

Casco Bay Steel Structures, Inc.

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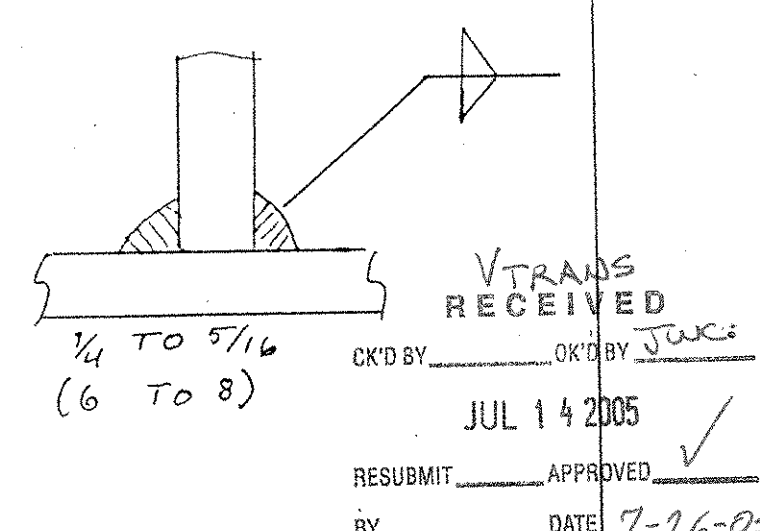
Fax: (207) 282-1179

WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A709/A709M - Gr 36 (250), 50 (345), 50w (345w)
 Welding process Submerged Arc Welding
 Manual or machine Machine
 Position of welding Horizontal (2F)
 Filler metal specification AWS A5-23
 Filler metal classification E802-EWIK-Ni1 Lincoln
 Flux Lincoln 760 Flux with LA-95 Electrode
 Shielding gas NA Flow rate NA
 Single or multiple pass Single - Electrode Ex. 1-3/4 (25.4 ± 1.1)
 Single or multiple arc Single
 Welding current DC EN
 Polarity DC EN
 Welding progression See Joint detail
 Root treatment AWS Spec - wire brush - grind - Blast (Clean area)
 Preheat and interpass temperature To 30 (19) - 50 (10) - 30 (19) to 140 (38) to 200 (20) - 140 (38) to 250 (63) 150 (65)
 Postheat temperature NA
 Heat Input Min 3.0 kJ/in (1.2 kJ/mm) Max 4.7 kJ/in (1.9 kJ/mm) PQR # 4-428 kJ/in (1.7 kJ/mm) Bathel - Vermont
Ar No. 31 (Spec # 1)
Proj # BAF-0241(30) 5/04
CBSS # 270

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Fillet
		Amperes	Volts		
1	3/32	299	31	13 IPAs	2F
		269	29	11	
		70	70	70	
		329	33	15	
2	2.4	Metric			Joint detail
		299	31	380 mm	
		269	29	299	
		70	70	70	
		329	33	381	



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

