

75 Spring Hill Road
Saco, Maine 04072

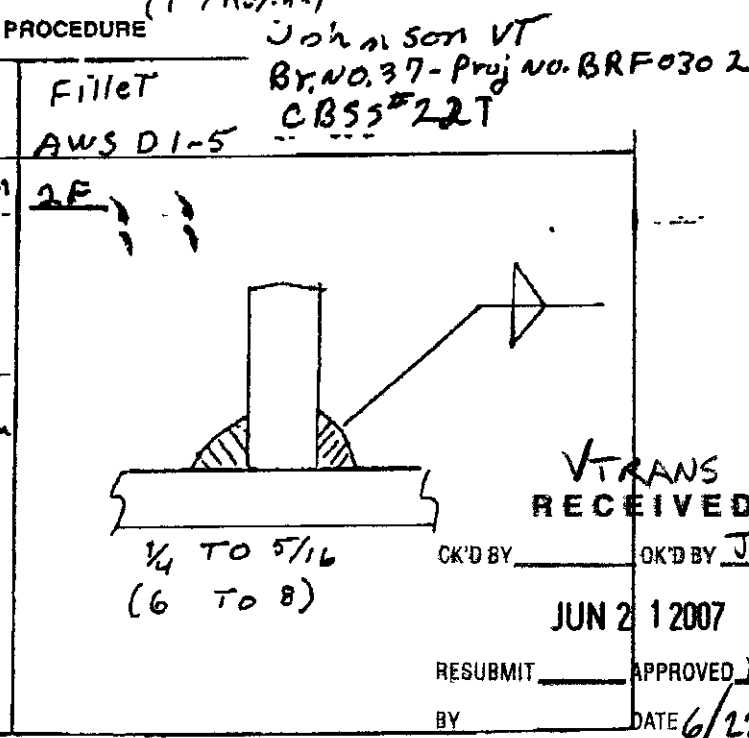
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WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A709/A709M - Gr 50 (270), 50 (345), 50W (345W)
 Welding process Submerged Arc Welding
 Material or machine Machine
 Position of welding Horizontal (AF)
 Filler metal specification AWS E5-23
 Filler metal classification E502-E611R-N, 1 Lincoln
 Flux Lincoln 96 Flux with LA-75 Electrode
 Shielding gas Ar Flow rate Ar
 Single or multiple pass Single - Electrode E502 (25.4 #11)
 Single or multiple arc Single
 Welding current DC
 Polarity DCEN
 Welding progression See joint detail
 Root treatment AWS spec - wire brush - grind - Blast (lean area)
 Preheat and interpass temperature 30 (19) - 50 (10) - 50 (10) - 70 (20) - 70 (20) - 225 (100) (65)
 Postheat temperature Ar
 Heat input Min 3.0 kJ/in (1.2 kJ/mm) Max 4.0 kJ/in (1.6 kJ/mm) DGR 4-728 kJ/in (1.7 kJ/mm)

Pass no	Electrode size	Welding current		Travel speed
		Amperes	Volts	
1	3/32	299	31	13 IPM
		269	29	11
		329	33	15
2	Metric 24	299	31	320 mm
		269	29	299
		329	33	381



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. 01 Authorized By Paul E Goodale
 Date 6-13-00

