

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A36 Gr 36-50-50w (250-345-345w)
 Welding process Submerged Arc Welding - Auto (SAW)
 Manual or machine Machine
 Position of welding Flat (H), Horizontal (HF)
 Filler metal specification AWS A5-17, AWS A5-23
 Filler metal classification E8018-ENiK-Ni1 Lincoln
 Flux 960 Flux - Lincoln Weld - LA-75 Electrode
 Shielding gas NA
 Single or multiple pass Both
 Single or multiple arc Single
 Welding current Direct
 Polarity Reverse Electrode Positive
 Welding progression
 Root treatment Meet AWS specification
 Preheat and interpass temperature To 3/4 (19-50 (100) 3/4 (19) 1 1/2 (38) 70 (160) 1 1/2 (38) To 2 1/2 (63) 150 (65)
 Postheat temperature NA
 Heat Input Min 41.65 Max 65.45 PQR # 1-59.5

APPROVED BY CWC DATE 7-8-09
 JUN 29 2009

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WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail	Filler	
		Amperes	Volts				
5/32	605	29.5	18.5	18.5	IF	5/16 To 1/2 (8 To 12.7)	
		544.5 To 665.5	27.4 To 31.56				15.3 To 20.7
		605	29.5				18.5
3/8	Metric	29.5	457.2	457.2	2F	1/4 To 5/16 (6 To 8) 3/8 To 5/8 (9.5 To 15.9)	
		544.5 To 665.5	27.4 To 31.56				389.6 To 525.8
		605	29.5				457.2

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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 Revision no. _____
 Form III-2

Contractor Casco Bay Steel
 Authorized By Paul E. Woodale
 Date 3/2/00