

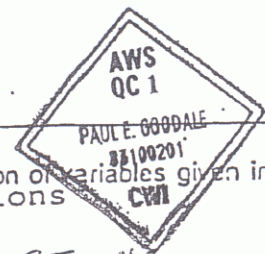
Filler metal classification ER70S-6 Lincoln
 Flux Lincoln 960 with LA75 Elec.
 Shielding gas NA Flow rate NA
 Single or multiple pass single
 Single or multiple arc single
 Welding current DC
 Polarity DC EN
 Welding progression see Joint Detail
 Root treatment Blast Clean - wire brush - Free of loose scale & moisture
 Preheat and interpass temperature 3/4-50°F, 3/4 To 1/2-70°F, 1/2 To 2/2-150°F over 2/2-225
 Postheat temperature NA
 Heat Input Min 30.3 kJ/in Max 47.6 kJ/in PQR-FCM #9-43.3 kJ/in

WELDING PROCEDURE

Vermont A.C.T.
 B1-F15-Prj #1443(39)
 CIAREDEM - C855424

Pass no.	Electrode size	Welding current		Travel speed	AWS 5-13 AWS D1-5 Joint detail Fillet
		Amperes	Volts		
	3/32	293	32	13 IPM	
		270	30	11	
		To	To	To	
		322	34	14	

TRANS RECEIVED
 CK'D BY _____ OK'D BY JWC
 SEP 23 2009
 RESUBMIT _____ APPROVED ✓
 BY _____ DATE 10/13/09



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
 Revision no. _____
 Form III-2

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