



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

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

| | |
|-------|--|
| Scope | Fillet, 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. | - | - | - | - |
| Retainers | All A709 steels with 50 ksi or less are also qualified | | | | | | |
| Notes | | | | | | | |

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

| FILLER METALS | | | | | | THICKNESS RANGE QUALIFIED (in.) | | | |
|---------------|----------------|-------|-------|---------------------------------|-----------|---------------------------------|-----------|------|--|
| SFA | Classification | F-no. | A-no. | Chemical analysis or Trade name | As-welded | | With PWHT | | |
| | | | | | Min. | Max. | Min. | 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 | | 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
RECEIVED
 CK'D BY R. Foster OK'D BY R. Foster
 March 8, 2017
 RESUBMIT No Approved
 BY Kristin Higgins DATE 3/10/2017

CBSS 696 RT 110 over 1st Branch White River
 Br #9 Proj BHF 0169(9)
 CBSS 697 RT 110 over South Washington Brook
 Br #11 Proj BHF 169(10)
 Chelsea, VT