

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 (1G)
 Filler metal specification AWS A5.17 AWS A5.23
 Filler metal classification FRAX-EX11K-N11 Lincoln
 Flux 960 Flux - Lincoln Weld - LA-75 Electrode
 Shielding gas NA Flow rate NA
 Single or multiple pass both
 Single or multiple etc. single
 Welding current Direct
 Polarity Reverse Electrode Positive
 Welding progression
 Root treatment Meet AWS specification - Back gouge side 2
 Preheat and interpass temperature To 340 (90) to 600 (300) 1 1/2 (88) 2 1/2 (39) 150 (60)
 Postheat temperature NA
 Heat input Min 41.65 Max 65.45 PAR 1-59.5 Chester Vermont
By A.C. 43 Proj. No. BR Fall 10 (2)
C.B.S.S. No. 369

(Metric)

Pass no	Electrode size	Welding current		Travel speed	AWS D1.5 side #1											
		Amperes	Volts													
5/32	605	29.5	18.5													
	544.5	27.4	15.3													
	To	To	To													
	665.5	31.56	20.7													
3.9	605	29.5	457.2	<table border="1"> <tr> <td>1/2" to 1"</td> <td>1/4 min</td> </tr> <tr> <td>(2.7 to 25.4)</td> <td>(6)</td> </tr> <tr> <td>1" to 1 1/2"</td> <td>3/8 min</td> </tr> <tr> <td>(25.4 to 38.1)</td> <td>(9.5)</td> </tr> <tr> <td>1 1/2" to 2"</td> <td>1/2 min</td> </tr> <tr> <td>(38.1 to 50)</td> <td>(12)</td> </tr> </table>	1/2" to 1"	1/4 min	(2.7 to 25.4)	(6)	1" to 1 1/2"	3/8 min	(25.4 to 38.1)	(9.5)	1 1/2" to 2"	1/2 min	(38.1 to 50)	(12)
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544.5	27.4	388.6														
To	To	To														
665.5	31.56	525.8														

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

Procedure no 202
 Revision no _____
 Form III 2

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

