

**Casco Bay Steel Structures, Inc.**

75 Spring Hill Road  
Saco, Maine 04072

Phone: (207) 282-7360

Fax: (207) 282-1179

**WELDING PROCEDURE SPECIFICATION**

Material specification ASTM A36 (280-345-345W)  
 Welding process Submerged Arc Welding - Auto (SAW)  
 Manual or machine Auto  
 Position of welding Flat  
 Filler metal specification AWS A5-23  
 Filler metal classification E70T1-K-Ni Lincoln  
 Flux 960 Flux - Lincoln LA-75 Electrode  
 Shielding gas Ar  
 Single or multiple pass Single  
 Single or multiple arc Single  
 Polarity Reverse Electrode Positive  
 Welding progression As specified  
 Root treatment As specified  
 Preheat and interpass temperature As specified  
 Postheat temperature As specified  
 Heat input Min 41.65 Max 65.45 PAR 1-59.5

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OK'D BY JWC

DATE 01-23-2008

VERMONT A.C.T.  
LEICESTER 01\*6  
Proj # BRF 0160305  
CBS5 285

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
5/32	605	29.5	18.5	AWS D1.5 Joint detail R-2.2.2.5 side #1 
	544.5	27.4	15.3	
	665.5	31.56	20.7	
3/9	605	29.5	45.2	T1 1/8" to 1/4" 1/4 min (2.7 to 25.4) (6) 1/4" to 1/2" 3/8 min (5.4 to 38.1) (9.5) 1/2" to 2" 1/2 min (38.1 to 60) (12)
	544.5	27.4	38.6	
	665.5	31.56	52.8	

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

Procedure no. 202  
 Revision no. 001  
 Contractor Casco Bay Steel  
 Authorized By Tom R. Chandler  
 Date 3/2/00

