Casco Bay Steel Structures, Inc.

WELDING PROCEDURE SPECIFICATION

VTrans Received JWC
CKD OK'd BY

DEC 12 2013

Resubmit APPROVED
BY DATE 12/17/13

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 F8A2-EN1K-Ni1-H8
Flux Lincoln 960-Elec LA-75
Shielding gas N.A. Flow rate N.A
Single or multiple pass Single / Multiple
Single or multiple arc Single
Welding current D.C.
Polarity DCEP
Welding progression See Detail
Root treatment Grind-Wire Brush-Area Free of Slag-Rust & Moisture
Preheat and interpass temperature See Table
Posfheat temperature N/A
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]

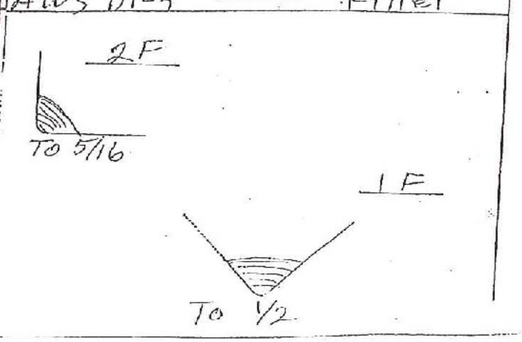
Welding Process (Base Metal)	Thickness of Thickest Part at Point of Welding, mm (in): To 20 mm [3/4 in] Incl.	Over 20 mm [3/4 in] to 40 mm [1-1/2 in] Incl.	Over 40 mm [1-1/2 in] to 65 mm [2-1/2 in] Incl.	Over 65 mm [2-1/2 in]
SAW; GMAW; FCAW; SMAW (M270M [M270] [A 709M (A 709)] Gr. 250 [36], 345 [50], 345W [50W], HPS 345W (HPS 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 [100], 690W [100W])*	10 [50]	50 [125]	80 [175]	110 [225]

VERMONT AOT
CAVENDISH VT RTE 131
OVER TWENTYMILE STREAM
PROJ # ER BRF 0146 (13)
CBSS JOB NO. 541

WELDING PROCEDURE

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

See 5.13
AWS D1-5 Joint detail Fillet



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. 201 - ST OF VT. / Contractor Casco Bay Steel
Revision no. Authorized By Paul E. Gaudette
Date April-13-2012