

Casco Bay Steel Structures, Inc.

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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 (1F) Horizontal (1E)
 Filler metal specification AWS/A5.1 - A5.5
 Filler metal classification E7018 - E7018 C63 - 702B
 Flux NA
 Shielding gas NA Flow rate NA
 Single or multiple pass Single and multiple
 Single or multiple arc Single
 Welding current AC/DC
 Polarity Straight / Reverse
 Welding progression See AWS Specification
 Root treatment See AWS Specification
 Preheat and interpass temperature Preheat 3/4 (5) 50 (60) 3/4 (1) 140 (18) 70 (40) 1/4 (1) 140 (18) 1/4 (1) 140 (18)
 Postheat temperature NA
 Heat Input Min NA Max NA

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By # 34 - Proj STRBR0-1447(2)
CBS No 380

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5	Joint detail	Filler
		Amperes	Volts				
AS	7018 1/8 (3-2)	70-170	22-26	AS	AWS D1.5	Joint detail	Filler
	5/32 (3-9)	120-225	22-26				
	3/16 (4-P)	170-300	24-27				
	702B 1/8 (3-2)	90-160	22-26				
REQ	5/32 (3-9)	120-225	22-26	REQ	AWS D1.5	Joint detail	Filler
	3/16 (4-P)	180-290	24-27				
	702B 5/32 (3-9)	170-270	22-26				
	3/16 (4-P)	210-330	24-27				

This procedure may vary due to location, 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
 Revision no. _____ Authorized By Paul E. Hoodale
 Form III-2 Date 3/2/00