

Casco Bay Steel Structures, Inc.

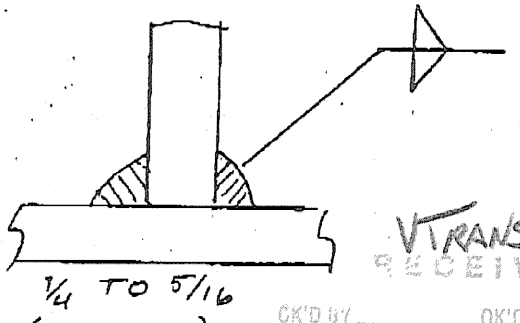
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WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A709M-Gr36(250), 50(345), 50W(345W)
Welding process Submerged Arc welding
Manual or machine Machine
Position of welding Horizontal (2F)
Filler metal specification AWS A5-23
Filler metal classification E802-ENiK-Ni1 Lincoln
Flux Lincoln 90 Flux with LA-75 Electrode
Shielding gas Ar Flow rate Ar
Single or multiple pass Single Electrode Ex. 1-34 (25.4 ± 1.1)
Single or multiple arc Single
Welding current AC
Polarity DCEN
Welding progression See Joint Detail
Root treatment AWS Spec. wire brush - grind - Blast (Clean area)
Preheat and interpass temperature 1/4 (19) - 50 (10) 30 (17) to 1 1/4 (66) 70 (20) 1 1/2 (38) to 2 1/2 (63) 150 (60)
Postheat temperature Ar over 2 1/2 (63) - 225 (110)
Heat Input Min 3.0 kJ/in (1.2 kJ/mm) Max 42.1 kJ/in (1.9 kJ/mm) PQR # 4-42-8 KJ/in (1.7 kJ/mm)

WELDING PROCEDURE					Travel speed	Fillet
Pass no.	Electrode size	Welding current		Travel speed		
		Amps	Volts			
1	3/32	299	31	12 IPM		VT, ACT GORINTH Br # 34 - Proj # STRBR0-1447(32) CBS NO 380 AWS D1-5
		269	29	11		
		70	70	70		
		329	33	15		
	2.4	299	31	380 mm	VT TRANS RECEIVED JWC 11/24/08	
		269	29	279		
		70	70	70		
		329	33	381		

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. 250 Contractor Casco Bay Steel
Revision no. 001 Authorized By Paul E Goodale
Form 111-2 Date 6-13-00