



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

WPS record number	250	Revision	1	Qualified to	AWS D1.5
Date	6/10/2014	Company name	Casco Bay Steel Structures		
Supporting PQR(s)	SAW FCM 3/32 DC- 5/7/14				
Reference docs.					

Scope	Fillet, no PWHT (As-welded), impact testing
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.	-	-	-	-
Retainers	All A709 with 50 ksi or less are also qualified						
Notes							

Complete pen.	-	-	-	-
Impact tested	-	-	-	-
Partial pen.	-	-	-	-
Fillet welds	1/8	no max.	-	-

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

FILLER METALS						THICKNESS RANGE QUALIFIED (in.)			
SFA	Classification	F-no.	A-no.	Chemical analysis or Trade name	As-welded		With PWHT		
SAW	5.23	EN1K	6	LincolnElectric LA-75	Min.	Max.	Min.	Max.	
Flux	5.23	F8A2		LincolnElectric Lincolnweld960	-	-	-	-	
Sup. filler					-	-	-	-	
Flux type	No								
Flux from recrush. slag	N/A								
Suppl. filler metal vol. (ft <sup>3</sup> )	N/A								

WELDING PROCEDURE		SAW
Type		Machine
Minimum preheat/interpass temperature (°F)		See Back Page
Maximum interpass temperature (°F)		400
Filler metal size (in.)		3/32
Layer number		
Position		H
Current/polarity		DCEN (straight polarity)
Amperes		363.3
Volts		31.6
Travel speed (in./min)		12.8
Maximum heat input (kJ/in.)		53.8138
Wire feed type		Cold 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.)		Varies
Maximum pass thickness (in.)		See Back Page
Weld deposit chemistry		F8A2-EN1K-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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 BY Rob Young DATE 03/06/2017