

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A709M-Gr36(230), 50(345), 50W(345W)
 Welding process Submerged Arc welding
 Manual or machine Machine
 Position of welding Horizontal (GF)
 Filler metal specification AWS A5-23
 Filler metal classification E802-E7018-Ni-1 Lincoln
 Flux Lincoln 800 Flux with LA-75 Electrode
 Shielding gas NA Flow rate NA
 Single or multiple pass Single - Electrode Ex. 1#34 (25.4 ± 1%)
 Single or multiple arc Single
 Welding current DC
 Polarity DCEN
 Welding progression See Joint Detail
 Root treatment AWS spec. wire brush - grind - Blast (Clean area)
 Preheat and interpass temperature 34 (19) to 50 (10) to 30 (19) to 140 (60) to 200 (150) to 225 (100) to 250 (100)
 Postheat temperature NA
 Heat input See table Max 40.1 kJ/in (1.9 kJ/mm) DGR 4-42.8 kJ/in (1.7 kJ/mm)

WELDING PROCEDURE VT, ACT GORINTH

Pass no.	Electrode size	Welding current		Travel speed	Fillet AWS D1.5
		Amperes	Volts		
1	3/32	299	31	12 IPM	AP
		269	29	11	
		70	33	15	
2	2.4	299	31	380 mm	
		269	29	279	
		70	33	381	

VT, ACT GORINTH
 Br # 34 - Proj # STBRO-1447(32)
 C.B.S.S. NO 380
 OK'D BY: [Signature] OK'D BY: [Signature]
 11/24/08

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

Procedure no. 250 Contractor Casco Bay Steel
 Revision no. _____ Authorized By Paul E. Goodale
 Form III-2 Date 6-13-00