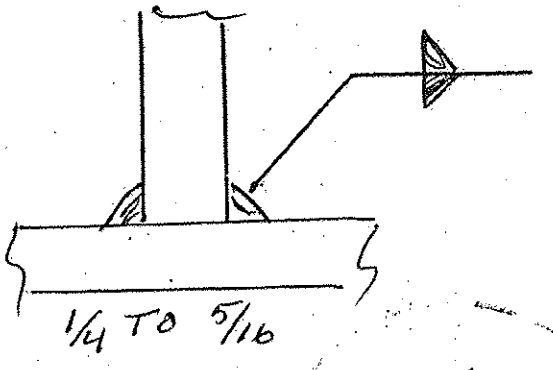


75 Spring Hill Road
Saco, Maine 04072
Phone: (207) 282-7360 Fax: (207) 282-1117

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 709 Gr 50-345-345W
Welding process Submerged Arc Welding (SAW)
Manual or machine Machine
Position of welding Flat 1F - Horizontal 2F
Filler metal specification AWS A 5-23 FBA2-EX11-M1
Filler metal classification Lincoln LA 75 EX 1/8 ± 3/4
Flux Lincoln 960
Shielding gas Ar Flow rate Ar
Single or multiple pass single and multiple pass
Single or multiple arc single
Welding current DC
Polarity DCEN
Welding progression See joint Details
Root treatment To meet AWS specifications
Preheat and interpass temperature To 34-50, 1/4 to 1/2 in. 70-110, 1/2 to 2 in. 150-225
Postheat temperature NA
Heat Input Min 30 KJ/in Max 4711 KJ/in PQR-FCM #9 42.8 KJ/in

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
1	3/32	293	32	13 IPM	
		264	80	11	
		70	70	70	
		822	34	15	

Nov 14 2011

APPROVED BY: 11/15/11

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

Procedure no. 250 Contractor Casco Bay Steel
Revision no. 1 new PQR Authorized By Paul E. Goodale
Form III-2 Date 11-1-06