

**Casco Bay Steel Structures, Inc.**

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**WELDING PROCEDURE SPECIFICATION**

Material specification ASTM A99 Gr 36-50-50w (250-345-345w)  
 Welding process Submerged Arc Welding - AUTO (SAW)  
 Manual or machine Machine  
 Position of welding FLAT (1F) HORIZONTAL (2F)  
 Filler metal specification AWS A5-17 AWS A5-23  
 Filler metal classification E802-Ewik-Ni1 Lincoln  
 Flux 960 Flux-Lincolnweld-LA-95 Electrode  
 Shielding gas NA Flow rate NA  
 Single or multiple pass both  
 Single or multiple arc single  
 Welding current Direct  
 Polarity Reverse Electrode Positive  
 Welding progression  
 Post treatment Meet AWS Specification  
 Preheat and interpass temperature To 3/4(19)-50(400) 3/4(19) 1/2(88) 70(200) 1/4(88) To 2 1/2(63.5)-450(650)  
 Postheat temperature NA  
 Heat input Min 41.65 Max 65.45 PQR # 1-59.5  
 Bathel - Vermont  
 8220 31 (30221)  
 Proj # BRF-0241(33) 5/2  
 CBS# 270

(Metric) WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail
		Amperes	Volts		
5/32	5/32	605	29.5	18.5	IF 
		544.5	29.4	15.3	
		665.5	31.56	20.9	
3/9	3/9	605	29.5	459.2	2F 
		544.5	29.4	384.6	
		665.5	31.56	525.8	

OK'D BY \_\_\_\_\_ OK'D BY JWC  
 JUL 14 2005  
 RESUBMIT \_\_\_\_\_ APPROVED ✓  
 BY \_\_\_\_\_ DATE 7-26-05

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. 201 Contractor Casco Bay Steel  
 Revision no. \_\_\_\_\_ Authorized By Paul E. Woodruff  
 Form III-2 \_\_\_\_\_ Date 3/2/00