

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A36-50-50w (250-345-345w)
 Welding process submerged arc welding - Auto (SAW)
 Manual or machine Automatic
 Position of welding Flat (1G)
 Filler metal specification AWS A5.19 AWS A5-23
 Flux 760 Flux - Lincoln Weld - LA-75 Electrode
 Shielding gas NA
 Single or multiple pass both
 Single or multiple arc single
 Welding current Direct Electrode Positive
 Polarity Reverse Electrode Positive
 Welding progression Meet AWS specification - Back gouge side 2
 Root treatment Meet AWS specification - 1/2" to 1 1/2" (3.2 to 38.1) 2 1/2" (63.5) 150 (6.5)
 Preheat and interpass temperature NA
 Postheat temperature NA
 Heat Input Min 41.65 Max 65.45 PAR 1-59.5

APPROVED BY: JWC
 DATE: 7-26-05

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail
		Amperes	Volts		
5/32	605	29.5	18.5	AWS D1.5 Joint detail B-12c-s side #1 	
	544.5	27.4	15.3		
	665.5	31.56	20.7		
3/8	605	29.5	457.2	T1 1/2" to 1" 1/4 min (2.7 to 25.4) (6) 1" to 1 1/2" 3/8 min (25.4 to 38.1) (9.5) 1 1/2" to 2" 1/2 min (38.1 to 50) (12)	
	544.5	27.4	388.6		
	665.5	31.56	525.8		

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

Procedure no. 202
 Revision no. _____
 Form III-2

Contractor Casco Bay Steel
 Authorized By T. P. Stoddard
 Date 3/2/00