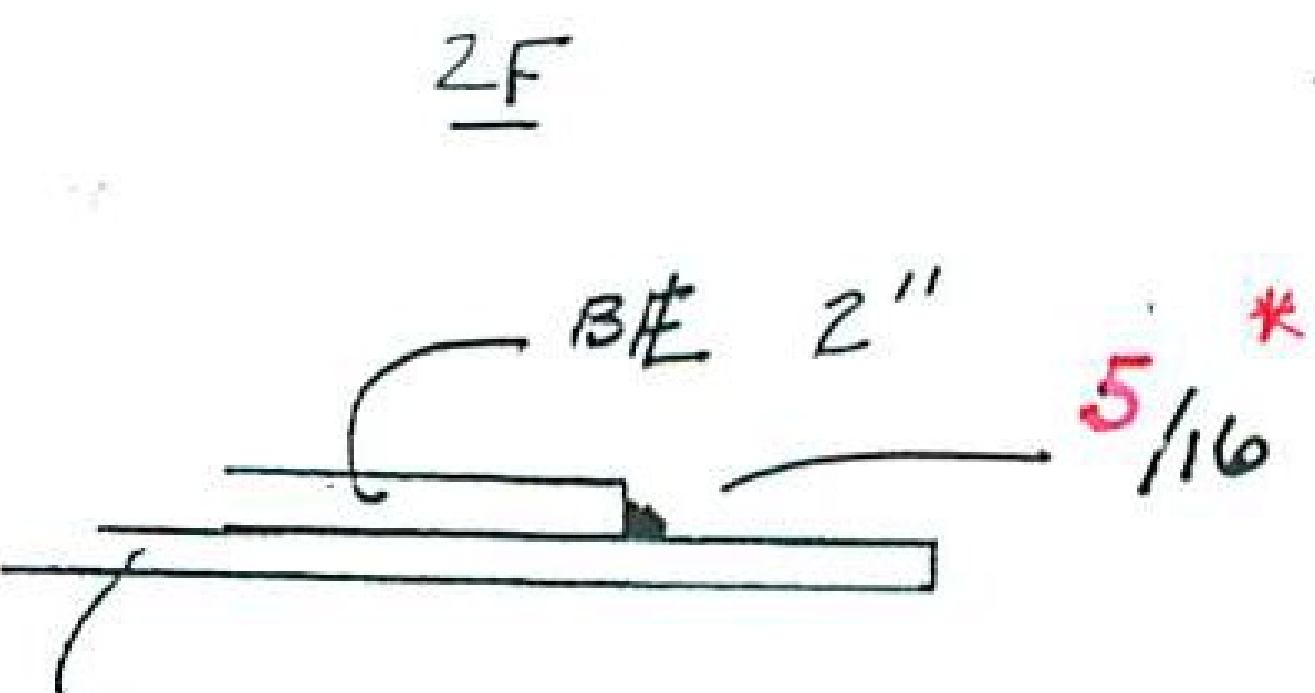


Manual or machine MANUAL
 Position of welding HORIZONTAL 2F
 Filler metal specification AWS A5-1
 Filler metal classification E 7018
 Flux N/A
 Shielding gas N/A Flow rate N/A
 Single or multiple pass SINGLE OR MULTIPLE
 Single or multiple arc SINGLE
 Welding current AC/DC
 Polarity STRAIGHT OR REVERSE
 Welding progression —
 Root treatment WIRE BRUSH AREA TO BE FREE OF LOOSE RUST, MOISTURE
 Preheat and interpass temperature 50° to 3/4", 70° to 3/4"-1 1/2", 150°F 1 1/2" to 2 1/2"
 Postheat treatment —

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Ampere	Volts		
AS REQUIRED	1/8"	90-170	22-26	AS REQUIRED	 2F 2" 5/16 * 1" SOLE PLATE
	5/32"	120-200	22-26		
	3/16"	170-250	24-27		

Vermont Agency of Transportation
RECEIVED
 CK'D BY _____ OK'D BY JWC
 15 DEC 2011
 RESUBMIT _____ APPROVED ☒
 BY _____ DATE 12-19-2011

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

Procedure no. 401-A-FIELD WELD
 Revision no. # REV PER VTIANJ REQUEST

Contractor WINTERSET, INC.
 Authorized by GLENN A. LAVOIE, P.E.
 Date 11-11-11 REV. 12-15-11
 PROJECT: BETHEL
BHF 0241/30 1

