

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A572 Gr 50 (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 E802-EMiK-NiL LINCOLN
 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 Meets AWS Specification
 Preheat and interpass temperature To 3/4(19)-50(100) 3/4(19) 1/2(8) 70(20) 1/2(8) To 2 1/2(63.5) 150(65) over 2 1/2(63.5)-225(110)
 Postheat temperature NA
 Heat Input Min 41.65 Max 65.45 PQR # 1-59.5

VT. A.D.T.
 E. MONTPELIER
 Br# 74-Proj# 0283(36)
 CBSS 400

WELDING PROCEDURE

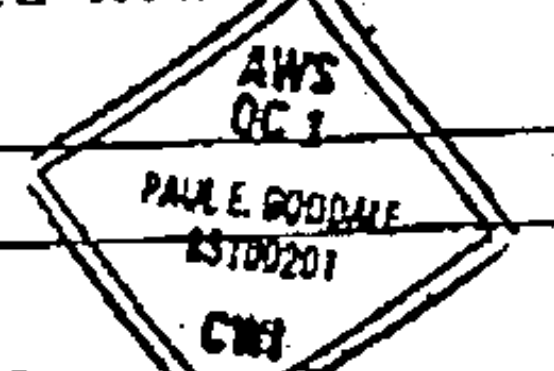
(Metric)

Pass no.	Electrode size	Welding current		Travel speed	AWS D1-5 Joint detail
		Amperes	Volts		
	5/32	605	29.5	18.5	1F  5/16 TO 1/2 (8 TO 12.7)
		544.5 TO 665.5	27.4 TO 31.56	15.3 TO 20.7	
	3.9	Metric	29.5	457.2	2F  1/4 TO 5/16 (6 TO 8)
		605	27.4	389.6	
		544.5 TO 665.5	31.56	525.8	

FILET RECEIVED
 CKD BY _____ CKD BY JWC
 APR 29 2009
 REQUEST BY _____ APPROVED ✓
 DATE 5/11/09
 VTrans - PDD
 APR 29 2009
 Structures Design Section

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 11-2



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