

Position of welding HORIZONTAL / VERTICAL / OVERHEAD
 Filler metal specification AUS 851
 Filler metal classification E 7018
 Flux N/A
 Shielding gas N/A Flow rate N/A
 Single or multiple pass MULTIPLE PASS FOR 3/8" SINGLE FOR 5/16"
 Single or multiple arc SINGLE
 Welding current DC
 Polarity REVERSE
 Welding progression SEE JOINT DETAIL
 Root treatment WIRE BRUSH AREA
 Preheat and interpass temperature 50° min
 Postheat treatment N/A

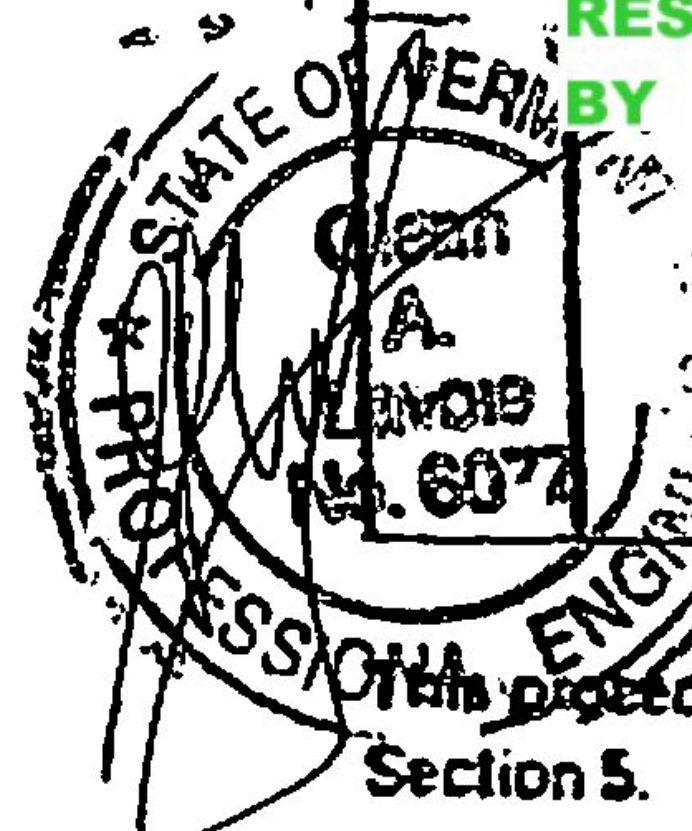
* operator must be certified in position used

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
1	1/8	125	30	10"	
2 or more		±10%	±7%	10"	

Vermont Agency of Transportation
RECEIVED
 CK'D BY _____ OK'D BY J.W.C.
 15 DEC 2011
 RESUBMIT _____ APPROVED ✓
 DATE 12-19-2011

HP 12 x 84
 (HP 310 x 125)



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

Procedure no. SPLICE PLATE
 Revision no. 0

Contractor WINTERSET INC.
 Authorized by GLENN A. LAVOIE, P.E.
 Date 11-11-11

PROJECT: BETHEL
BHF 0241/30