

Casco Bay Steel Structures, Inc.

110 STRUCTURAL
STEEL

WELDING PROCEDURE SPECIFICATION

Material specification ASTM-709-GY50
 Welding process Submerged Arc welding
 Manual or machine Machine
 Position of welding Horizontal-2F, Flat-1F
 Filler metal specification AWS-A5-23
 Filler metal classification E802-ENIK-Ni1-H8
 Flux Lincoln 960-Elec. LA75
 Shielding gas NA Flow rate NA
 Single or multiple pass Single
 Single or multiple arc Single
 Welding current DC EN
 Polarity DC EN
 Welding progression See joint Detail
 Root treatment Blast Clean-wire brush-Free From Loose-Scale-Slag-Moisture
 Preheat and interpass temperature See table
 Postheat temperature AS Req
 Heat Input Min 40.9 kJ/in Max 64.2 kJ/in POR #2-58.4 kJ/in

Minimum Preheat and Interpass Temperature, °C [°F]

TRANS
RECEIVED

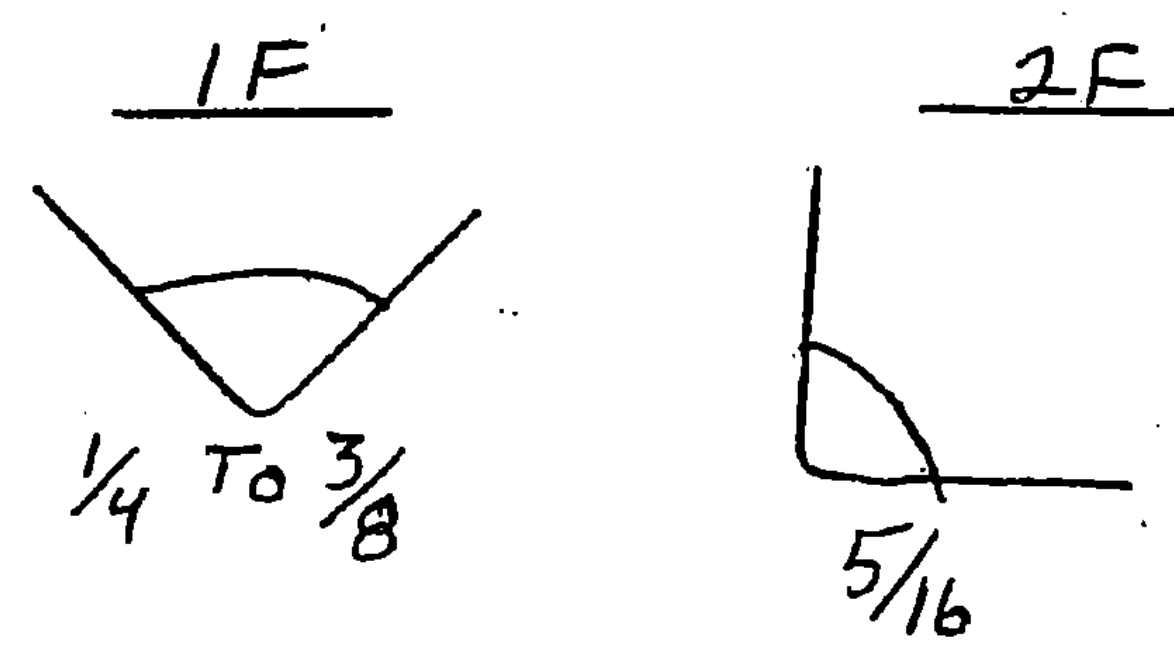
CK'D BY _____ OK'D BY JWC

DEC 07 2010

Welding Process (Base Metal)	Thickness of Thickest Part at Point of Welding, mm (in)				RESUBMIT	APPROVED
	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; OMAW; FCAW; SMAW (M270M [M270] [A 709M [A 709]])	10 [50]	20 [70]	65 [1150]	110 [2251]	BY _____	DATE <u>12/07/10</u>

WELDING PROCEDURE

VT-A.G.T., Bridgewater
 Proj. # BRS 0149(4)
 Br. # 14, CBSS 454

Pass no.	Electrode size	Welding current		Travel speed	Sec 5-13 AWS D1-5 Joint detail
		Amperes	Volts		
AS REQ	3/32	365	32	12	Fillet 1F 2F  1/4 To 3/8 5/16
		328	30	11	
		To	To	To	
		365	33	14	

MAX INTERPASS 410^{OF}

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 ST OF VT Contractor Casco Bay Steel
 Revision no. 1-8-7-1 PAUL E. GOODALE Authorized By Paul E. Goodale
 CWI 83100201 Date 6-21-10
 QCI EXP. 10/01/10

