



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

WPS record number	250	Revision	Qualified to	AWS D1.5
Date	6/10/2014		Company name	Casco Bay Steel Structures
Supporting PQR(s)	SAW FCM 3/32 DC- 5/7/14			
Reference docs.				

Scope	Fillet, no PWHT (As-welded), impact testing
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:	Yes	P-no.	Grp-no.	Complete pen.	-	-	-
Retainers	All A709 with 50 ksi or less are also qualified			Impact tested	0.625	no max.	-
Notes				Partial pen.	-	-	-
				Fillet welds	no min.	no max.	-

FILLER METALS				DIAMETER RANGE QUALIFIED (in.)			
SFA	Classification	F-no.	A-no.	As-welded		With PWHT	
				Min.	Max.	Min.	Max.
SAW	EN1K	6		N/A	N/A	-	-

THICKNESS RANGE QUALIFIED (in.)							
SFA	Classification	F-no.	A-no.	As-welded		With PWHT	
				Min.	Max.	Min.	Max.
SAW	EN1K	6		0.125	no max.	-	-
Flux	F8A2					- Required -	-
Sup. filler						- Required -	
Flux type	No						
Flux from recrush. slag							
Suppl. filler metal vol. (ft ³)	N/A						

WELDING PROCEDURE	
Welding process	SAW
Type	Machine
Minimum preheat/interpass temperature (°F)	See Back Page
Maximum interpass temperature (°F)	400
Filler metal size (in.)	3/32
Layer number	
Position	F,H
Current/polarity	DCEN (straight polarity)
Amperes	363.3
Volts	31.6
Travel speed (in./min)	12.8
Maximum heat input (kJ/in.)	53.8138
Wire feed type	Cold 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.)	Varies
Maximum pass thickness (in.)	See Back Page
Weld deposit chemistry	F8A2-EN1K-Ni1-H8
Notes	

Vermont Agency of Transportation
RECEIVED
 OK'D BY _____ OK'D BY Rob Young
 April 4, 2016
 RESUBMIT NO Approved
 BY Rob Young DATE 04/08/2016