



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

WPS record number	203	Revision	2	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.	over 1/2	2	-	-
Retainers				Impact tested	-	-	-	-
Notes	All A709 steels with 50 ksi or less are also qualified			Partial pen.	NO	-	-	-
				Fillet welds	-	-	-	-

FILLER METALS						THICKNESS RANGE QUALIFIED (in.)			
SFA	Classification	F-no.	A-no.	Chemical analysis or Trade name	As-welded		With PWHT		
SAW	5.23 ENi1K	6		Lincolnweld LA-75	Min.	Max.	Min.	Max.	
Flux	5.23 F8A2	6		Lincolnweld 960	over 1/2	2	-	-	
Sup. filler	-	-	-	-	- Required -				
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  
**RECEIVED**  
 CK'D BY \_\_\_\_\_ OK'D BY Rob Young  
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 BY Rob Young DATE 03/06/2017