

# Casco Bay Steel Structures, Inc.

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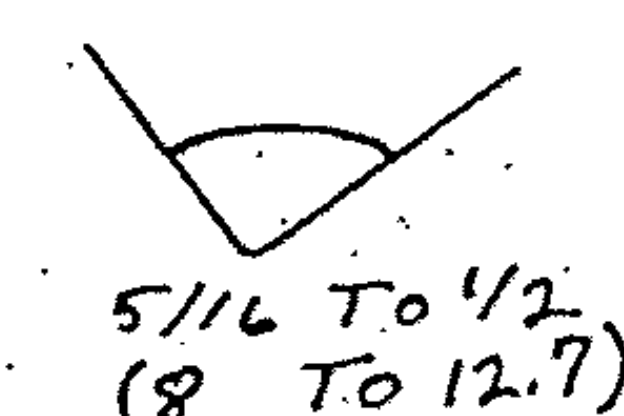
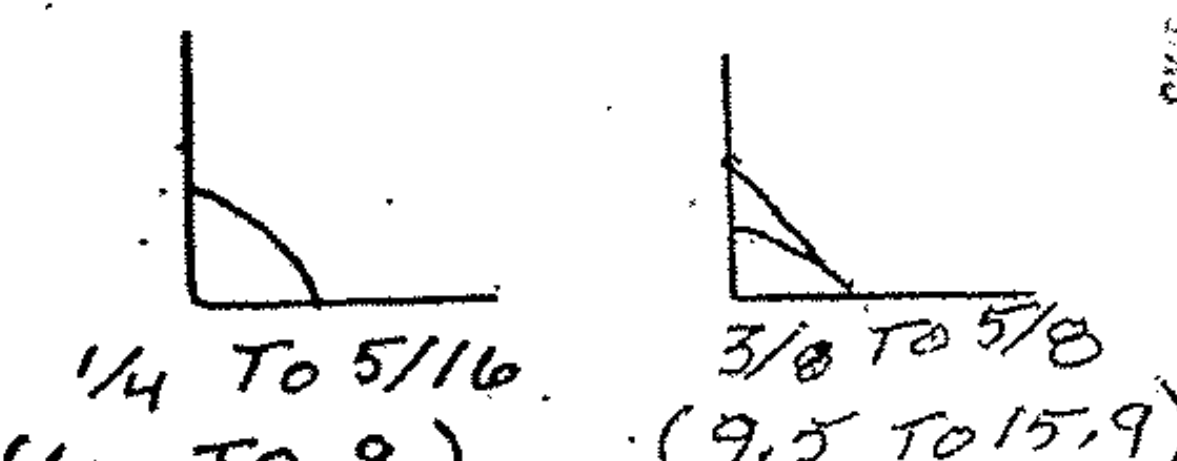
## WELDING PROCEDURE SPECIFICATION

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 (1F), HORIZONTAL (2F)  
 Filler metal specification AWS A5-17, AWS A5-23  
 Filler metal classification E802-ENiK-Ni1 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°(10°) 3/4(19) 1/2(8) 70°(20°) 1/2(8) To 2 1/2(63.5)-150°(65°)  
over 2 1/2(63.5)-225°(110°)  
 Postheat temperature NA  
 Heat Input Min 41.65 Max 65.45 POR 1-59.5

VT - AOT, BY NO 9  
Proj NO. - BR5 0172(6)  
CORNWALL - CBSS-457

### WELDING PROCEDURE

(Metric)

Pass no.	Electrode size	Welding current		Travel speed	AWS D1-5 Joint detail
		Amperes	Volts		
	5/32	605	29.5	18.5	LF  5/16 TO 1/2 (8 TO 12.7)
		544.5	27.4	15.3	
		TO 665.5	TO 31.56	TO 20.7	
	3.9	Metric			2F  1/4 TO 5/16 (6 TO 8)      3/8 TO 5/8 (9.5 TO 15.9)
		605	29.5	457.2	
		544.5	27.4	389.6	
		TO 665.5	TO 31.56	TO 525.8	

JUN 23 2010

RESUBMIT \_\_\_\_\_ APPROVED ✓  
 BY \_\_\_\_\_ DATE 7-8-10

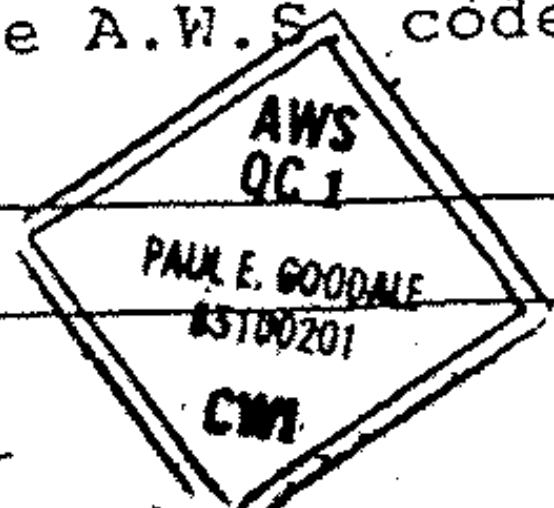
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This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in applicable A.W.S. codes or contract specifications

Procedure no. 201

Revision no. \_\_\_\_\_

Form III-2



Contractor Casco Bay Steel

Authorized By Paul E. Goodale

Date 3/2/00