

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A709/A709M-Gr 250(A36)-345(CASD)-345W(A50W)
 Welding process Submerged Arc welding - Semi-Auto
 Manual or machine Machine
 Position of welding Fillet weld - 1F - 2F
 Filler metal specification AWS A5-17 - AWS A5-23
 Filler metal classification EBA2-EX1K-N11 Lincoln
 Flux 960 Lincoln Flux - ELECTrade LA-75 Lincoln
 Shielding gas NA Flow rate NA
 Single or multiple pass Single Electrode Ex. 1 2.54
 Single or multiple arc Single
 Welding current Direct
 Polarity DCED
 Welding progression
 Root treatment Wire brush - Grind - blast clean To AWS specification
 Preheat and interpass temperature 3/4 (19) 50° (10°) 3/4 (19) To 1 1/2 (38) 70 (20)
1 1/2 (38) To 2 1/2 (64) 50 (65) 2 1/2 (64) 125 (110)
 Postheat temperature NA
 Heat Input Min 50 KJ/in Max 79 KJ/in PQR 5-72 KJ/in, 2.8 KJ/in
2 KJ/mm 3 KJ/mm

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail
		Amperes	Volts		
3/32	3/32	505	33	14 IPM 356 mm/min	
		454	31	14 I 2	
		70	35	356 ±53	
TRANS RECEIVED OK'D BY: [Signature] DATE: JUL 14 2005 APPROVED BY: [Signature] 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

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 Form III-2

Contractor Casco Bay Steel
 Authorized By Paul E. Goodale
 Date 11-20-2002

