

Filler metal specification E 7018
 Flux N/A
 Shielding gas N/A Flow rate N/A
 Single or multiple pass MULTIPLE
 Single or multiple arc SINGLE
 Welding current DC
 Polarity REVERSE
 Welding progression SEE JOINT DETAIL
 Root treatment WIRE BRUSH
 Preheat and interpass temperature 50° MIN
 Postheat treatment NA

Vermont Agency of Transportation

RECEIVED

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

15 DEC 2011

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

* OPERATOR MUST BE CERTIFIED IN POSITION USED
WELDING PROCEDURE

Pass no	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
1	1/8	90-170	22-26	AS REQ'D	
AS REQ'D	3/16	170-250	24-27	AS REQ'D	

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

Procedure no. PILE SPLICE Contractor WINTERSET, INC.

Revision no. 0 Authorized by GLENN A. LAVOIE, P.E.

Date 11-11-11

PROJECT: BETHEL

R.H.F. 0241/30

