



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

WPS record number	250	Revision	1	Qualified to	AWS D1.5
Date	6/10/2014	Company name	Casco Bay Steel Structures		
Supporting PQR(s) Reference docs.	SAW FCM 3/32 DC- 5/7/14				

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:	none	P-no.	Grp-no.	-	-	-	-
Retainers							
Notes	All A709 with 50 ksi or less are also qualified						

Complete pen.	-	-	-	-
Impact tested	-	-	-	-
Partial pen.	-	-	-	-
Fillet welds	1/8	no max.	-	-

DIAMETER RANGE QUALIFIED (in.)			
As-welded		With PWHT	
Min.	Max.	Min.	Max.
N/A	N/A	-	-

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		LincolnElectric LA-75	1/8	no max.	-	-
Flux Sup. filler	5.23	F8A2			LincolnElectric Lincolnweld960			- Required -	- Required -
Flux type									
Flux from recrush. slag	No								
Suppl. filler metal vol. (ft <sup>3</sup> )	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	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-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