

**Casco Bay Steel Structures, Inc.**

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Saco, Maine 04072

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**WELDING PROCEDURE SPECIFICATION**

Material specification ASTM-A709/A709M Gr36(250) - A50(345) - A50W(345)  
 Welding process Submerged Arc welding  
 Manual or machine Machine  
 Position of welding Horizontal (2F)  
 Filler metal specification AWS A5-23  
 Filler metal classification E8A2-EMiK-Ni1 Lincoln  
 Flux Lincoln 960 with LA75 Elec.  
 Shielding gas NA Flow rate NA  
 Single or multiple pass single  
 Single or multiple arc single  
 Welding current DC  
 Polarity DC EP  
 Welding progression see Joint Detail  
 Root treatment Blast clean - wire brush - free of loose scale & moisture  
 Preheat and interpass temperature 3/4-50°F, 3/4 to 1/2-70°F, 1 1/2 to 2 1/2-150°F over 2 1/2-225  
 Postheat temperature NA  
 Heat Input Min 30.3 kJ/in Max 47.6 kJ/in PQR-FCM #9-43.3 kJ/in

**WELDING PROCEDURE**

VT-A.C.T.

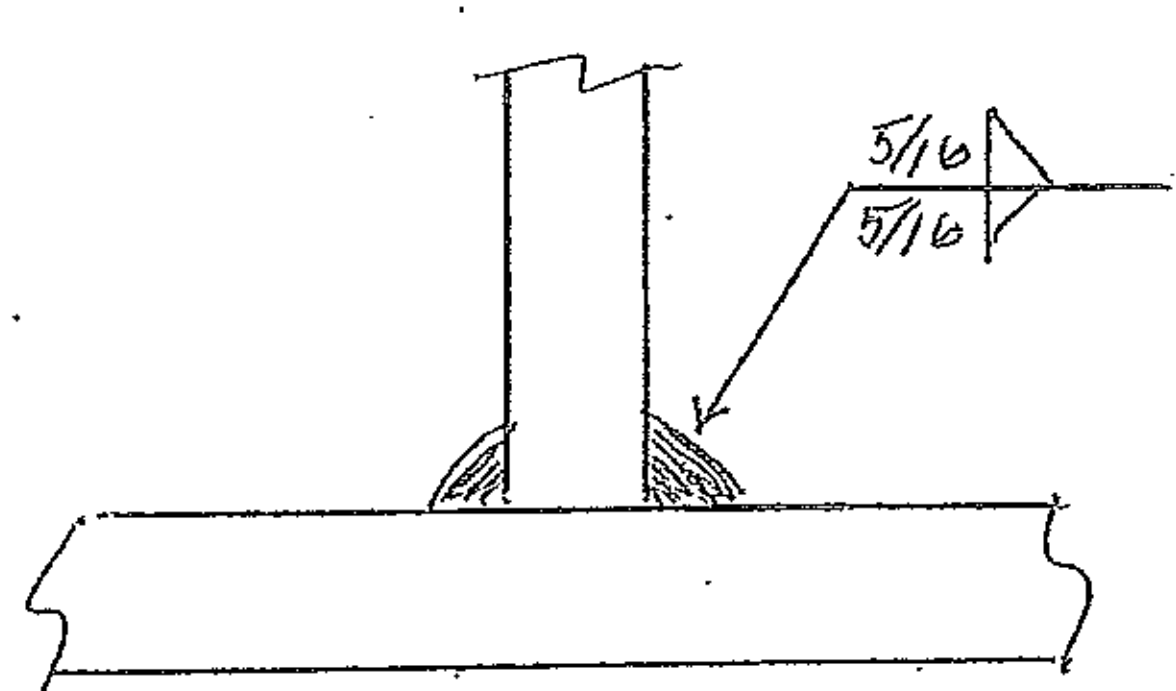
Moretown-Middle:

Project 0284(14)

CRSS No 44

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
		293	32	13 IPM
		270	30	11
		TO	TO	TO
	3/32	322	34	14

AWS 5-13  
 AWS D1-5 Joint detail



VTRANS RECEIVED  
 OK'D BY \_\_\_\_\_ OK'D BY JWC  
 SEP 21 2009  
 REQUESTED \_\_\_\_\_ APPROVED \_\_\_\_\_  
 BY \_\_\_\_\_ DATE 9/21/09

AWS QC 1  
 PAUL E. GOODALE  
 02100201  
 CWI

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

Contractor Casco Bay Steel

Revision no. \_\_\_\_\_

Authorized By Paul E. Goodale

Date 12-6-06