

Casco Bay Steel Structures, Inc.

75 Spring Hill Road
Saco, Maine 04072

Phone: (207) 282-7360

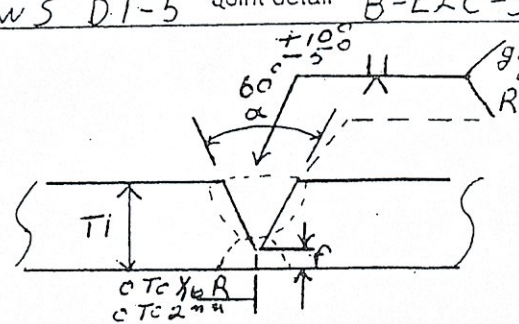
Fax: (207) 282-1171

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709/A709M = Gr. 250 (A36) - 345 (A50) - 345W (A50W)
 Welding process Submerged Arc welding - Semi-AUTO
 Manual or machine machine
 Position of welding Flat (G)
 Filler metal specification AWS A5-17 - AWS A5-23
 Filler metal classification E802-ENi1K-Ni1 Lincoln
 Flux 960 Lincoln Flux - Electrode, LA-95 Lincoln
 Shielding gas Ar Flow rate Ar
 Single or multiple pass Both
 Single or multiple arc Single Electrode Extension 1"±3/4 - 20.4"±20mm
 Welding current Direct
 Polarity DC EP
 Welding progression
 Root treatment Back gauge - Grind to AWS Specification
 Preheat and interpass temperature To 3/4 (19) 50 (60) 3/4 (19) to 1 1/2 (38) - 70 (205) 1 1/2 (38) to 2 1/2 (64) - 150 (6)
 Postheat temperature Ar over 2 1/2 (64) - 225 (110)
 Heat Input Min 50 KJ/in Max 79 KJ/in PQR #5 72RJ/14, 28KJ/mm
 ST OF VT ACT
 Springfield-Br #6
 Proj # BHF C16-204

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
AS REQ	3/32	505	33	14 IPM 356 mm/min
		454	31	14 I2
		70	37	356
		556	37	356

Joint detail B-L2c-S
 AWS D1-5


T1	f
1/2 To 1"	1/4"
1/2 To 3/4"	6 mm
1" To 1 1/2"	3/8"
1 1/2 To 2"	9.5 mm
2 To 3"	12"
3 To 4"	12 mm

VT TRANS RECEIVED
 OK'D BY JUC
 JUN 29 2009
 RESUBMIT BY CWC APPROVED JUC DATE 7-9-09

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. 150 Contractor Casco Bay Steel
 Revision no. _____ Authorized By Paul E. Goodale
 Form III-2 Date 11-20-2002

