



Casco Bay Steel Structures
 One Wallace Avenue, South Portland ME 04106
AWS - Welding Procedure Specification (WPS)
 WeldOffice WPS

WPS record number	203	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	Groove, no PWHT (As-welded)
Joint	Joint details for this welding procedure specification in: JOINTS section of this WPS

BASE METALS				THICKNESS RANGE QUALIFIED (in.)				
Type	Gr50/Gr50W	P-no.	Grp-no.	As-welded		With PWHT		
Welded to	Gr50/Gr50W	P-no.	Grp-no.	Min.	Max.	Min.	Max.	
Backing:	None	P-no.	Grp-no.	Complete pen.	over 1/2	2	-	-
Retainers				Impact tested	-	-	-	-
Notes	All A709 steels with 50 ksi or less are also qualified			Partial pen.	NO	-	-	-
				Fillet welds	-	-	-	-

FILLER METALS				DIAMETER RANGE QUALIFIED (in.)			
SFA	Classification	F-no.	A-no.	As-welded		With PWHT	
				Min.	Max.	Min.	Max.
SAW	ENi1K	6		over 1/2	2	-	-
Flux	F8A2	6		- Required - - None -			
Sup. filler	-	-	-				

WELDING PROCEDURE				THICKNESS RANGE QUALIFIED (in.)				
Welding process	SFA	Classification	F-no.	A-no.	As-welded		With PWHT	
					Min.	Max.	Min.	Max.
Type	5.23	ENi1K	6		over 1/2	2	-	-
Minimum preheat/interpass temperature (°F)					- Required - - None -			
Maximum interpass temperature (°F)								
Maximum heat input (kJ/in.)								
Flux from recrush. slag	No							

Welding process	SAW
Type	Machine
Minimum preheat/interpass temperature (°F)	See Backpage
Maximum interpass temperature (°F)	490
Flux from recrush. slag	5/32
Layer number	
Position	F
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.)	
Weld deposit chemistry	F8A2-ENi1K-Ni1-H8
Notes	

Vermont Agency of Transportation
RECEIVED
 CK'D BY _____ OK'D BY Rob Young
 April 4, 2016
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 BY Rob Young DATE 04/08/2016