Casco Bay Steel Structures, Inc.

WELDING PROCEDURE SPECIFICATION

Material specification: ASTM 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-Nil-H8
Flux: Lincoln 960 - ElecTrode LA-75
Shielding gas: NA Flow rate: NA
Single or multiple pass: BoTh
Single or multiple arc: Single
Welding current: DC
Polarity: DCEP
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

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

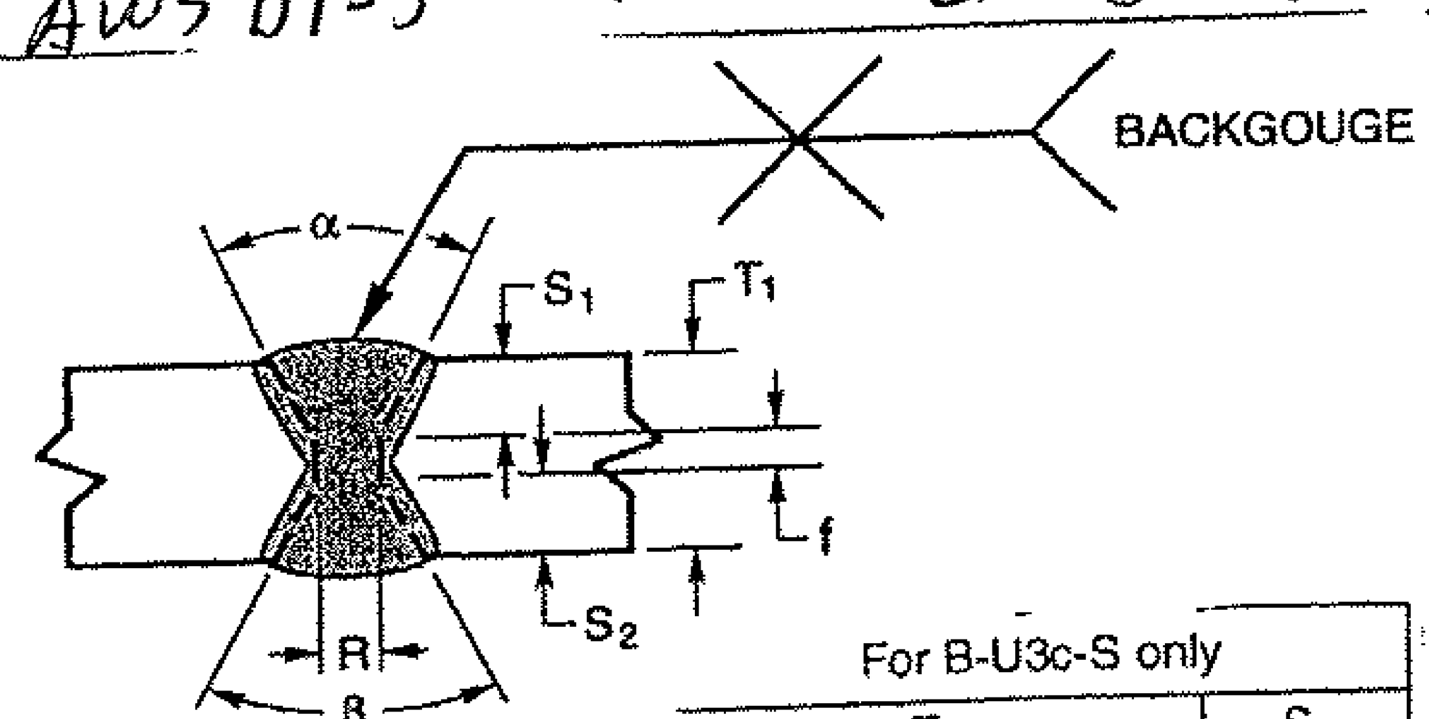
VT-AOT Chester
Br No, 9 - Proj No. BRF0251-37
CBSS No 476

Welding Process (Base Metal)	To 20 mm [3/4 in] Incl.	Thickness of Thickest Part at Point of Welding, mm [in] 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; GMAW; FCAW; 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; GMAW; FCAW; SMAW (M270M [M270]				

Pass no.	Electrode size	Welding current Amperes	Welding current Volts	Travel speed
		600	30	19
AS REQ	5/32	640 TO 560	32 TO 28	21 TO 17

Sec. 5-13
AWS D1-5

Joint detail B-U3c-S



For B-U3c-S only

T_1 Over	T_1 to	S_1
2	2-1/2	1-3/8
2-1/2	3	1-3/4
3	3-5/8	2-1/8
3-5/8	4	2-1/2
4	4-3/4	2-3/4
4-3/4	5-1/2	3
5-1/2	6-1/4	3-3/4

For $T_1 > 6\text{-}1/4$ or $T_1 \le 2$
$S_1 = 2/3 (T_1 - 1/4)$

VTRANS
BY JLC
[illegible] 15 2010
RESUBMIT ___ APPROVED ✓
BY DATE 12/16/10

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-B
Revision no.

Contractor: Casco Bay Steel
Authorized By: [signature]
Date: 12-10-2010