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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709 - Gr 36-50-50W / A709M - Gr 250-345-345W
 Welding process Submerged Arc welding (SAW)
 Manual or machine Machine
 Position of welding Flat
 Filler metal specification AWS A5-23
 Filler metal classification E8A2-ENILK-Ni1
 Flux Lincoln 960 with LA75 Elec. - Elec EX.
 Shielding gas NA Flow rate NA
 Single or multiple pass Both
 Single or multiple arc Single
 Welding current DC
 Polarity DC EP
 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" (3/4) 10 (50), 20" (3/4) To 40 (1 1/2) 20 (70), 40 (1 1/2) To 60 (2 1/2) 65 (150)
 Postheat temperature NA over 60 (2 1/2) 110 (225)
 Heat Input Min 41.1 Max 64.5 P.Q.R-FCM 3A - 5A.7 KJ

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS 5-13 AWS D1-5 Side - 1
		Amperes	Volts		
	5/32	597	29.5	18 IPM	
		567	27	16	
		627	31	21	
		VTRANS RECEIVED CK'D BY _____ OK'D BY <u>JWC</u> OCT 08 2009 RECEIVED _____ APPROVED <u>✓</u> BY _____ DATE <u>10/27/09</u>		Joint detail <u>B-L2C-S</u> T1 P 1/2 To 1" 1/4 min over 1" To 1 1/2 3/8 min over 1 1/2 To 2 1/2 min Backgouge side 2 Max heat 420 F	

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. 202
 Revision no. 1-Root 0E
 Form III-2

Contractor Casco Bay Steel
 Authorized By Paul E. [Signature]
 Date 12-6-06

