

Casco Bay Steel Structures, Inc.

WELDING PROCEDURE SPECIFICATION

Material specification ASTM-Gr 50-50w NOTE-1
 Welding process Submerged ARC welding
 Manual or machine Machine
 Position of welding Flat - Horizontal
 Filler metal specification AWS A5-23
 Filler metal classification F8A2-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 DCEN
 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 40.9 KJ/in Max 64.2 KJ/in PQR #2-58.4 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 [P00], 690W [100W])	10 [50]	50 [125]	80 [175]	110 [225]

VT - HOT HYDE PARK
 BR. NO. 42
 PROJ NO. STP-CUIV Co.
 CLASS NO. 865

WELDING PROCEDURE

Max. Interpass - 450°

Pass no.	Electrode size	Welding current		Travel speed	Sec 5-13 AWS D1-5 Joint detail FillerT
		Amperes	Volts		
		365	32	12 IPM	
	3/32	320	30	11	
		TO	TO	TO	
		350	33	14	

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CK'D BY JWC OK'D BY JWC

March 17, 2014

RESUBMIT Approved

BY DATE 03/24/2014

NOTE-1

use for welding Gr 50 to C4HPS

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

250 ST OF VT

Casco Bay Steel
 for E. Stoddard
 April 13, 2012