Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM 709 Gr36-50-50W (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 F8A2-EM11K-N11
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) 1½(38)-70°(20°) 1½(38) To 2½(63.5)-150°(65°) over 2½(63.5)-225°(110°)
Postheat temperature NA
Heat Input Min 41.65 Max 65.45 PQR# 1-59.5 Chester Vermont
BrNO.43 Proj No. BRFo16-1(25)
CBSS No 369

(Metric)

WELDING PROCEDURE

Pass no	Electrode size	Welding current Amperes	Welding current Volts	Travel speed	Joint detail AWS D1.5 Fillet
	5/32	605 544.5 To 665.5	29.5 27.4 To 31.56	18.5 15.3 To 20.7	1F 5/16 To 1/2 (8 To 12.7)
	3.9	Metric 605 544.5 To 665.5	29.5 27.4 To 31.56	459.2 384.6 To 525.8	2F 1/4 To 5/16 (6 To 8)

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

AWS QC1 PAUL E. WOODALE 8310201 CWI

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