Filler metal classification E81T1-Ni1-H4 ESAB

Flux ~A

Shielding gas 75% AR - 25% CO2 Flow rate 35 CFH +8 -4

Single or multiple pass Single / Multiple Elec Ex 5/8 ± 1/4

Single or multiple arc Single

Welding current DC

Polarity DCEP

Welding progression See deTail

Root treatment wire brush - area To be Free of loose Scale, Slag, rusT & MoisTure

Preheat and interpass temperature To 20mm (3/4) 10(50), 20+ (3/4+) To 40 (1 1/2) 20(70), 40+ (1 1/2) To 60 (2 1/2) 65 C(150), over 60 (2 1/2) 110 (225)

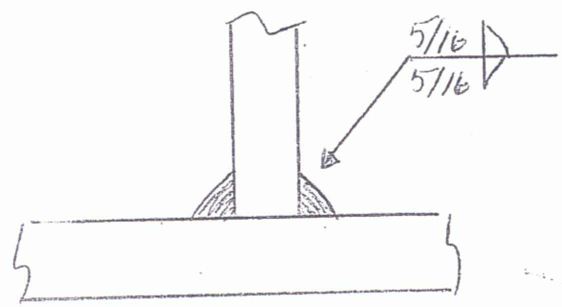
Postheat temperature ~A

Heat Input Min 27.7 KJ/in Max 43.6 KJ/in PQR FCM #8 39.6 KJ/in

Vermont A.O.T.
Br #15 - Proj # 1143(39)
Clarendon - CBSS 424

WELDING PROCEDURE

AWS 5-13

Pass no.	Electrode size	Welding current: Amperes	Welding current: Volts	Travel speed	AWS D1-5 Joint detail FilleT
		287	29	13	
	1/16	258 To 315	26.8 To 31	11.4 To 14	

V TRANS RECEIVED
CK'D BY ______ CK'D BY JWC
SEP 2 9 2009
RESUBMIT ______ APPROVED ✓
BY DATE 10/13/09

AWS QC1 PAUL E. GOODALE 93100201 CWI

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. 101

Revision no. ______

Form III-2

Contractor Casco Bay Steel

Authorized By Paul E. Goodale

Date 12-6-06