

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709/A709M, Gr 36 (250) - 50 (345) - F11K (345-4)
 Welding process Flux Cored Arc welding
 Manual or machine Semi Auto
 Position of welding ELT (E) - Horizontal (2F)
 Filler metal specification AWS-A5-29
 Filler metal classification E81T1-A1
 Flux NA
 Shielding gas 75%AR / 25%CO₂ Flow rate 35 CFH ± 8.6
 Single or multiple pass Single and Multiple
 Single or multiple arc Single
 Welding current Direct
 Polarity Reverse Electrode Positive
 Welding progression
 Root treatment As per AWS D1.5 Specification
 Preheat and interpass temperature As per AWS D1.5 Specification
 Postheat temperature NA
 Heat Input Min 28.6 (1.15kcal) Max 45.0 (1.8kcal) PQR # 2 = 40.9 (1.6kcal)

WELDING PROCEDURE (Metric) VT, ACT CORINTH
Br # 34 - Proj # STBRO-1447(2)
C.B.S.S. No 380

Pass no.	Electrode size	Welding current		Travel speed	Notes
		Amperes	Volts		
AS	1/16	27.5	28.8	11.6	IF
		24.7 To 302.5	26.8 To 30.8	10.4 To 12.8	
		27.5 To 302.5	28.8 To 30.8	2.946 To 3.2512	
Req	1.6	27.5	28.8	2.946	2E
		24.7 To 302.5	26.8 To 30.8	2.642 To 3.2512	
		27.5 To 302.5	28.8 To 30.8	2.642 To 3.2512	

Joint detail: Fillet

TRANS RECEIVED
 OK'D BY: JUC
 DATE: 11/21/08

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. 101-A
 Revision no. 1
 Date 2/20/07