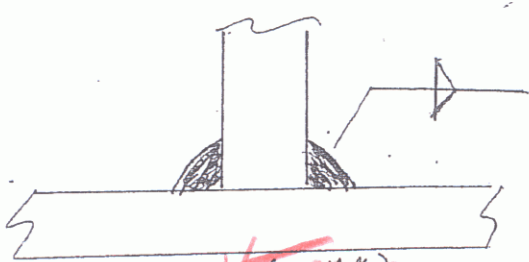


Filler metal specification AWS A5-23
 Filler metal classification F8A2-ENiK-Ni Lincoln
 Flux Lincoln 960 FLUX with LA75 Elec.
 Shielding gas NA Flow rate _____
 Single or multiple pass Single
 Single or multiple arc Single
 Welding current DC
 Polarity DCEP
 Welding progression See Joint Detail
 Root treatment WIRE BRUSH - area To be Free of Loose Scale - Slag - Rust & Moisture
 Preheat and interpass temperature To 3/4(19) 50°F(10°) - 3/4(19) To 1 1/2(38) 70°F(20) 1 1/2(38) To 2 1/2(63) 150°F(65)
 Postheat temperature NA over 2 1/2(63) 225°F(110°)
 Heat Input Min 4.1(1.6) Max 64.5(2.5) P.Q.R. 3A-58.7 KJ/IN (2.3 KJ/mm) Δ

VERMONT A.C.T.
 B-15 - Proj # 1443(39)
 CIAREDEM - CB55424

(Metric)

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail Fillet
		Amperes	Volts		
1	5/32	597	29.5	18 IPM	
		567	27	16	
		To	To	To	
		627	31	21	
1	3.9	597	29.5	457 ^{mm} / _{min}	<p>5/16 (8mm) RECEIVED</p> <p>CK'D BY _____ OK'D BY <u>JWC</u></p> <p>SEP 23 2009</p> <p>RESUBMIT _____ APPROVED <u>✓</u></p> <p>BY _____ DATE <u>10/13/09</u></p> <p>MAX 420°F (216°C)</p>
		567	27	406	
		To	To	To	
		627	31	533	

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. 201 Br. ST of V
 Revision no. A New P.Q.R
 Form III-2

Contractor Casco Bay Steel
 Authorized By Paul E. Goodale
 Date 1-24-05