



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

WPS record number	204	Revision 2	Qualified to	AWS D1.5
Date	4/22/2014	4.14.17	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

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			

	As-welded		With PWHT	
	Min.	Max.	Min.	Max.
Complete pen.	over 2	Unlimited	-	-
Impact tested	-	-	-	-
Partial pen.	NO	-	-	-
Fillet welds	-	-	-	-

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	As-welded		With PWHT	
						Min.	Max.	Min.	Max.
SAW	5.23	ENi1K	6		Lincolnweld LA-75	over 2	Unlimited	-	-
Flux	5.23	F8A2	6		Lincolnweld 960			- Required -	
Sup. filler	-	-	-	-	-			- None -	
Flux type									
Flux from recrush. slag	No								

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	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.V.D (in.)	
Multi/Single pass per side	Multiple passes
Multiple or single layer	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

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CK'D BY _____ OK'D BY RSF

May 7, 2017

RESUBMIT No **Approved**

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