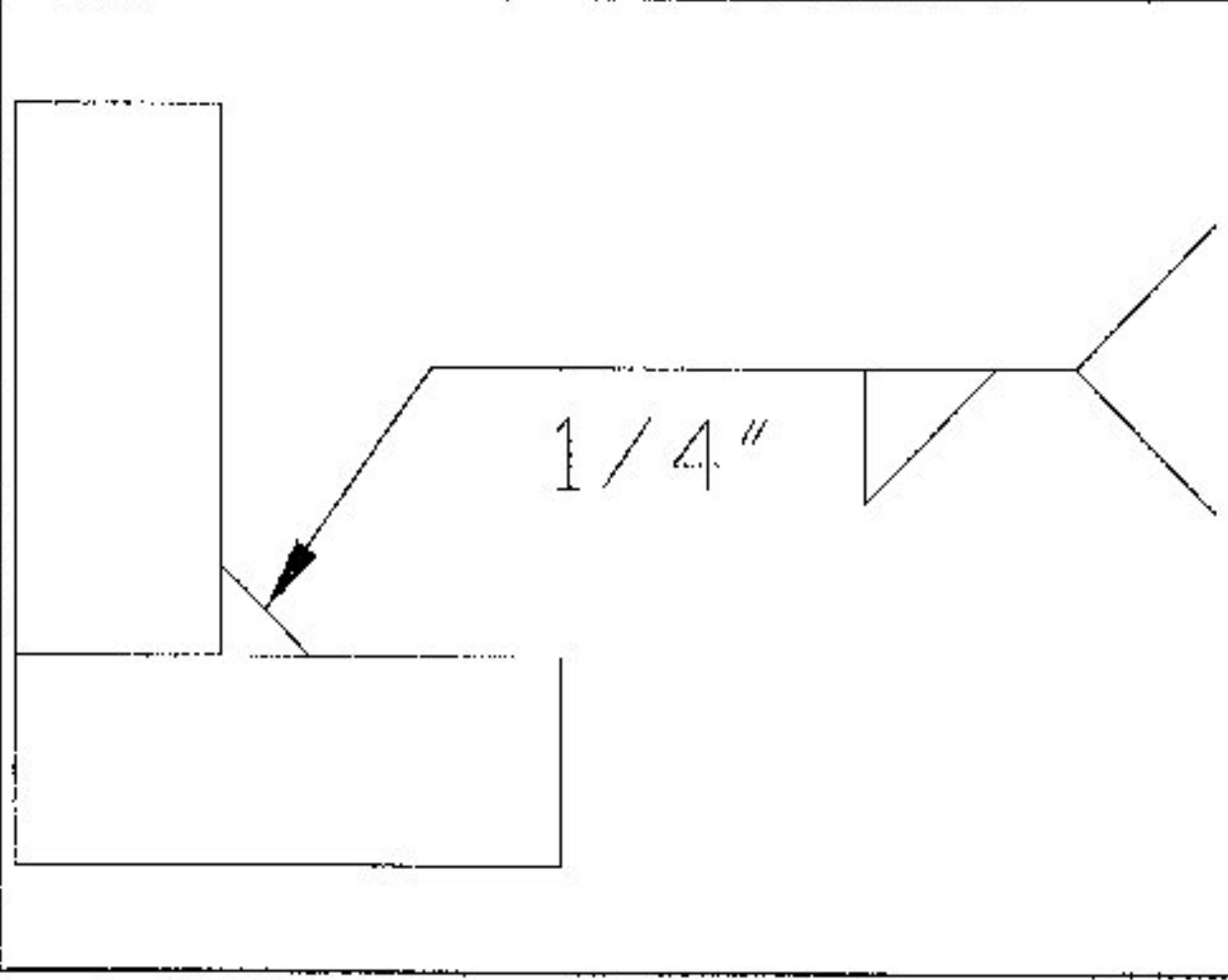
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Reviewed by: SRB

Date: 3/23/2015

| WELDING PROCEDURE |                |                 |       |              |                                                                                     |
|-------------------|----------------|-----------------|-------|--------------|-------------------------------------------------------------------------------------|
| Pass no.          | Electrode size | Welding Current |       | Travel speed | Joint detail                                                                        |
|                   |                | Amperes         | Volts |              |                                                                                     |
| 1                 | 1/16           | 310             | 25    | 11           |  |
| Variable          | LIMITS         | 341             | 27    | 12           |                                                                                     |
|                   |                | TO 269          | TO 23 | TO 10        |                                                                                     |

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

3/20/2014

Vermont Agency of Transportation

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CONFORMANCE

BY: Rob Young

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