

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A36 Gr 36 50-50w (250-345-345w)
 Welding process Submerged Arc Welding - AUTO (SAW)
 Manual or machine Machine
 Position of welding Flat (S.A.C.)
 Electrode specification AWS A5-17 AWS A5-23
 Electrode classification E70T5 Lincoln
 Flux 9.60 Flux-Lincoln Weld - LA-75 Electrode
 Shielding gas None Flow rate NA
 Single or multiple pass Both
 Single or multiple arc Single
 Welding current Direct
 Polarity Reverse Electrode Positive
 Welding progression MEET AWS SPECIFICATION
 Root treatment None
 Preheat and interpass temperature None
 Postheat temperature None
 Heat input Min 41.65 Max 65.45 PQR # 1-59.6
LYNDON VT
BY BNS 0269 (B)
BY B-COSS 293

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Notes
		Amperes	Volts		
5/32	605	29.5	18	Joint detail B-L1-S, B-L1-a-s	
	544.5	27.4	15.3		
	665.5	31.56	20.7		
3.9	605	29.5	457.2	T1: 3/8 (9.5) B-L1-S T1: 5/8 (15.875) B-L1-a-s	
	544.5	27.4	388.6		
	665.5	31.56	525.8		

Diagram: A schematic showing a vertical weld joint between two plates. A horizontal line represents the weld. A dimension line indicates a distance 'T' from the top of the weld to the top of the upper plate. A note 'bank gage (except B-L1-S)' points to the weld joint.

APPROVED: [Signature] DATE: 3/29/06

RESUBMIT: [Signature]

*Evidence of CUP is req.

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.

Procedure no. 203 Contractor Casco Bay Steel
 Revision no. 01 Authorized By Paul C. Spadale
 Form III-2 Date 3/12/06