

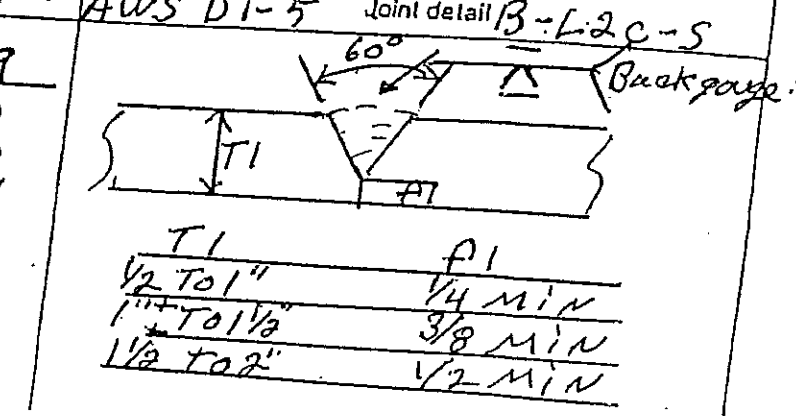
Casco Bay Steel Structures, Inc.
WELDING PROCEDURE SPECIFICATION

Material specification ASTM A572 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 E80T8-K-Ni1-H8 Lincoln
 Flux Lincoln 960 with LA-75 Etc
 Shielding gas NA 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 & moisture
 Preheat and interpass temperature See Table
 Postheat temperature NA
 Heat Input Min 39.26 kJ/in Max 12.5 kJ/in R.Q.R FCM #14 - 0.8 kJ/in

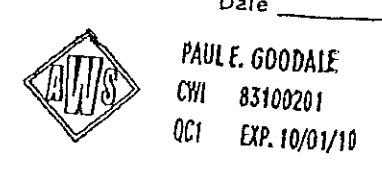
Minimum Preheat and Interpass Temperature, °C (°F)
 Vermont Act
 By No. 9 - Proj No. BR-021(00)
 Stockbridge, CBSS 461

Welding Process (Base Metal)	Thickness of Thicker Part at Point of Welding, mm (in)			
	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)
SAW: (E6010, E6011, E6012, E6013, E6014, E6015, E6016, E6017, E6018, E6019, E6020, E6021, E6022, E6023, E6024, E6025, E6026, E6027, E6028, E6029, E6030, E6031, E6032, E6033, E6034, E6035, E6036, E6037, E6038, E6039, E6040, E6041, E6042, E6043, E6044, E6045, E6046, E6047, E6048, E6049, E6050, E6051, E6052, E6053, E6054, E6055, E6056, E6057, E6058, E6059, E6060, E6061, E6062, E6063, E6064, E6065, E6066, E6067, E6068, E6069, E6070, E6071, E6072, E6073, E6074, E6075, E6076, E6077, E6078, E6079, E6080, E6081, E6082, E6083, E6084, E6085, E6086, E6087, E6088, E6089, E6090, E6091, E6092, E6093, E6094, E6095, E6096, E6097, E6098, E6099, E6100)	10 (150)	20 (170)	45 (150)	110 (225)
SAW: (E6010, E6011, E6012, E6013, E6014, E6015, E6016, E6017, E6018, E6019, E6020, E6021, E6022, E6023, E6024, E6025, E6026, E6027, E6028, E6029, E6030, E6031, E6032, E6033, E6034, E6035, E6036, E6037, E6038, E6039, E6040, E6041, E6042, E6043, E6044, E6045, E6046, E6047, E6048, E6049, E6050, E6051, E6052, E6053, E6054, E6055, E6056, E6057, E6058, E6059, E6060, E6061, E6062, E6063, E6064, E6065, E6066, E6067, E6068, E6069, E6070, E6071, E6072, E6073, E6074, E6075, E6076, E6077, E6078, E6079, E6080, E6081, E6082, E6083, E6084, E6085, E6086, E6087, E6088, E6089, E6090, E6091, E6092, E6093, E6094, E6095, E6096, E6097, E6098, E6099, E6100)	10 (150)	30 (125)	40 (125)	110 (225)

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
AS REQ.	5/32	600	30	19
		567	27	17
		70	70	70
		627	31	2-1



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. 1-8-9-10
 Contractor Casco Bay Steel
 Authorized By Paul E. Goodale
 Date 4-13-09



PAUL E. GOODALE
 CUI 83100201
 OGI EXP. 10/01/10

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 SEP 02 2010
 APPROVED
 DATE 9/11/10