

WELDING PROCEDURE SPECIFICATION

Material ASTM Gr 50-50w  
 Welding process Submerged Arc welding Power Wave  
 Manual or machine Machine  
 Position of welding Flat + Horizontal  
 Filler metal specification A5-23  
 Filler metal classification F8A2-EN11-N11-H8  
 Flux Hycolm 960-Elec. LA 75  
 Shielding gas NA Flow rate NA  
 Single or multiple pass Single - multiple  
 Single or multiple arc Single  
 Welding current Alternating  
 Polarity AC  
 Welding progression See Details  
 Root treatment Grind - wire brush - Area Free of Slag - RUST - MOISTURE  
 Preheat and interpass temperature See Table  
 Postheat temperature NA  
 Heat Input Min 47.1 kJ/in Max 74.0 kJ/in PQR - PWT - 67.3 kJ/in

Minimum Preheat and Interpass Temperature, °C [°F]

Welding Process (Base Metal)	Thickness of Thickest Part at Point of Welding, mm [in]			
	To 20 mm [3/4 in] Incl.	Over 20 mm [3/4 in] to 40 mm [1-1/2 in] Incl.	Over 40 mm [1-1/2 in] to 65 mm [2-1/2 in] Incl.	Over 65 mm [2-1/2 in]
SAW; GMAW; FCAW; SMAW (M270M [M270] [A 709M (A 709)] Gr. 250 [36], 345 [50], 345W [50W], HPS 345W [HPS 50W])	10 [50]	20 [70]	65 [150]	110 [225]
SAW; GMAW; FCAW; SMAW (M270M [M270] [A 709M (A 709)] Gr. HPS 485W [HPS 70W], 690 [100], 690W [100W])	10 [50]	50 [125]	80 [175]	110 [225]

VT - AOT, HYDE PARK  
 Br. NO. 42  
 Proj. NO. STP-CUIV C26  
 CLASS NO 566

WELDING PROCEDURE

Max Interpass - 460°F

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
AS Reg.	5/32	827	38	28 IPM
		744	35	24
		To 910	To 41	To 32

see 5.13  
 A.W.S. D1-5 Joint detail AL2c-s

T1	A	R
1/2" T1"	1/4" A"	0
1/2" T1"	3/8" A"	0
1/2" T1"	1/2" A"	0

Vermont Agency of Transportation  
**RECEIVED**  
 CK'D BY JWC OK'D BY JWC  
 March 17, 2014  
 RESUBMIT Approved  
 BY DATE 03/24/2014

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. PW202B ST OF VT  
 Revision no. \_\_\_\_\_

Contractor Casco Bay Steel  
 Authorized By Paul E. Woodale  
 Date April 13 2012