



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

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

DIAMETER RANGE QUALIFIED (in.)

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

FILLER METALS

	SFA	Classification	F-no.	A-no.	Chemical analysis or Trade name	THICKNESS RANGE QUALIFIED (in.)			
						As-welded		With PWHT	
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

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CK'D BY _____ OK'D BY RSF

May 7, 2017

RESUBMIT No **Approved**

BY C. Carlson **DATE** 05/09/2017