

Casco Bay Steel Structures, Inc.
WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 709 Gr 50-50W
 Welding process Submerged Arc Welding
 Manual or machine Machine
 Position of welding Flat
 Filler metal specification AWS A5-23
 Filler metal classification E70T5-K8
 Flux Lincoln 960 with LA-75 Elec
 Shielding gas sea Flow rate NA
 Single or multiple pass Multiple
 Single or multiple arc single
 Welding current DC EP
 Polarity DC EP
 Welding progression See Detail
 Root treatment Wire brush area to be free of loose scale, slag, rust & dirt
 Preheat and interpass temperature See Table
 Postheat temperature NA
 Heat input Min 39.26 KJ/in Max 42.0 KJ/in P.Q.R FCM #14-56.8 KJ/in

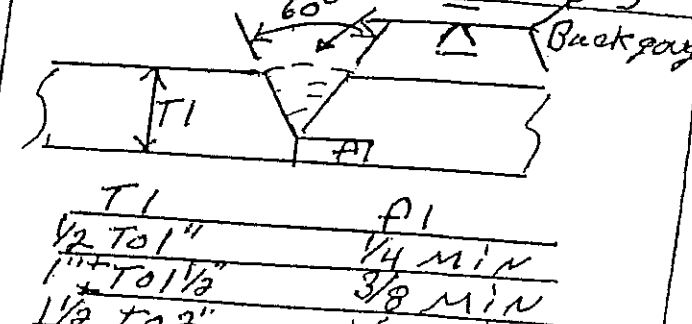
Minimum Preheat and Interpass Temperature, °C (°F)

Thickness of Thicker Part or Plate of Welding, mm (in)	Over 20 mm (3/4 in)		Over 40 mm (1-1/2 in)	
	To 20 mm (3/4 in) Incl.	Over 20 mm to 40 mm (1-1/2 in) Incl.	To 40 mm to 65 mm (1-1/2 in) Incl.	Over 65 mm (2-1/2 in)
SAW (CMAA W. PCA W. SAA W. D4270M (A1270)) (A 709 (A 709)) Or: 250 (250), 345 (350), 445W (50% REDUCED STRENGTH)	10 (150)	20 (300)	65 (1150)	110 (2225)
SAW (CMAA W. PCA W. SAA W. D4270M (A1270)) (A 709M (A 709M)) Or: 105 (445W REDUCED STRENGTH)	10 (150)	30 (1125)	80 (1125)	110 (2225)

OK'D BY: [Signature] DATE: 9/1/10
 RESUBMIT: _____ APPROVED: _____ BY: _____ DATE: _____

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
AS REQ.	5/32	600	30	19
		567	27	17
		70	31	2-1

SEC. 6.13
 AWS D1-5 Joint detail B-L20-S

 T1 to 1/4" 1/4 MIN
 1/4 to 1/2" 3/8 MIN
 1/2 to 2" 1/2 MIN
 MAX Interpass Temp. 450°F

This procedure may vary due to fabrication sequence, fillet pass size, etc., within the limitation of variables given in applicable A.W.S. codes or contract specifications.

Procedure no. 902-ST OF VT
 Revision no. 1-8-10

Contractor Casco Bay Steel
 Authorized By Paul E. Goodale
 Date 4-13-09

PAUL E. GOODALE
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 GC1 EXP. 10/01/10

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