

**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 A 36 Gr 36-50-50w (250-345-345w)  
 Welding process Submerged Arc welding - AUTO (SAW)  
 Manual or machine MACHINE  
 Position of welding FLAT (1sa.2)  
 Filler metal specification AWS A5-17, AWS A5-23 LINCOLN  
 Filler metal classification E802-EXXIK-NiL  
 Flux 960 FLUX-LIACALWELL-LA-55 Electrode  
 Shielding gas NA Flow rate NA OK'D BY JUC  
 Single or multiple pass single JUN 29 2009  
 Single or multiple arc single  
 Welding current Direct REVISIT APPROVED  
 Polarity Reverse Electrode Positive BY WJC DATE 7-8-09  
 Welding progression  
 Root treatment MEET AWS SPECIFICATION  
 Preheat and interpass temperature To 44 (19) 50 (10), 54 (11) 120 (100)  
 Postheat temperature NA  
 Heat Input Min 41.65 Max 65.45 PAR # 1-59.5 ST OF VT AOT  
 SPRINGFIELD - Br # 64 -  
 Proj # BHF 016-204

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JUN 29 2009  
APPROVED  
DATE 7-8-09

**WELDING PROCEDURE**

(Metric)

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
5/32	605	29.5	18	AWS D1.5 Joint detail B-L1-S, B-L1a-S
		544.5 To	27.4 To	
		665.5	31.56	
3.9	605	29.5	457.2	T1: 3/8 (9.5) B-L1-S T1: 3/8 (15.875) B-L1a-S
		544.5 To	27.4 To	
		665.5	31.56	

\* Evidence of C.V.P. is req.

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. 203 Contractor Casco Bay Steel  
 Revision no. \_\_\_\_\_ Authorized By Paul G. Hoodale  
 Form III-2 Date 3/2/00

