

75 Spring Hill Road
Saco, Maine 04072

Fax: (207) 282-1170

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709-Gr36-50-50W / A709M-Gr250-345-345W
 Welding process Submerged Arc welding (SAW)
 Manual or machine Machine
 Position of welding Horizontal (2F)
 Filler metal specification AWS A5-23
 Filler metal classification F8A2-ENILK-Ni1
 Flux Lincoln 960 with LA75 Elec. - Elec Ex.
 Shielding gas NA Flow rate NA
 Single or multiple pass Single
 Single or multiple arc single
 Welding current DC
 Polarity DC EN
 Welding progression See details
 Root treatment Wire brush. area to be free of loose scale, slag, rust and moisture
 Preheat and interpass temperature To 20 (36) 10 (50) 20 (34) To 40 (1 1/2) 20 (90) 40 (1 1/2) To 60 (4) 65 (150)
 Postheat temperature NA
 Heat Input Min 41.1 Max 64.5 P.Q.R-FCM 3A-5B.T K%_m

WELDING PROCEDURE

VERMONT-A.C.T.
 BENNINGTON-RAMA AFD
 BRNO. BLS-N
 PROJ NO. PC-NH-019-1 (51)
 CB SS NO. 408-162

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
		597	29.5	18 IPM
	5/32	567 To 627	27 To 31	16 To 21

5-13
 AWS D1-5
 Joint detail: B-U3C-S1

	T1	S1
Over	10"	
2	2-1.2	1-3/8
2-1.2	3	1-3/4
3	3-5/8	2-1/8
3-5/8	4	2-1/2
4	4-3/4	2-3/4
4-3/4	5-1/2	3
5-1/2	6-1/4	3-3/4

* Back gouge

R=0
 P=1/4 min
 α=β=60°

To find S1 see Table, S2=T1-(S1+A)

VT TRANS RECEIVED

OK'D BY _____ OK'D BY JWC
 OCT 03 2009
 RELEASHT APPROVED ✓
 BY _____ DATE 10/27/09

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. 201
 Revision no. _____
 Contractor Casco Bay Steel
 Authorized By Paul E. Goodale
 Date 12-6-06

