Casco Bay Steel Structures, Inc.

WELDING PROCEDURE SPECIFICATION

Material specification ASTM 709 - Gr 50 - 50W
Welding process Submerged Arc welding (Power wave)
Manual or machine Machine
Position of welding Flat
Filler metal specification A5-23
Filler metal classification F8A2-EN11-N11-HA
Flux Lincoln 880 - Flux LA75
Shielding gas N.A. Flow rate NA
Single or multiple pass Single / Multiple
Single or multiple arc Single
Welding current Alternating
Polarity AC
Welding progression See detail
Root treatment Grind - wire brush - To be free of slag - Rust - Moisture
Preheat and interpass temperature See Table
Postheat temperature As Req.
Heat Input Min 47.1 KJ/in Max 74.0 KJ/in P.Q.R - PW #1 - 67.3 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 (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] [A 709M/[A 709]] Gr. 690 [100], HPS 485W [HPS 70W], 690 [100], 690W [100W])	10 [50]	50 [125]	80 [175]	110 [225]

For ECA - 100F
150° 200F 200F

Vermont AOT
Br. No. 9 - Proj No. BRF-0231(6)
Stockbridge - Class 4b1

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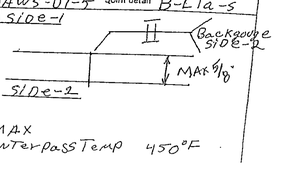
CK'D BY ____ OK'D BY ____

RESUBMIT ____ APPROVED ✓
BY ____ DATE 9/1/10

WELDING PROCEDURE

Pass no.	Electrode size	Welding current Amperes	Welding current Volts	Travel speed
		827	38	28 IPM
AS REQ	5/32	910 To 744	41 To 35	32 To 24

Sec 5.13
AWS-D1-5 Joint detail B-L1a-S
Side-1



MAX Interpass Temp 450°F

This procedure may vary due to fabrication sequence, fit-up, pass and other limits and limitation of variables given in applicable A.W.S. codes or contract specifications

Procedure no. #3 - PW - ST OP VT
Revision no. 1 - 8-3-10

Contractor Casco Bay Steel
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Date Jan 4 - 2010 PAUL E. GOODALE
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