

Casco Bay Steel Structures, Inc.

75 Spring Hill Road
Saco, Maine 04072

Phone: (207) 282-7360

Fax: (207) 282-1179

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 709 Gr 250-345-345W
 Welding process Submerged Arc Welding (SAW)
 Manual or machine Machine
 Position of welding Flat 1F - Horizontal 2F
 Filler metal specification AWS A5-23
 Filler metal classification Lincoln LA 75, FBAZ-EM11-M1
 Flux Lincoln 960, ELECL EX 1/8 ± 3/4
 Shielding gas NA Flow rate NA
 Single or multiple pass single and multiple Pass
 Single or multiple arc single
 Welding current DC
 Polarity D.C.E.N
 Welding progression See joint Detail
 Root treatment To meet AWS specification
 Preheat and interpass temperature To 34-50, +34 to 1 1/2-70, 1 1/4 to 2 1/2-130 over 2 1/2 225
 Postheat temperature NA
 Heat Input Min 30 KJ/in Max 4711 KJ/in PQR-FCM #9 4218 KJ/in

WELDING PROCEDURE

VT. A.O.T.
 E. MONTPELLIER
 Br # 74-Prj # 0283(36)
 CBSS 400.

Pass no.	Electrode size	Welding current		Travel speed	AWS D1-5 Joint detail
		Amperes	Volts		
1	3/32	293	32	13 IPM	
		264	30	11	
		TO	TO	TO	
		322	34	15	

VT. A.O.T. RECEIVED
 CWD BY: JWC
 APR 29 2009
 RESUBMITTED BY: S/1/09

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. 250
 Revision no. 1 New PQR
 Form III-2

Contractor Casco Bay Steel
 Authorized By Paul E. Goodale
 Date 11-1-06