



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

WPS record number	201	Revision	1	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	Fillet, 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.	-	-	-	-
Retainers							
Notes	All A709 steels with 50 ksi or less are also qualified						
Complete pen.	-	-	-	-	-	-	-
Impact tested	-	-	-	-	-	-	-
Partial pen.	-	-	-	-	-	-	-
Fillet welds	1/8	All	-	-	-	-	-

FILLER METALS				DIAMETER RANGE QUALIFIED (in.)			
SFA	Classification	F-no.	A-no.	As-welded		With PWHT	
SAW	ENi1K	6		Min.	Max.	Min.	Max.
Flux	-	-	-	-	-	-	-
Sup. filler	-	-	-	-	-	-	-

FILLER METALS				THICKNESS RANGE QUALIFIED (in.)			
SFA	Classification	F-no.	A-no.	As-welded		With PWHT	
SAW	ENi1K	6		Min.	Max.	Min.	Max.
Flux	-	-	-	-	-	-	-
Sup. filler	-	-	-	-	-	-	-

WELDING PROCEDURE		SAW
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,H
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.)		See Backpage
Weld deposit chemistry		F8A2-ENi1K-Ni1-H8
Notes		

Vermont Agency of Transportation  
**RECEIVED**  
 CK'D BY RSF OK'D BY WDL  
**March 9, 2016**  
 RESUBMIT No Approved  
 BY RSY DATE 05/26/2016