

Casco Bay Steel Structures Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 36 Gr 36-50-50w (250-345-345w)
 Welding process Submerged Arc welding - AUTO (SAW)
 Manual or machine Machine
 Position of welding FLAT (I.S.A.C.)
 Filler metal specification AWS A5-17, AWS A5-23
 Filler metal classification E802-ENiLK-MiI LINCOLN
 Flux 960 FLUX-Lincoln Weld - LA-75 Electrode
 Shielding gas None Flow rate NA
 Single or multiple pass both
 Single or multiple arc SINGLE
 Welding current Direct
 Polarity Reverse Electrode Positive
 Welding progression _____
 Root treatment MEET AWS SPECIFICATION
 Preheat and interpass temperature To 3/4 (19) 50°F (10°), 3/4 (19) 1/2 (88) - 70 (20°)
 Postheat temperature NA
 Heat Input Min 41.65 Max 65.45 PQR # 1-59.5

Vtrans
Received
OK'd BY JWC

DEC 2 2013

RECORDED BY APPROVED DATE 12/17/13

VERMONT AOT

CAVENDISH Vt RTE 131

OVER TWENTYMILE STREAM

Proj # ER BR.F 0146 (13)

C.B.S.S. Job. No. 541

WELDING PROCEDURE

(Metric)

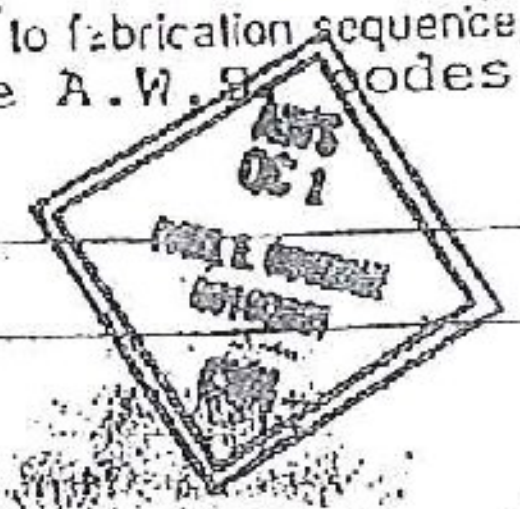
Pass no.	Electrode size	Welding current		Travel speed	AWS D1-5 joint detail B-L1-S, B-L1a-S
		Amperes	Volts		
	5/32	605	29.5	18	
		544.5	27.4	15.3	
		To 665.5	To 31.56	To 20.7	
	3.9	605	29.5	457.2	T1: 3/8 (9.5) B-L1-S T1: 5/8 (15.875) B-L1a-S *Evidence of C.V.P. 15 req.
		544.5	27.4	388.6	
		To 665.5	To 31.56	To 525.8	

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. 203

Revision no. _____

Form III-2



Contractor Casco Bay Steel
 Authorized By Paul E. Hoodale
 Date 3/2/12