Casco Bay Steel Structures, Inc.
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WELDING PROCEDURE SPECIFICATION

Material specification ASTM 709 Gr 36-50-50W (250-345-345W)
Welding process Submerged Arc welding - AUTO (SAW)
Manual or machine Machine
Position of welding FLAT (F) Horizontal (F)
Filler metal specification AWS A5-17, AWS A5-23
Filler metal classification F8A2-EH14K-H11 Lincoln
Flux 960 Flux - Lincolnweld - LA-75 Electrode
Shielding gas NA Flow rate NA
Single or multiple pass both
Single or multiple arc Single
Welding current Direct
Polarity Reverse Electrode Positive
Welding progression
Root treatment Meet AWS specification
Preheat and interpass temperature To 3/4(19)-50°(60°) 3/4(19)-1 1/2(38)-70°(80°) 1 1/2(38)-2 1/2(63.5)-150°(65°) over 2 1/2(63.5)-225°(100°)
Postheat temperature NA
Heat Input Min 41.65 Max 65.45 PQR # 1-59.5

1 Y WDAY VT
HQ BRS 0269 (B)
BR 8 - CBSS 293

(metric)

WELDING PROCEDURE

Pass no.	Electrode size	Welding current Amperes	Volts	Travel speed	Joint detail
					AWS D1-5 Joint detail Fillet
	5/32	605 544.5 To 665.5	29.5 27.4 To 31.56	18.5 15.3 To 20.7	1F 5/16 To 1/2 (8 To 12.7)
	3.9	Metric 605 544.5 To 665.5	29.5 27.4 To 31.56	457.2 384.6 To 525.8	2F 1/4 To 5/16 (6 To 8)

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

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Revision no.
Form III-2

AWS QC1 PAUL E. DOODALE 03/08/2001 CWI

Contractor Casco Bay Steel
Authorized By Paul E. Doodale
Date 3/2/00

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OK'D BY ____ OK'D BY Jun
RESUBMIT ____ APPROVED ____
BY ____ DATE 3/23/06

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