

**Casco Bay Steel Structures, Inc.**

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**WELDING PROCEDURE SPECIFICATION**

Material specification: ASTM A 709 Gr 50-50 (250-345-345W)  
 Welding process: Submerged Arc Welding - Auto (SAW)  
 Manual or machine: Machine  
 Position of welding: FLAT (H) Horizontal (AE)  
 Filler metal specification: SAW 62-A5-23  
 Filler metal classification: ER 60-2-1-A5-23  
 Flux: Flux - Electrode - LA-75 Electrode  
 Shielding gas: Ar  
 Single or multiple pass: Single  
 Single or multiple arc: Single  
 Welding current: Direct  
 Polarity: Reverse Electrode Positive  
 Welding progression: As per AWS specifications  
 Root treatment: As per AWS specifications  
 Preheat and interpass temperature: As per AWS specifications  
 Postheat temperature: As per AWS specifications  
 Heat input: Min 41.85 Max 65.45 PQR # 1-59.5

WELDING PROCEDURE

Joint detail: Filet

Pass no	Electrode size	Welding current Amperes	Volts	Travel speed
5/32	605	29.5	18.5	IF
	544.5	27.4	15.3	
	665.5	31.56	20.7	
3/8	605	29.5	459.2	2F
	544.5	27.4	389.6	
	665.5	31.56	525.8	

Notes:  
 5/16 To 1/2 (8 To 12.7)  
 1/4 To 5/16 (6 To 8)

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 Contractor: Casco Bay Steel  
 Revision no. \_\_\_\_\_ Authorized By: Paul E. Woodale  
 Date: 3/2/00

TRANS RECEIVED  
 JUN 2 2007  
 APPROVED: [Signature]  
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