

Casco Bay Steel Structures, Inc.

75 Spring Hill Road
Saco, Maine 04072

Phone: (207) 282-7360

Fax: (207) 282-1179

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A109/A109M = Gr. 250 (A36) - 345 (A50) - 345W (A50W)
 Welding process Submerged Arc Welding - Semi-AUTO
 Manual or machine machine
 Position of welding FLAT (G)
 Filler metal specification AWS A5-17 - AWS A5-23
 Filler metal classification E8018-11 Lincoln
 Flux 960 Lincoln Flux - Electrode, LA-72 Lincoln
 Shielding gas NA Flow rate NA
 Single or multiple pass Both Electrode extension 1"±4 - 20.4 rcm
 Single or multiple arc Single
 Welding current Direct
 Polarity DC EP

Welding progression
 Root treatment Backgrind - Grind to AWS specification
 Preheat and interpass temperature To 34(19) 50(60) 34(19) to 1/2 (88) - 70(20) 100(80) to 2/2 (69) - 50(60)
 Postheat temperature NA over 2/2 (69) 25(109)
 Heat input Min 50 KJ/in Max 79 KJ/in POR #5 2.2 KJ/in, 2.8 KJ/in
2 KJ/in 3 KJ/in

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
AS REQ	3/32	505	33	14 IPM 356 mm/min
		454	31	14 I2
		70	35	356 I33
		556	35	356

TRANS RECEIVED
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 JUL 14 2005
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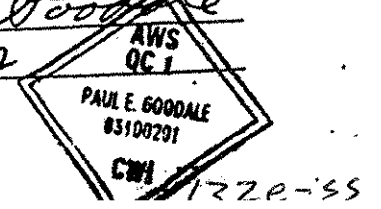
WELDING PROCEDURE

Joint detail B-L2C-S

T1	P
1/2 T01	1/4
12 T02.4	6 mm
1 T01/2	3/8
25.4 T02.1	9.5 mm
1/2 T02	1/2
39.1 T020	12 mm

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. 15a Contractor Casco Bay Steel
 Revision no. _____ Authorized By Paul E. Goodale
 Form III-2 Date 11-20-2002



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