

Phone: (201) 114-4533

WELDING PROCEDURE SPECIFICATION

Material specification: ASTM A109 Gr 36-50-50W (250-345-345W)  
 Welding process: Shielded Metal Arc Welding (SMAW)  
 Manual or machine: Manual  
 Position of welding: Flat (F) Horizontal (HF)  
 Filler metal specification: ER70S-2  
 Filler metal classification: ER70S-2 E6010 E6013 E6018  
 Shielding gas: NA Flow rate: NA  
 Single or multiple pass: Single and multiple  
 Single or multiple arc: Single  
 Welding current: AC  
 Polarity: Straight / Reverse  
 Preheat and interpass temperature: 70°(160°) to 140°(280°) to 210°(400°)  
 Postheat temperature: NA  
 Heat input: NA Min: NA Max: NA  
 Location: RICH FORD, VT  
 Project: By No. 41 - Proj No BHF-0302(3)S  
 Drawing: C855 361

| Pass no. | Electrode size       | Welding current |       | Travel speed | AWS D1.5 | Joint detail |
|----------|----------------------|-----------------|-------|--------------|----------|--------------|
|          |                      | Amperes         | Volts |              |          |              |
| A5       | 2018<br>1/8<br>(3-2) | 70-170          | 22-26 | AS           | IF       |              |
|          | 5/32<br>(3-9)        | 120-225         | 22-26 |              |          |              |
|          | 3/16<br>(4-0)        | 170-300         | 24-27 |              |          |              |
| REQ      | 2018<br>1/8<br>(3-2) | 90-160          | 22-26 | 2F           | 2F       |              |
|          | 5/32<br>(3-9)        | 120-225         | 22-26 |              |          |              |
|          | 3/16<br>(4-0)        | 180-290         | 24-27 |              |          |              |
| REQ      | 2018<br>1/8<br>(3-2) | 170-270         | 22-26 | REQ          | REQ      |              |
|          | 5/32<br>(3-9)        | 170-270         | 22-26 |              |          |              |
|          | 3/16<br>(4-0)        | 210-330         | 24-27 |              |          |              |

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

Procedure no. 401 Contractor Casco Bay Steel  
 Authorized By Paul E. Hoada  
 Date 3/2/00

TRANS RECEIVED  
 CKD BY JUC  
 RESUBMIT APPROVE  
 BY WBJ DATE 4/17/08