

Casco Bay Steel Structures, Inc.

75 Spring Hill Road
Saco, Maine 04072

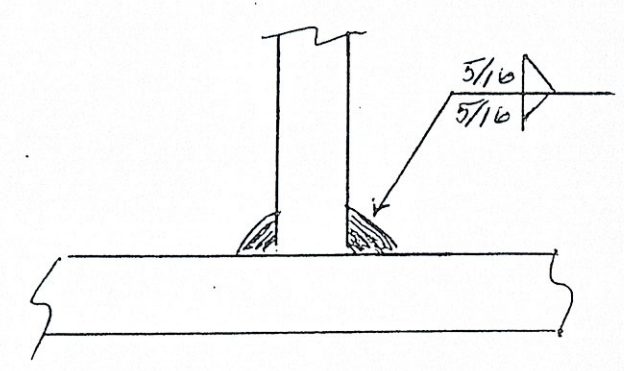
Phone: (207) 282-7360

Fax: (207) 282-117

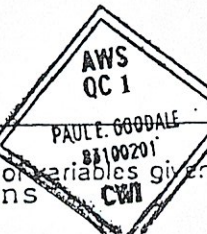
WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A 909/A909M Gr 36(250) - A50(345) - A50W (345)
 Welding process Submerged Arc welding
 Manual or machine Machine
 Position of welding Horizontal (GF)
 Filler metal specification AWS A5-23
 Filler metal classification E80T8-K-Mi Elec. Lincoln
 Flux Lincoln 960 with LAD5 Flow rate NA
 Shielding gas NA
 Single or multiple pass single
 Single or multiple arc single
 Welding current DC
 Polarity DCEN
 Welding progression see Joint Detail
 Root treatment Root clean - wire brush - free of loose scale & moisture
 Preheat and interpass temperature 24-50° 3/4" to 1 1/2" 70°, 1 1/2" to 2 1/2" 150° over 2 1/2" 225°
 Postheat temperature NA
 Heat Input Min 30.3 kJ/in Max 47.6 kJ/in PQR-FCM #9-43.3 kJ/in

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS 5-13
		Amperes	Volts		
		293	32	13 IPM	Joint detail Fillet 
		270	30	11	
	3/32	322	34	14	

TRANS RECEIVED
 OK'D BY JUC OK'D BY JUC
 JUN 29 2009
 RESUBMIT one APPROVED [Signature]
 DATE 7/8/09



This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of conditions given in applicable A.W.S. codes or contract specifications.

Procedure no. 250 Contractor Casco Bay Steel
 Revision no. _____ Authorized By Paul S. Stodab
 Form II-2 Date 12-6-06