

Casco Bay Steel Structures, Inc.

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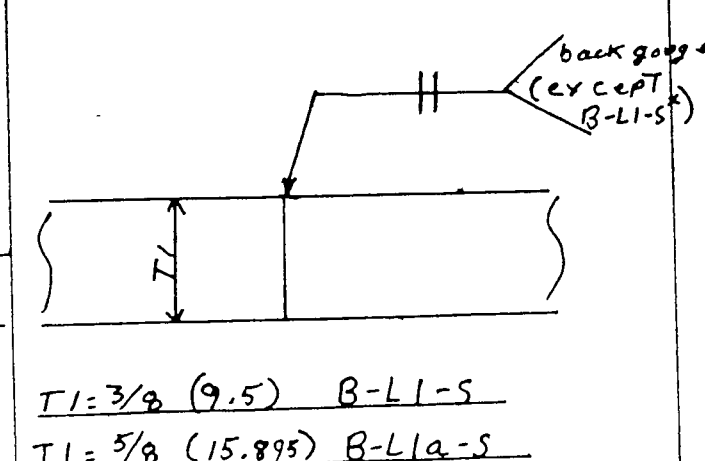
Fax: (207) 282-1179

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709 Gr 36-50-50w (250-345-345w)
 Welding process Submerged Arc welding - AUTO (SAW)
 Manual or machine MACHINE
 Position of welding FLAT (1sa.g)
 Filler metal specification AWS A5-17, AWS A5-23 LINCOLN DEPT.
 Filler metal classification E70A2-EN18Ni-Ni LINCOLN ELECTRODE
 Flux 960 Flux-Lincoln weld-LA-75 Flow rate NA
 Shielding gas NA
 Single or multiple pass both
 Single or multiple arc single
 Welding current Direct Electrode Positive
 Polarity Reverse Electrode Positive
 Welding progression MEET AWS SPECIFICATION
 Post treatment Preheat and interpass temperature to 24(19) 50°C(100), 3/4(19) 1/2(80)
 Postheat temperature NA
 Heat input NA Max 65.45 PQR # 1-59.6 CHESTER VERMONT
 BY NO. 43 Proj No. BRP016-105
 CBSS No 369

WELDING PROCEDURE

Pass no	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
5/32	605	29.5	18	18	AWS D1.5 Joint detail B-L1-S, B-L1-S
		544.5 TO	27.4 TO		
		665.5	31.56		
3/8	605	29.5	457.2	388.6	T1: 3/8 (9.5) B-L1-S T1: 5/8 (15.875) B-L1-S
		544.5 TO	27.4 TO		
		665.5	31.56		



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

Procedure no 203
 Revision no _____
 Form III 2

Contractor Casco Bay Steel
 Authorized By Paul E. Woodale
 Date 3/12/00

