

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 250 GR 250-345-345W
 Welding process Submerged Arc Welding (SAW)
 Manual or machine Machine
 Position of welding Flat 1E Horizontal 2F
 Filler metal specification AWS A5-23
 Filler metal classification Lincoln EA77 EBAZ-EN11-N1
 Flux Lincoln 960 Elec EX 1/8 ± 3/4
 Shielding gas NA Flow rate NA
 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 specifications
 Preheat and interpass temperature To 34-50, 1/4 to 1/2 in 10, 1/2 to 2/4 in 150 over 2/4 in 225
 Postheat temperature NA
 Heat input Min 30 kJ/in Max 40 kJ/in PQR-FCM #9 42.8 kJ/in

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
1	3/32	293	32	12 IPM
		264	80	11
		822	34	16

Joint detail FLLET

AWSD1-5

1/4 TO 5/16

VERMONT ACT
 BY: No. 9 - Proj. No. BRF-0221(00)
 STOCKBRIDGE - CRSS 461

VT AWS
 RECEIVED
 OK'D BY: JWC
 SEP 02 2010
 RESUBMIT APPROVED
 BY: DATE 9/10/10

AWS
 QC 1
 PHIL E. GOODALE
 MANAGER

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

Procedure no. 250 Contractor Casco Bay Steel
 Revision no. 1 New PQR Authorized By Phil E. Goodale
 Form III-2 Date 11-1-06