

**Casco Bay Steel Structures, Inc.**

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**WELDING PROCEDURE SPECIFICATION**

Material specification ASTM A99-Gr36-50-50W (250-345-345W)  
 Welding process Shielded Metal Arc Welding (SMAW)  
 Manual or machine Manual  
 Position of welding Flat (F), Horizontal (HF)  
 Filler metal specification A51/AWS A51-A5.5  
 Filler metal classification E7018-R018 1/8" - 7028  
 Flux NA  
 Shielding gas NA  
 Single or multiple pass Single and multiple  
 Single or multiple arc single  
 Welding current AC/DC  
 Polarity STRAIGHT / Reverse  
 Welding progression Meet AWS SPECIFICATION  
 Root treatment Meet AWS SPECIFICATION  
 Preheat and interpass temperature To 24(9) 50(10) 30(9) To 1/4(3) 70(20) 1/2(8) To 3/4(3) 150(65) over 3/4(3) 225(110)  
 Postheat temperature NA  
 Heat Input Min NA Max NA

TRANS RECEIVED  
 JUL 14 2005  
 APPROVED  
 DATE 7-26-05

(Metric)

**WELDING PROCEDURE**

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5	Joint detail	Filler	
		Amperes	Volts					
AS	7028 1/8 (3.2)	70-170	22-26	AS	IF		IF	
	5/32 (3.9)	120-225	22-26					
	3/16 (4.8)	170-300	24-27					
REQ	8028 1/8 (3.2)	90-160	22-24	REQ	2F		2F	
	5/32 (3.9)	120-225	22-26					
	3/16 (4.8)	180-290	24-27					
REQ	7028 5/32 (3.9)	170-270	22-26	REQ	3/4 To 3/8 (5 To 10)		3/8 To 1/2 (10 To 13)	
	3/16 (4.8)	210-330	24-27					1/2 To 5/8 (13 To 16)
	7028 5/32 (3.9)	170-270	22-26					
3/16 (4.8)	210-330	24-27	3/8 (10)					
7028 5/32 (3.9)	170-270	22-26		7/16 To 5/8 (11 To 16)				
3/16 (4.8)	210-330	24-27						

This procedure may vary due to fusion 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. Hordale  
 Date 3/2/00