

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A709/A709M-Gr 36 (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 E6010-EWIK-Ni1 Lincoln
 Flux Lincoln 960 Flux with LA-95 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 DC
 Polarity DCEN

Welding progression See Joint Detail
 Root treatment AWS Spec. - wire brush - grind - Blast Clean area
 Preheat and interpass temperature 125 (19) - 50 (10) - 30 (17) to 125 (25) to 225 (45) (65)
 Postheat temperature Ar
 Heat Input Min 3.0 kJ/in Max 4.0 kJ/in PQR 4-42-8 kJ/in 1.7 kJ/in
 (1.2 kJ/mm) (1.9 kJ/mm) over 2 1/2 (6.3) - 2.25 (10)
BRW 7 - P. 10 3 H F O I B L T
Warren VT. C855 MC 324

(Metric)

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
1	3/32	299	31	13 IPM
		269	29	11
		70	30	70
		329	33	15
2	2.4	299	31	380 mm
		269	29	299
		70	30	70
		329	33	381

WELDING PROCEDURE

Fillet AWS D1.5 Joint detail

1/4 TO 5/16 (6 TO 8)

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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. AWC DC 1 Authorized By Paul E Goodale
 Form III-2 PAUL E. GOODALE 04/10/2001 CWI Date 6-13-00