Casco Bay Steel Structures

One Wallace Avenue, South Portland ME 04106

AWS - Welding Procedure Specification (WPS)

WeldOffice WPS

WPS record number	201 Revision 1	Qualified to	AWS D1.5
Date	4/24/2014	Company name	Casco Bay Steel Structures
Supporting PQR(s) Reference docs.	SAW DC + FCM 2-21-14 - Rev 1		

Scope	Fillet, no PWHT (As-welded)
Joint	Joint details for this welding procedure specification in: JOINTS section of this WPS

BASE METALS

Type	Gr50/Gr50W	P-no.	Grp-no. -
Welded to	Gr50/Gr50W	P-no.	Grp-no. -
Backing:	None	P-no.	Grp-no. -
Retainers			
Notes	All A709 steels with 50 ksi or less are also qualified		

THICKNESS RANGE QUALIFIED (in.)

	As-welded Min.	As-welded Max.	With PWHT Min.	With PWHT Max.
Complete pen.	-	-	-	-
Impact tested	-	-	-	-
Partial pen.	-	-	-	-
Fillet welds	1/8	All	-	-

DIAMETER RANGE QUALIFIED (in.)

	As-welded Min.	As-welded Max.	With PWHT Min.	With PWHT Max.
			-	-

FILLER METALS

	SFA	Classification	F-no.	A-no.	Chemical analysis or Trade name	THICKNESS RANGE QUALIFIED (in.) As-welded Min.	As-welded Max.	With PWHT Min.	With PWHT Max.
SAW	5.23	ENi1K	6		Lincolnweld LA-75	1/8	All	-	-
Flux	-	-	-	-	- Lincolnweld 960	- None -			
Sup. filler	-	-	-	-	-	- None -			

WELDING PROCEDURE

Welding process		SAW
Type		Machine
Minimum preheat/interpass temperature	(°F)	See Backpage
Maximum interpass temperature	(°F)	490
Filler metal size	(in.)	5/32
Layer number		
Position		F,H
Current/polarity		DCEP
Amperes		604
Volts		29.5
Travel speed	(in./min)	17.1
Maximum heat input	(kJ/in.)	62.5193
Wire feed type		Hot wire
Wire feed speed	(in./min)	N/A
String or weave		Stringer
C.T.W.D	(in.)	
Multi/Single pass per side		Single or Multiple passes
Multiple or single layer		Single or Multiple layer
Oscillation		None
Multi/single electrode		Single electrode
Electrode angle	(deg.)	As needed
Maximum pass thickness	(in.)	See Backpage
Weld deposit chemistry		F8A2-ENi1K-Ni1-H8
Notes		

Vermont Agency of Transportation

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CK'D BY _____ OK'D BY Rob Young

April 4, 2016

RESUBMIT NO Approved

BY Rob Young DATE 04/08/2016