

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A109/A109M = Gr 250 (A36) - 345 (A50) - 345W (A50W)
 Welding process Submerged Arc welding - Semi-Auto
 Manual or machine Machine
 Position of welding Fillet weld - 1F - 2F
 Filler metal specification AWS A5-17 - AWS A5-23
 Filler metal classification EBA2-EX-1K-VII Lincoln
 Flux 760 Lincoln Flux - Electrode LA-75 Lincoln
 Shielding gas NA Flow rate NA
 Single or multiple pass Single & multiple Electrode EX-1 1/4" - 2 1/2" x 20mm
 Single or multiple arc Single
 Welding current Direct
 Polarity DC EP
 Welding progression _____
 Root treatment wire brush - Grind - Blast Clean To AWS specification
 Preheat and interpass temperature 1/2" (12.7) 50° (100°) 3/4" (19) To 1 1/2" (38) 70 (200)
 Postheat temperature NA
 Heat Input Min 50 KJ/in Max 7900/in PQR 5-72 KJ/in, 2.8 KJ/in
2 KJ/in 3 KJ/in Christen Vermont

WELDING PROCEDURE

Pass no	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail
		Amps	Volts		
	3/32	505	33	14 IPM 356 mm/min	
		454	31	14 IPM	
		70	30	14 IPM	
		556	35	356 mm/min	

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 151 Contractor Casco Bay Steel
 Revision no _____ Authorized By Paul E. [Signature]
 Form III-2 Date 11-20-2002

