

### Casco Bay Steel Structures, Inc.

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#### WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 709 Gr 50-50W (250-345-345W)  
 Welding process Submerged Arc Welding - AUTO (SAW)  
 Manual or machine Machine  
 Position of welding Flat (H) Horizontal (H)  
 Filler metal specification AWS A5.17 AWS A5.23  
 Filler metal classification E 7018-1M1 Lincoln  
 Shielding gas Ar Flow rate NA  
 Single or multiple pass both  
 Single or multiple arc single  
 Welding current Direct  
 Polarity Reverse Electrode Positive  
 Preheat and interpass temperature 34(11) to 40(10) 3/8(10) 1/2(8) 3/4(6) 1(5) 1 1/4(5) 1 3/4(5) 2(5)  
 Postheat temperature NA  
 Heat input Min 41.65 Max 45.45 PQR 1-59.5 V.T.A.C.T.  
 Broomington  
 BR 15-17-8R0449624  
 C085-376

(METRIC)

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail
		Amps	Volts		
5/32	605	29.5	18.5	1F	<p>5/16 To 1/2 (8 To 12.7)</p>
	544.6	27.4	15.3		
	665.5	31.56	20.7		
3/8	MATRIC	29.5	45.2	2F	<p>1/4 To 5/16 (6 To 8)</p>
	605	29.5	45.2		
	544.6	27.4	45.2		

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 Contractor Casco Bay Steel  
 Revision 1 Authorized By Paul E. Woodruff  
 Date 3/2/09

RESUBMIT \_\_\_\_\_ APPROVED \_\_\_\_\_  
 BY \_\_\_\_\_ DATE 4/1/09

