



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

WPS record number	203	Revision	2	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				THICKNESS RANGE QUALIFIED (in.)			
SFA	Classification	F-no.	A-no.	As-welded		With PWHT	
				Min.	Max.	Min.	Max.
SAW	EN1K	6		over 1/2	2	-	-
Flux	F8A2	6		- Required - - None -			
Sup. filler	-	-	-				

WELDING PROCEDURE			
Parameter	Value	Units	Notes
Welding process	SAW		
Type	Machine		
Minimum preheat/interpass temperature	See Backpage	(°F)	
Maximum interpass temperature	490	(°F)	
Filler metal size	5/32	(in.)	
Layer number			
Position	F		
Current/polarity	DCEP		
Amperes	604		
Volts	29.5		
Travel speed	17.1	(in./min)	
Maximum heat input	62.5193	(kJ/in.)	
Wire feed type	Hot wire		
Wire feed speed	N/A	(in./min)	
String or weave	Stringer		
C.T.V.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	As needed	(deg.)	
Maximum pass thickness		(in.)	
Weld deposit chemistry	F8A2-EN1K-Ni1-H8		
Notes			

Vermont Agency of Transportation
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 May 7, 2017
 RESUBMIT No Approved _____
 BY C. Carlson DATE 05/09/2017