

WELDING PROCEDURE SPECIFICATION

Material specification ASTM - Gr 50-50w
 Welding process Submerged Arc welding Power source Power Wave
 Manual or machine Machine Vitals received JAC
 Position of welding Flat + Horizontal OK'D BY
 Filler metal specification A5-23
 Filler metal classification E8A2-ENi1-Ni1-H8 DEC 12 2013
 Flux Lincoln 960 - Elec. LA 75
 Shielding gas NA Flow rate NA
 Single or multiple pass Single Resubmit BY DATE 12/17/13
 Single or multiple arc Single
 Welding current ALTERNATING
 Polarity AC
 Welding progression See Details
 Root treatment Grind - wire brush - Area Free of Slag - RUST - MOISTURE
 Preheat and interpass temperature See Table
 Postheat temperature NA
 Heat Input Min 47.1 kJ/in Max 74.0 kJ/in PQR - PW1 - 67.3 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)] Cr. 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)] Cr. 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 BRP 0146 (13)
 CBSS Job. No. 541

WELDING PROCEDURE

Max Int-erpass: 480°F

Pass no.	Electrode size	Welding current		Travel speed
		Ampères	Volts	
AS Req.	5/32	827	38	28 IPM
		744	35	24
		To	To	To
		910	41	32

See 5.13
 AWS D1-5 Joint detail BL1a-5

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. PW 2020 - ST of VT

Contractor Casco Bay Steel

Revision no. _____

Authorized By Paul E. Fordale

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