

Casco Bay Steel Structures, Inc.

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 36 - Gr 36 - 50 - 50W
 Welding process Submerged Arc welding
 Manual or machine Machine
 Position of welding Flat - Horizontal
 Filler metal specification A 5 - 23
 Filler metal classification E 802 - ENIK - Nil - HR
 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 EP
 Polarity DC EP
 Welding progression See Detail
 Root treatment grind with brush - 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]

Vermont Act
RF No. 9 - Proj No. RRF-021(60)
Stocbridge - CBSS 461

Welding Process (Base Metal)	Thickness of Thickest Part at Point of Welding, mm [in]			
	To 20 mm [3/4 in] bct.	Over 20 mm [3/4 in] to 40 mm [1-1/2 in] bct.	Over 40 mm [1-1/2 in] to 65 mm [2-1/2 in] bct.	Over 65 mm [2-1/2 in]
SAW, GMAW, FCAW, SMAW (A4270M [A4270]) (A 709M (A 709) Gr. 250 [24], 345 [30], 345W [30W], HPS 345W [HPS 30W])	10 [50]	20 [100]	65 [150]	110 [225]
SAW, GMAW, FCAW, SMAW (A4270M [A4270]) (A 709M (A 709) Gr. HPS 485W [HPS 70W], 660 [60], 660W [60W])	10 [50]	30 [125]	60 [175]	110 [225]

VTRAWS RECEIVED
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WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
AS REQ	5/32	600	30	19	Sec. 5-13 AWS D1-5 2F
		640	32	21	
		70	70	17	
		560	28	17	

This procedure may vary due to fabrication sequence, in which case the contractor shall be responsible for the applicability of this procedure within the limitation of variables given in applicable A.S. codes or contract specifications.

Procedure no. 201-A
 Revision no. _____
 Contractor Casco Bay Steel
 Authorized By Paul E. Goodale
 Date 1-11-10