



**Casco Bay Steel Structures**  
 One Wallace Avenue, South Portland ME 04106  
**AWS - Welding Procedure Specification (WPS)**  
 WeldOffice WPS

WPS record number	202	Revision <b>3</b>	Qualified to	AWS D1.5
Date	4/24/2014		Company name	Casco Bay Steel Structures
Supporting PQR(s) Reference docs.	SAW DC + FCM 2-21-14 - Rev 1			

Scope	Groove, no PWHT (As-welded)
Joint	Joint details for this welding procedure specification in: JOINTS section of this WPS

BASE METALS				THICKNESS RANGE QUALIFIED (in.)				
Type	Gr50/Gr50W	P-no.	Grp-no.	As-welded		With PWHT		
Welded to	Gr50/Gr50W	P-no.	Grp-no.	Min.	Max.	Min.	Max.	
Backing:	None	P-no.	Grp-no.	Complete pen.	1/8	5/8	-	-
Retainers				Impact tested	-	-	-	-
Notes	All A709 steels with 50 ksi or less are also qualified			Partial pen.	NO	-	-	-
				Fillet welds	-	-	-	-

DIAMETER RANGE QUALIFIED (in.)			
As-welded		With PWHT	
Min.	Max.	Min.	Max.
		-	-

FILLER METALS						THICKNESS RANGE QUALIFIED (in.)			
	SFA	Classification	F-no.	A-no.	Chemical analysis or Trade name	As-welded		With PWHT	
						Min.	Max.	Min.	Max.
SAW	5.23	ENi1K	6		Lincolnweld LA-75	1/8	5/8	-	-
Flux	5.23	F8A2	6		Lincolnweld 960	- Required -			
Sup. filler	-	-	-	-	-	- None -			
Flux type									
Flux from recrush. slag	No								

WELDING PROCEDURE	
Welding process	SAW
Type	Machine
Minimum preheat/interpass temperature (°F)	See Backpage
Maximum interpass temperature (°F)	490
Filler metal size (in.)	5/32
Layer number	
Position	F
Current/polarity	DCEP
Amperes	604
Volts	29.5
Travel speed (in./min)	17.1
Maximum heat input (kJ/in.)	62.5193
Wire feed type	Hot wire
Wire feed speed (in./min)	N/A
String or weave	Stringer
C.T.W.D (in.)	
Multi/Single pass per side	Single or Multiple passes
Multiple or single layer	Single or Multiple layer
Oscillation	None
Multi/single electrode	Single electrode
Electrode angle (deg.)	As needed
Maximum pass thickness (in.)	
Weld deposit chemistry	F8A2-ENi1K-Ni1-H8
Notes	

TH1 FAS RT 0211 Huntington River  
 Rural Major Collector  
 BR 8 Proj BF-0211(32) CBSS 695

Vermont Agency of Transportation  
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 CK'D BY \_\_\_\_\_ OK'D BY Rob Young  
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