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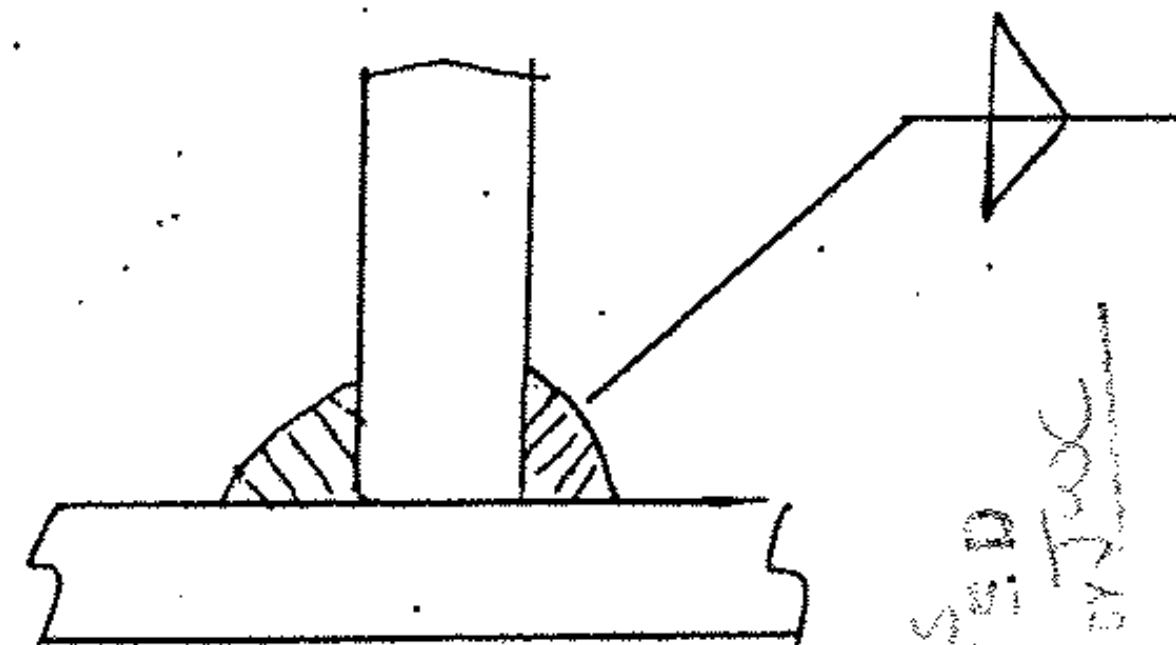
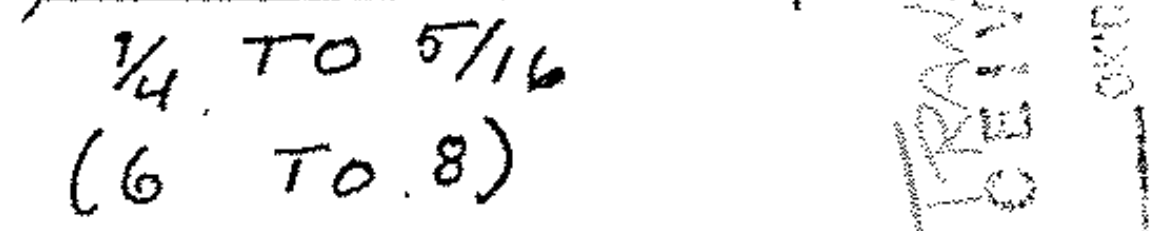
WELDING PROCEDURE SPECIFICATION

Material specification ASTM-709/A709M-Gr36(250), 50(345), 50W(345W)
 Welding process Submerged Arc welding
 Manual or machine Machine
 Position of welding Horizontal (2F)
 Filler metal specification AWS A5-23
 Filler metal classification E8A2-ENiK-Ni1 Lincoln
 Flux Lincoln 960 Flux with LA-75 Electrode
 Shielding gas NA Flow rate NA
 Single or multiple pass Single - Electrode EX. 1" ± 3/4 (25.4 ± 19.1)
 Single or multiple arc single
 Welding current DC
 Polarity DCEN
 Welding progression See joint detail
 Root treatment AWS-spec. - wire brush - grind - Blast Clean area
 Preheat and interpass temperature To 3/4(19) - 50(10) - 3/4(19) To 1/2(38) 70(28) - 1/2(38) To 2 1/2(63) 150(65)
 Postheat temperature NA over 2 1/2(63) - 225(110)
 Heat Input Min 30.0 kJ/in (1.2 kJ/mm) Max 42.1 kJ/in (1.9 kJ/mm) PQR # 4-42-8 kJ/in (1.7 kJ/mm)

VT-AOT, By No 9
 Proj No. - BR5 0172(6)
 Coy N Wall - CBSS-457

WELDING PROCEDURE

(Metric)

Pass no.	Electrode size	Welding current		Travel speed	Fillet AWS D1-5 Joint detail 2F
		Amperes	Volts		
1	3/32	299	31	13 IPM	
		269 To 329	29 To 33	11 To 15	
	2.4	Metric			
		299	31	330 mm	
		269 To 329	29 To 33	279 To 381	

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 BY

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. 250 Contractor Casco Bay Steel
 Revision no. _____ Authorized By Paul E Goodale
 Date 6-13-00

