

75 Spring Hill Road
Saco, Maine 04072

Phone: (207) 282-7360

Fax: (207) 282-1171

WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A709/A709M Gr36(250) - A50(345) - A50W (345)
 Welding process Submerged Arc welding
 Manual or machine Machine
 Position of welding Horizontal (2F)
 Filler metal specification AWS A5-23
 Filler metal classification E8A2-EMiK-Ni1 Lincoln
 Flux Lincoln 960 with LA75 Elec.
 Shielding gas NA Flow rate NA
 Single or multiple pass Single
 Single or multiple arc Single
 Welding current DC
 Polarity DCEN
 Welding progression see Joint Detail
 Root treatment Blast clean - wire brush - free of loose scale & moisture
 Preheat and interpass temperature 3/4-50°, 9/4 To 1 1/2-70°, 1 1/2 To 2 1/2-150° over 2 1/2-225
 Postheat temperature NA
 Heat Input Min 30.3 kJ/in Max 47.6 kJ/in PQR-FCM #9-43.3 kJ/in

WELDING PROCEDURE

VT-AOT Chester
BrNO.9 - Proj No. BRFO25137
AWS 5-13 CBSS NO 476

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
	3/32	293	32	13IPM
		270	30	11
		To	To	To
		322	34	14

Joint detail Fillet

VT TRANS
APPROVED
DATE 12/16/06

AWS QC 1
PAUL E. GOODALE
88100201
CWI

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
 Revision no. _____
 Form III-2

Contractor Casco Bay Steel
 Authorized By Paul E. Goodale
 Date 12-6-06