

Casco Bay Steel Structures, Inc.

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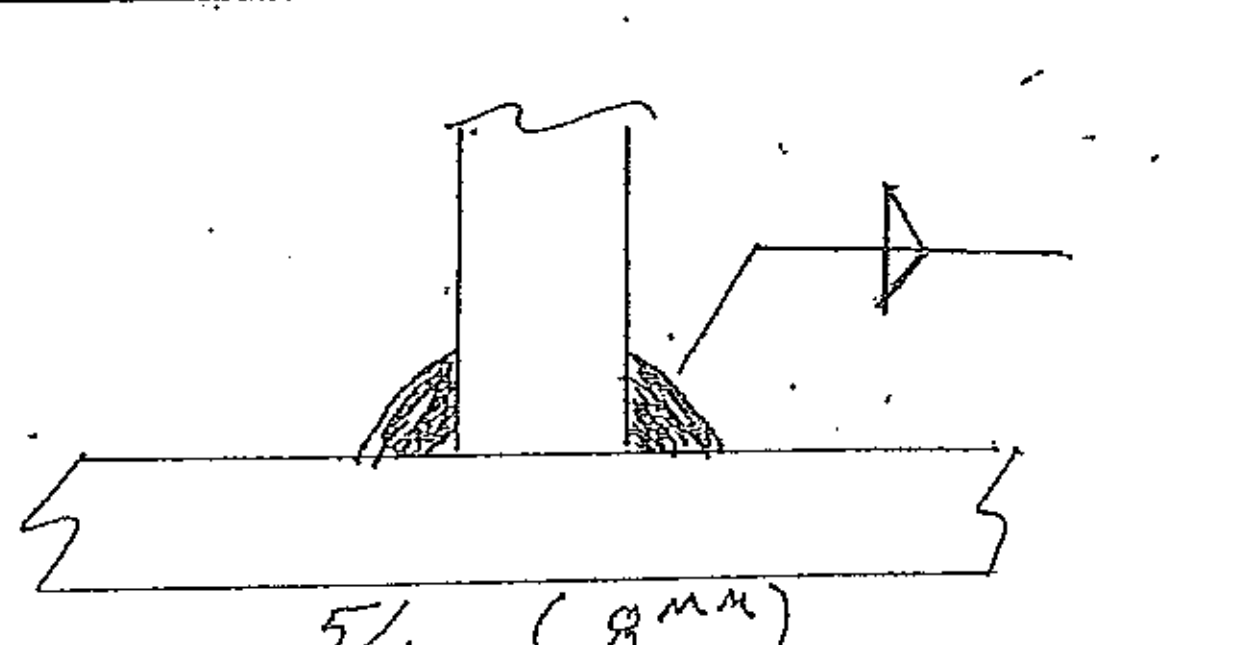
WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A709/A709M - Gr 50 (345) - Gr 50W (345w)  
 Welding process Submerged Arc welding SAW  
 Manual or machine Machine VIRANS  
 Position of welding Horizontal (2F) RECEIVED  
 Filler metal specification AWS A5-23  
 Filler metal classification E802-ENiK-NiL Lincoln OK'D BY JWC  
 Flux Lincoln 960 Flux with LA95 Elec. SEP 21 2009  
 Shielding gas NA Flow rate \_\_\_\_\_  
 Single or multiple pass Single REQUEST APPROVED ✓  
 Single or multiple arc Single BY DATE 9/21/09  
 Welding current DC  
 Polarity DCEP  
 Welding progression See Joint Detail  
 Root treatment WIRE BRUSH - area to be free of loose scale - slag - rust & moisture  
 Preheat and interpass temperature To 3/4 (19) 50° (109) - 3/4 (19) To 1 1/2 (38) 70° (209) 1 1/2 (38) To 2 1/2 (63) 150° (66)  
 Postheat temperature NA over 2 1/2 (63) 225° (110°)  
 Heat Input Min 41.1 (1.6) Max: 64.5 (2.5) P.Q.R. 3A-58.7 kJ/in (2.2 kJ/mm) Δ

WELDING PROCEDURE

(Metric)

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
1	5/32	597	29.5	18 IPM
		567	27	16
		To	To	To
		627	31	21
1	3.9	597	29.5	457 <sup>mm</sup> / <sub>min</sub>
		567	27	406
		To	To	To
		627	31	533

AWS D1.5 Joint detail: CSSS NO 421  
  
 MAX 420° (216°)

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in applicable A.W.S. codes or contract specifications

Procedure no. 201 Br. ST of V  
 Revision no. A New P.Q.R

Contractor Casco Bay Steel  
 Authorized By Paul E. Goodale  
 Date 1-24-05