

75 Spring Hill Road
Saco, Maine 04072

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM 709 - Gr 36-50-50W / A 209M - Gr 250-345-345W
 Welding process Submerged Arc welding (SAW)
 Manual or machine Machine
 Position of welding Flat
 Filler metal specification AWS A5-23
 Filler metal classification E8A2-EMILK-Nil
 Flux Lincoln 960 with LA 95 Elec. - Elec EX.
 Shielding gas NA Flow rate NA
 Single or multiple pass _____
 Single or multiple arc _____
 Welding current DC
 Polarity DC EN
 Welding progression See details
 Root treatment wire brush area to be free of loose scale, slag, rust and moisture
 Preheat and interpass temperature To 20 (36) 10 (60) 20 (36) To 40 (1 1/2) 20 (70) 40 (1 1/2) To 60 (1 1/2) 65 (150)
 Postheat temperature NA
 Heat Input Min 41.1 Max 64.5 PQR-FCM 3A-5B VT. AOT

WELDING PROCEDURE

VT. AOT
 E. MONTPELIER
 Br # 74-Proj # 0203(36)
 CBSS 400.

Pass no	Electrode size	Welding current		Travel speed	AWS 5-13 AWS D1-5 Joint detail B-L2C-5 Side - 1
		Amperes	Volts		
	5/32	597	295	18 IPM	
		567	27	16	
		627	31	21	
OK'D BY		OK'D BY JWC			
RESUBMIT BY		APPROVED DATE 5/11/09			
APR 29 2009 RECEIVED VI RWS					
Back gouge side - 2 Max heat 420 F					

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. 202

Revision no. 1-Root 0±

Form III-2

Contractor Casco Bay Steel
 Authorized By Paul E. [Signature]
 Date 12-6-06

