

75 Spring Hill Road
Saco, Maine 04072

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Phone: (207) 282-7360

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 709 Gr 250-345-345W
 Welding process Submerged Arc Welding (SAW)
 Manual or machine Machine
 Position of welding Flat 1F - Horizontal 2F
 Filler metal specification AWS A5-23
 Filler metal classification Lincoln LA 75 FBAZ-EM11-M1
 Flux Lincoln 960 Elec EX 1/8 ± 3/4
 Shielding gas NA Flow rate NA
 Single or multiple pass single and multiple pass
 Single or multiple arc single
 Welding current DC
 Polarity D.C.E.N
 Welding progression See joint details
 Root treatment To meet AWS specification
 Preheat and interpass temperature To 3/4-50, +3/4 to 1/2-70, 1/2 to 2/2-130 over 2 1/2 225
 Postheat temperature NA
 Heat Input Min 30 KJ/in Max 47.1 KJ/in PQR-FCM #9 4219 KIT/11/06

WELDING PROCEDURE

VT-A.C.T.
 Marietta-Middlesex
 Proj No 0284(14)
 AWS D1-5 Joint detail
 Class No 421

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
1	3/32	293	32	13 IPM
		264	80	11
		To	To	To
		822	34	15

VTRANS RECEIVED
 OK'D BY _____ ON'D BY JWC
 SEP 21 2008
 RESUBMITTED BY _____ APPROVED BY _____
 DATE 9/21/09

AWS QC 1
 PAUL E. GOODALE
 B3109201

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. 250
 Revision no. 1 new PQR
 Form III-2

Contractor Casco Bay Steel
 Authorized By Paul E. Goodale
 Date 11-1-06