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-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: 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]

Welding Process (Base Metal)	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]
		Thickness of Thicker Part at Point of Welding, mm [in]		
SAW; GMAW; FCAW; SMAW (M220M [M270] [A 709/F(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] [A 709M (A 709)] Gr. HPS 485W [HPS 70W], 690 [100], 690W [100W])	10 [50]	50 [125]	80 [175]	110 [225]

Vermont AOT
By No. 9 - Proj No. BRF-0221(60)
Stockbridge - CBSS 461

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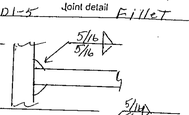
RESUBMIT _____ APPROVED ✓
BY _____ DATE 9/7/10

WELDING PROCEDURE

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

Sec. 5-13
AWS D1-5
Joint detail: Fillet

2F



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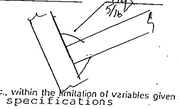

PAUL E. GOODALE
CWI 83100201

This procedure may vary due to fabrication sequence, fit-up, passes, 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. Goodale
Date: 1-11-10