75 Spring Hill Road
Saco, Maine 04072

Phone: (207) 282-7360 Fax: (207) 282-1179

## WELDING PROCEDURE SPECIFICATION

Material specification ASTM 709 - Gr36-50-50W / A709M - Gr250-345-345W
Welding process Submerged Arc welding (SAW)
Manual or machine Machine
Position of welding Flat
Filler metal specification AWS A5-23
Filler metal classification F8BA2-EN1LK-N1
Flux Lincoln 960 with LA75 Elec - Elec Ex.
Shielding gas NA Flow rate NA
Single or multiple pass
Single-or multiple arc
Welding current DC
Polarity DC EN
Welding progression See details
Root treatment Wire brush area Tobe Free of loose scale, slag, rust and moisture
Preheat and interpass temperature To 20°(36) 10(60), 20°(36) To 40(1½) 20(70), 40(1½) To 60(2½) 65 (150)
over 60(2½) 110 (225)
Postheat temperature NA
Heat Input Min 41.1 Max 64.5 P.Q.R-FCM 3A - 58.7 KJ/in

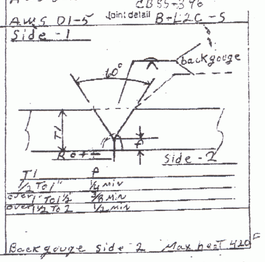
VT-ACT
Browning Tom
Brass-Proj BR0449(2-E)
2B55-396

### WELDING PROCEDURE

| Pass no. | Electrode size | Welding current Amperes | Welding current Volts | Travel speed |
|---|---|---|---|---|
| | | 597 | 295 | 18 IPM |
| | 5/32 | 569 To 629 | 29 To 31 | 16 To 21 |

AWS 5-13
AWS D1-5 Joint detail B-L2C-S

Side-1




| T1 | A |
|---|---|
| 1/2 To 1" | 1/4 min |
| over 1 To 1½ | 3/8 min |
| over 1½ To 2 | 1/2 min |

Backgouge side 2 Max heat 420°F

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. 202
Revision no. 1 - Root of
Form fi-2 VT RAWS

Contractor Cosco Bay Steel
Authorized By Paul B
Date 12-6-06

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OK'D BY _____ OK'D BY JWC
MAY 1 2009
RESUBMIT ____ APPROVED ✓