

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 51.3 kJ/in Max 79.4 kJ/in PQR-1 = 64.1 kJ/in

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

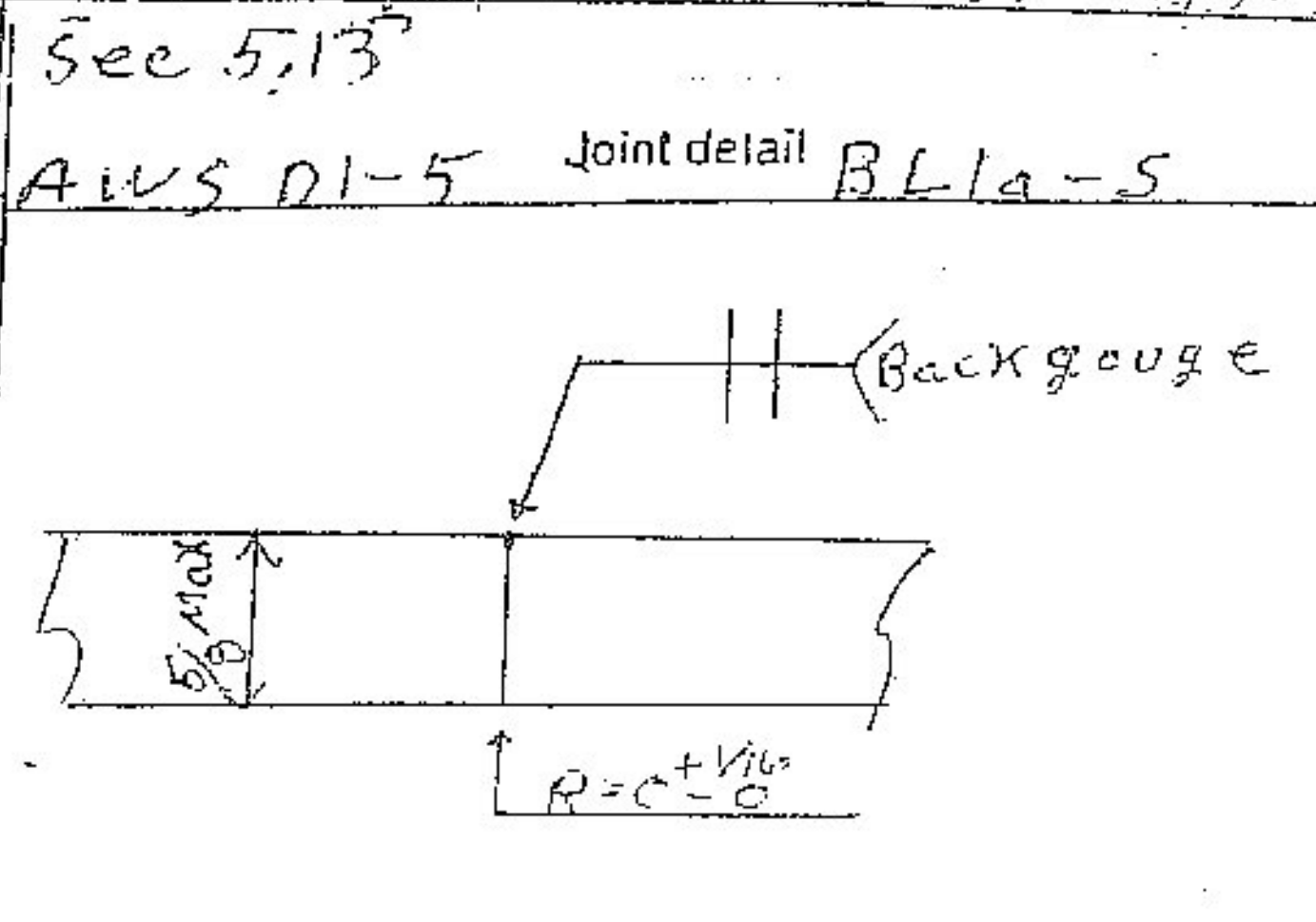
Welding Process (Base Metal)	Thickness of Thickest Part at Point of Welding, mm [in]			
	To 20 mm [3/4 in] incl.	Over 20 mm [3/4 in] to 40 mm [1-1/2 in] incl.	Over 40 mm [1-1/2 in] to 65 mm [2-1/2 in] incl.	Over 65 mm [2-1/2 in]
SAW; GMAW; FCAW; SMAW (M270M [M270] [A 709M (A 709)] Gr. 250 [36], 345 [50], 345W [50W], HPS 345W [HPS 30W])	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 - ROT, HYDE PARK
 Pr. NO. 42
 PROJ NO. STP-CUIV C26
 CLASS NO 865

WELDING PROCEDURE

Max Interpass - 430°K

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



Vermont Agency of Transportation
RECEIVED
 CK'D BY JWC OK'D BY JWC
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 Approved

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. 202A ST OF VT

Contractor Casco Bay Steel

Revision no. _____

Authorized By Paul E. [Signature]

April 13-2012