

CASCO BAY STEEL STRUCTURES, INC.

WELDING PROCEDURE SPECIFICATION

Material specification ASTM GR 50 + 50W
 Welding process Submerged ARC welding
 Manual or machine Machine
 Position of welding Flat + Horizontal
 Filler metal specification AWS A5-23
 Filler metal classification E8A2-ENiK-Ni1-H8
 Flux Lincoln 960-Elec LA-75
 Shielding gas NA Flow rate NA
 Single or multiple pass Single + Multiple
 Single or multiple arc Single
 Welding current DC
 Polarity DC EP
 Welding progression See Detail
 Root treatment Grind-wire Brush-Area Free of slag-RUST & Moisture
 Preheat and interpass temperature See Table
 Postheat temperature NA
 Heat Input Min 5.13 KJ/in Max 73.4 KJ/in PQR-1 = 64.1 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]] Or. 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]] Or. HPS 485W [HPS 70W], 690 [100], 690W [100W])	10 [50]	50 [125]	80 [175]	110 [225]

VT - HOT HYDE PARK
 Br. NO. 42
 Proj. No. STP-CUIV (26)
 CLASS NO. 565

WELDING PROCEDURE

Max InterPass - 430

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
5 32	5	620	31	18 IPM
		570	29	15
		TO	TO	TO
		650	33	20

sec 5.13
 AWS D1-5 Joint detail BL2c-S

T1	F	R
1/2" x 1/2"	1/8" Min	0
1/2" x 1/2"	3/8" Min	0
1/2" x 1/2"	1/2" Min	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. 202^B ST OF VT
 Revision no. _____

Contractor Casco Bay Steel
 Authorized By Paul E. [Signature]
 April 13-2012