

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 E802-ENiK-Ni1-118
 Flux Lincoln 960 - Elec-LA 75 DEC 1 9 2013
 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 P.Q.R #2 - 58.4 KJ/in

VERMONT
 Received
 OK'D BY
 JWC
 Resubmit
 BY
 APPROVED
 DATE
 12/17/13

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; CMAW; 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; CMAW; 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]

VERMONT AOT
 CAVENDISH VT RTE 131
 OVER TWENTYMILE STREAM
 PROJ # ER BR F 0146 (13)
 CBSS Job. No. 541

WELDING PROCEDURE

Max. Interpass - 450°

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
		365	32	12 IPM
	3/32	320	30	11
		70	70	70
		350	33	14

Sec 5-13
 AWS D1-5 Joint detail Fillet

NOTE-1
 use for welding Gr 50-50W to Gr HPS 70

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. 250 ST OF VT

Contractor Casco Bay Steel

Revision no. _____

Authorized By Paul J. Stanchale

Date April 13 - 2012