

CASCO BAY STEEL STRUCTURES, INC.

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Saco, Maine 04072

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A709/A709M Gr36(250) - A50(345) - A50W(345)
 Welding process Submerged Arc welding
 Manual or machine Machine
 Position of welding Horizontal (2F)
 Filler metal specification AWS A5-23
 Filler metal classification E8A2-EMILK-Ni1 Lincoln
 Flux Lincoln 960 with LAN5 Elec.
 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 Joint Detail
 Root treatment Blast clean - wire brush - free of loose scale & moisture
 Preheat and interpass temperature 3/4"-50°F, 3/4" to 1/2"-70°F, 1/2" to 2/2"-150°F over 2/2"-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

VERMONT-A.O.T.
Bennington - Ramp AFD
Br. NO. B15-S-N
Proj. NO. AC-NH-019-1(51)
CLASS. NO. 408-1F2
 Joint detail Filet

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
		293	32	13 IPM
		270	30	11
		TO	TO	TO
	3/32	322	34	14

AWS 5-13
 AWS D1-5
 Joint detail Filet

VTRANS RECEIVED
 OK'D BY _____ OK'D BY JWC
 OCT 09 2009
 REQUEST BY _____ APPROVED ✓
 DATE 10/27/09

AWS QC 1
 PAUL E. GOODALE
 88100201
 CWI

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

Procedure no. 250
 Revision no. _____
 Contractor Casco Bay Steel
 Authorized By Paul E. Goodale
 Date 12-6-06