

Casco Bay Steel Structures, Inc.

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 36 - Gr 36 - 50 - 50W
Welding process Submerged Arc welding
Manual or machine Machine
Position of welding Flat + Horizontal
Filler metal specification E 55-23
Filler metal classification E 8022 - ENIK - Nil - HB
Flux Lincoln 960 - Electrode LA-25
Shielding gas NA Flow rate NA
Single or multiple pass BOTH
Single or multiple arc Single
Welding current DC
Polarity DCRP
Welding progression See Detail
Root treatment Grind - wire brush - Free of Mill scale, Slag - Rust & Moisture
Preheat and interpass temperature See Table
Postheat temperature AS REQ
Heat Input Min 39.8 Max 62.5 FCM 14 - 56.8 KJ/in

Minimum Preheat and Interpass Temperature, °C (°F)

Welding Process (Base Metal)	Thickness of Thickest Part at Point of Welding, mm (in)			
	To 20 mm [3/4 in] Incl.	Over 20 mm [3/4 in] to 40 mm [1-1/2 in] Incl.	Over 40 mm [1-1/2 in] to 65 mm [2-1/2 in] Incl.	Over 65 mm [2-1/2 in]
SAW, CMAW, FCAW, SMAW (M270M (M270) [A 709M (A 709)] Gr. 250 [50], 345 [50], 345W [50W], 485 [50W], 485W [50W])	10 [50]	20 [70]	65 [150]	110 [225]
SAW, CMAW, FCAW, SMAW (M270M (M270) [A 709M (A 709)] Gr. 485 [50W], 485W [50W], 590 [100], 690W [100W]T	10 [50]	50 [125]	80 [175]	110 [225]

VT-AOT Bethel
VT 107 (River) Dover
White River
Project: BRP0221(14)
CLASS 498

Nov 14 2011

Resubmit BY DATE 11/14/11

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
AS REQ	5/32	600	30	19	2F 5/16 5/16 1F 5/16 5/16
		640	32	21	
		70	70	70	
		560	28	17	

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-A
Revision no. _____
Contractor Casco Bay Steel
Authorized By Paul E. Goodrich
Date 1-11-10