

Casco Bay Steel Structures, Inc.

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 709 - Gr 36-50-50W
 Welding process Submerged Arc Welding
 Manual or machine Machine
 Position of welding Flat + Horizontal
 Filler metal specification A5-23
 Filler metal classification F8A2-ENIK-Ni1-H8
 Flux Lincoln 960 - Electrode LA-95
 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 Detail
 Root treatment grind-wirebrush-free of Mill scale, Slag-RUST & Moisture
 Preheat and interpass temperature See Table
 Postheat temperature AS Req
 Heat Input Min 39.8 Max 62.5 FCM 14-56.8 kJ/in

VT TRANS
 RESUBMIT APPROVED
 DATE 12/16/10

Minimum Preheat and Interpass Temperature, °C [°F]

Welding Process (Base Metal)	Thickness of Thickest Part at Point of Welding, mm [in]			
	To 20 mm [3/4 in] Incl.	Over 20 mm [3/4 in] to 40 mm [1-1/2 in] Incl.	Over 40 mm [1-1/2 in] to 65 mm [2-1/2 in] Incl.	Over 65 mm [2-1/2 in]
SAW; CMAW; PCAW; SMAW (M270M [M270] [A 709M (A 709)] Gr. 250 [36], 345 [50], 345W [50W], HPS 345W [HPS 50W])	10 [50]	20 [70]	65 [150]	110 [225]
SAW; CMAW; PCAW; SMAW (M270M [M270] [A 709M (A 709)] Gr. HPS 485W [HPS 70W], 690 [100], 690W [100W])	10 [50]	50 [125]	80 [175]	110 [225]

VT-AOT Chester
 BRNO, 9 - Proj No. BRFO25137
 CBSS NO 476

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Sec. 5-13 AWS D1-5 Joint detail Fillet
		Amperes	Volts		
AS REQ	5/32	600	30	19	
		640	32	21	
		70	70	70	
		560	28	17	

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-A

Revision no. _____

Contractor Casco Bay Steel

Authorized By Paul E. Hoodub

Date 1-11-10