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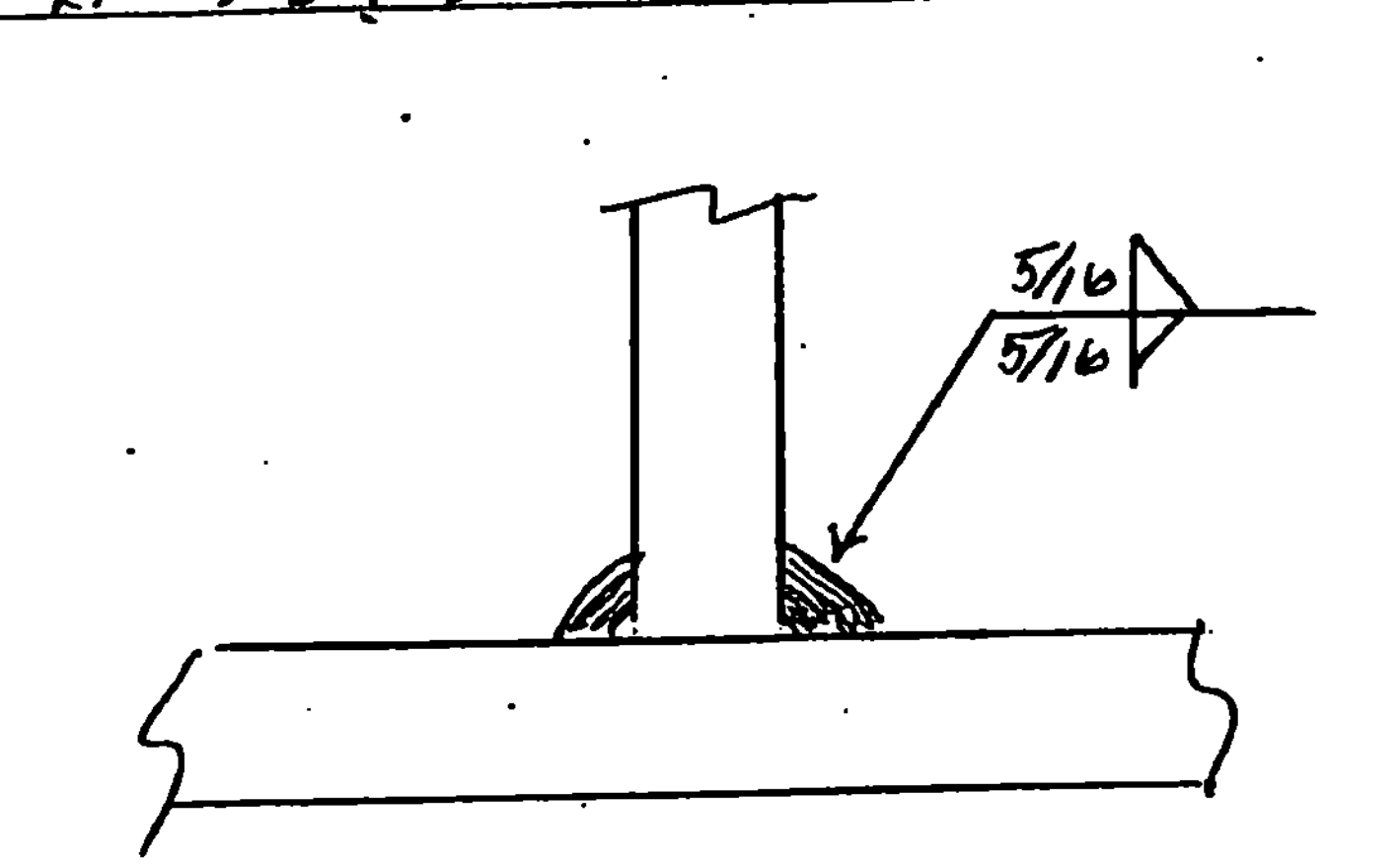
WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A709/A709M Gr36(250) - A50(345) - A50W(345)  
 Welding process Submerged Arc welding  
 Manual or machine Machine  
 Position of welding Horizontal (2F)  
 Filler metal specification AWS A5-23  
 Filler metal classification E802-EMILK-Mil Lincoln  
 Flux Lincoln 960 with LAD5 Elec.  
 Shielding gas NA Flow rate NA  
 Single or multiple pass single  
 Single or multiple arc single  
 Welding current DC  
 Polarity DCEN  
 Welding progression see Joint Detail  
 Root treatment Blast clean - wire brush - free of loose scale & moisture  
 Preheat and interpass temperature 3/4"-50°, 9/16" to 1/2"-70°, 1/2" to 2/4"-150° over 2/4"-225°  
 Postheat temperature NA  
 Heat Input Min 30.3 kJ/in Max 47.6 kJ/in PQR-FCM #9-43.3 kJ/in

WELDING PROCEDURE

VT-AOT - Read Board  
 Br. No. 31  
 Proj No - BRD-144(25)  
 CBSS 445  
 Joint detail Fillet

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
	3/32	293	32	13 IPM
		270	30	11
		TO	TO	TO
		322	34	14



VI TRAVIS RECEIVED

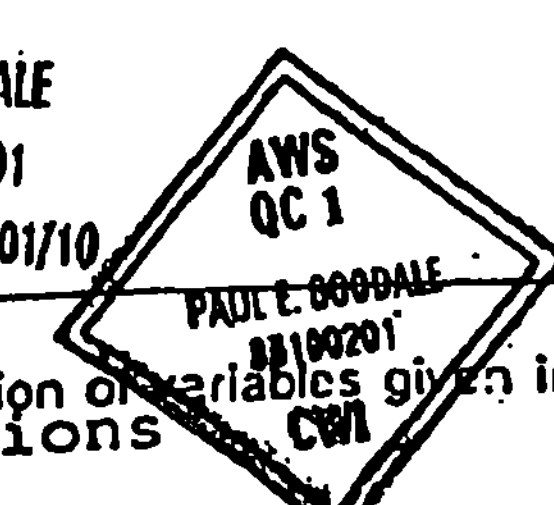
OK'D BY JWC

APR 22 2010

RESUBMIT APPROVED BY JWC DATE 05/04/10



PAUL E. GOODALE  
 CWI 85100201  
 OCT EXP. 10/01/10



This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of applicable A.W.S. codes or contract specifications

Procedure no. 250  
 Revision no. \_\_\_\_\_

Contractor Casco Bay Steel  
 Authorized By Paul E. Goodale  
 Date 12-6-06