

CASCO Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709 - Gr 36-50-50W / A709M - Gr 250-345-345W
 Welding process Submerged Arc welding (SAW)
 Manual or machine Machine
 Position of welding Flat
 Filler metal specification AWS A5-23
 Filler metal classification E8A2-EMILK-Ni1
 Flux Lincoln 960 with LA75 Elec. - Elec EX-
 Shielding gas NA Flow rate NA
 Single or multiple pass Both
 Single or multiple arc Single
 Welding current DC
 Polarity DC EP
 Welding progression See details
 Root treatment wire brush area to be free of loose scale, slag, rust and moisture
 Preheat and interpass temperature To 20" (34) 10 (30), 20" (34) To 40 (1 1/2) 20 (70), 40 (1 1/2) To 60 (2 1/2) 65 (150)
 Postheat temperature NA over 60 (2 1/2) 110 (225)
 Heat Input Min 41.1 Max 64.5 P.Q.R-FCM 3A - 5 B.T K J.m

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS-5-13 AWS D1-5 Joint detail: CBSS NO 421 Side - 1
		Amperes	Volts		
		597	29.5	18 IPM	
	5/32	567	27	16	
		627	31	21	
VTRANS RECEIVED OK'D BY _____ OK'D BY JWC SEP 21 2009 APPROVED _____ DATE 9/21/09					VT-A.C.T. Moretown-Middlesex Proj NO 0284(14) Backgouge side-2 Max heat 420 F

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. 202

Revision no. 1-Root 0±

Form III-2

Contractor Casco Bay Steel
 Authorized By Paul E. [Signature]
 Date 12-6-06

