

Flux	N/A	
Shielding Gas	CO 2	Dew Point -40DEG F Flow Rate 50CFH
Single or Multiple Pass	SINGLE	
Single or Multiple Arc	SINGLE	
Welding Current	DC	
Polarity	(REVERSE) ELECTRODE POSITIVE	
Welding Progression	STRINGER	
Root Treatment	CLEAN AS PER SECTION 603 OF THE NYSSCM	
Preheat and Interpass Temperature	PREHEAT AS PER TABLE 708 OF THE NYSSCM	
Postheat Temperature	NONE	
Heat Input	Min _____	Max _____

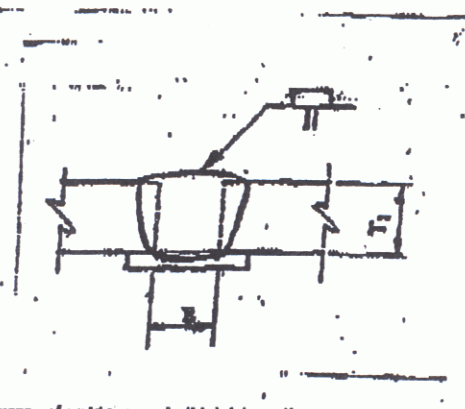
WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
	1/16	300	26	14	
Variable	LIMITS	270	24	12.6	
		TO	TO	TO	
		330	28	15.4	

**NYSDOT
METALS ENGINEERING
REVIEW**

☒ APPROVED
☐ APPROVED AS NOTED
☐ DISAPPROVED

1/21/09
R. Pinkins



Sequence of weld passes shall be shown diagrammatically

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

Procedure No. 1028
Revision No. _____

Contractor Elderlee, Inc.
Authorized By RANDY SCOTT
Date 12/4/2008

Form III-2

Form III-2-Sample Welding Procedure Specification

CK'D BY _____ OK'D BY Juc

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OCT 05 2008

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