

Welding process SMAW
 Manual or machine MANUAL
 Position of welding HORIZONTAL 2G
 Filler metal specification AWS A5.1
 Filler metal classification E 7018
 Flux NA
 Shielding gas N/A Flow rate N/A
 Single or multiple pass SINGLE
 Single or multiple arc SINGLE
 Welding current DC
 Polarity REVERSE
 Welding progression SEE JOINT DETAIL
 Root treatment WIRE BRUSH AREA TO BE FREE OF LOOSE SCALE, RUST, MORTAR
 Preheat and interpass temperature 70° min OVER 3/8" T
 Postheat treatment N/A

* operator must be certified in position used
 WELDING PROCEDURE

Pass no	Electrode size	Welding current		Travel speed	Joint detail
		Amps	Volts		
1	1/8	125 ± 10%	30 ± 7%	10 IPM	
1	5/32	125 ± 10%	30 ± 7%	10 IPM	

Vermont Agency of Transportation

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CK'D BY _____ OK'D BY J.W.C

15 DEC 2011

RESUBMIT _____ APPROVED ☒
 BY _____ DATE 12-19-2011

Procedure no. PWF POINT
 Revision no. - 0 -
 Contractor: WINTERSET, INC.
 Authorized by: GLENN A. LAVOIE, P.E.
 Date: 11-11-11
 PROJECT: BETHEL
BHF 0241 (30)