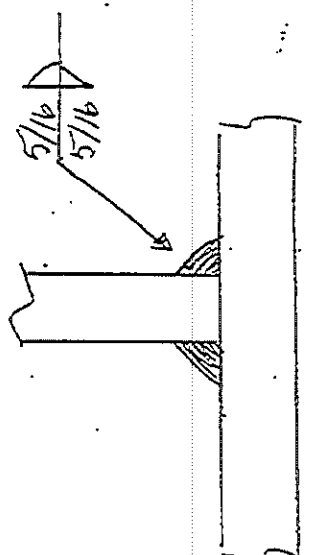


WELDING PROCEDURE SPECIFICATION

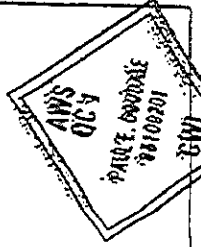
Material specification A51.1M-709-G-136-50-50w/A709M GR 250-345-345w
 Welding process Flux Cored Arc welding (FCAW) VTRANS
 Manual or machine Semi AUTO
 Position of welding Flat-Horizontal
 Filler metal specification AWS A5-29
 Filler metal classification E6017-Ni1-H4 E5AB
 Flux NA
 Shielding gas 75% AR-25% CO2 Flow rate 35 CFH
 Single or multiple pass Single / Multiple Elec EX ± 1/4
 Single or multiple arc Single
 Welding current DC
 Polarity DC EP
 Welding progression See detail
 Root treatment wire brush - argon to free of loose scale, slag, rust, moisture
 Preheat and interpass temperature 20mm (74) 10(50) 40(217) TO 40(1/2) 20(20) 40(217) TO 60(28) 65 C15
 Postheat temperature NA
 Heat Input Min 27.2 kJ/in Max 43.6 kJ/in PQR FCM #8 39.6 kJ/in

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 CBSS 484

WELDING PROCEDURE

Pass / no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
		<u>287</u>	<u>29</u>	<u>13</u>	
	<u>1/16</u>	<u>258 TO 315</u>	<u>26.8 TO 31</u>	<u>11.4 TO 14</u>	

Putney IM 091-1(60)
VTrans Structures' Section
Jan 26, 2011



This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variances given in applicable A.W.S. codes or contract specifications

Procedure no. 101 ST OF VT
 Revision no. _____
 Contractor Casco Bay Steel
 Authorized By Paul C. Goodale
 Date 12-6-06