

 Office of Structures <i>Guidelines and Procedures</i> <i>Memorandum</i>	DESIGN
	Number: D-77-11(4)
	Date: 03-16-2018
Electro-Slag Welding	Approval; 

Based on preliminary results of recent research and the actual observations in the field, the use of electro-slag weldments on main structural tension members will not be permitted. This restriction will continue until such time as the quality of this weld can be ensured by possible modification in the welding process and/or improvement in the inspection and quality control procedures which appear necessary at this time.

Because the economic advantage of this type of weld will be lost by this restriction, other types of welding processes in thicker material will become costly and provide opportunity for welding complications. Accordingly, the use of main member tension material in excess of 2 inches thickness is to be avoided wherever possible by modification in the structural components or in the material makeup of the individual structural member.

Based on FHWA Notice N 5040.23 dated February 16, 1977