

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 572 Gr 50
 Welding process Submerged Arc Welding (SAW)
 Manual or machine Machine
 Position of welding Flat
 Filler metal specification AWS A5-23
 Flux Lincoln LA 95
 Shielding gas Ar
 Single or multiple pass Single and Multiple Pass
 Single or multiple arc Single
 Welding current DC
 Polarity DCEN
 Welding progression See joint detail
 Root treatment To meet AWS specification
 Preheat and interpass temperature 34-50, +34 to 125, 125 to 225
 Postheat temperature NA
 Heat Input Min 30 KJ/in Max 47 KJ/in

WELDING PROCEDURE

Vermont A&T
By No. 9 - Proj No BR-02160
Stockbridge, CB55-461

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
1	3/32	293	32	13 IPM
		264	80	11
		70	70	70
		822	34	15

AWSD1-5 Joint detail Filet

TRANS RECEIVED
 OK'D BY JWC
 SEP 02 2010
 RESUBMIT _____ APPROVED _____
 BY _____ DATE 9/4/10

AWS QC 1
 PAUL E. GOODALE
 11-06

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of applicable A.W.S. codes or contract specifications.

Procedure no. 250 Contractor Casco Bay Steel
 Revision no. 1 new PAR Authorized By Paul E. Goodale
 Form III-2 Date 11-1-06