

# Casco Bay Steel Structures, Inc.

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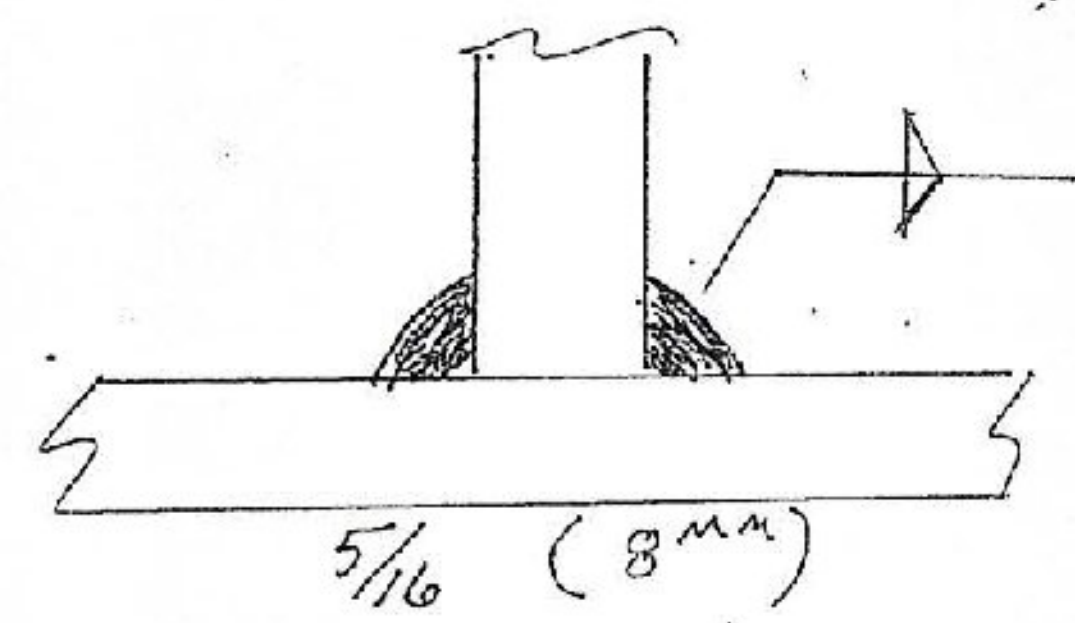
## WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A709/A709M - Gr 50 (345) - Gr 50W (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 E802-E NiK-Nil Lincoln  
 Flux Lincoln 960 Flux with LA95 Elec.  
 Shielding gas NA Flow rate \_\_\_\_\_  
 Single or multiple pass Single  
 Single or multiple arc Single  
 Welding current DC  
 Polarity DCEP  
 Welding progression See Joint Detail  
 Root treatment WIRE BRUSH - area to be free of loose scale - slag - rust & moisture  
 Preheat and interpass temperature To 3/4 (19) 50° (100) - 7/8 (19) To 1 1/2 (38) 70° (20) 1 1/2 (38) To 2 1/8 (63) 150° (65)  
 Postheat temperature NA  
 Heat Input Min 4.1 (16) Max 64.5 (215) P.Q.R. 3A - 58.7 KJ/in (2.3 J/mm) A

RECEIVED  
 OK'D BY \_\_\_\_\_  
 OCT 08 2009  
 APPROVED ✓  
 DATE 10/29/09

### (Metric) WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
1	5/32	597	29.5	18 IPM
		567	27	16
		To	To	To
		627	31	21
1	3.9	597	29.5	457 <sup>mm</sup> / <sub>min</sub>
		567	27	406
		To	To	To
		627	31	533



MAX 420° (216°)

VERMONT-A.O.T.  
 Revvington - Ramp AFD  
 Br NO. B155-N  
 Proj NO. AC-NH-019-1 (51)  
 CRSS NO. 408-1E2  
 FILE

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 Br. ST of V Contractor Casco Bay Steel  
 Revision no. Δ New P.Q.R Authorized By Paul E. Goodale  
 Form III-2 Date 1-24-05