

Casco Bay Steel Structures, Inc.

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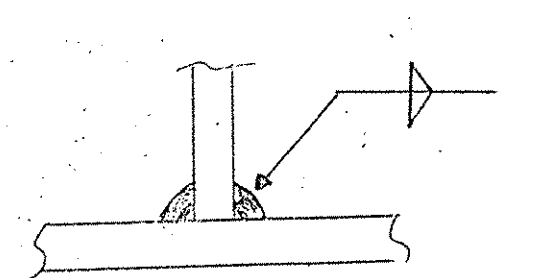
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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 709/A 709M - Grade 50w (345w)
 Welding process Flux Cored Arc welding (FCAW)
 Manual or machine semi AUTO
 Position of welding Horizontal (2F)
 Filler metal specification AWS A5-29
 Filler metal classification E 81T1-Ni1 Lincoln OuterShield 81Ni1-H
 Flux N/A Flow rate 35CFH ± 8 (16.64m³/hr ± 4)
 Shielding gas 75% AR - 25% CO₂
 Single or multiple pass Single or Multiple - Electrode Extension $\frac{3}{8}$ " (15.87 ± 0.4)
 Single or multiple arc Single
 Welding current DC
 Polarity DC EP
 Welding progression see Joint Detail
 Root treatment wire brush area to be free of loose scale, slag, rust, moisture
 Preheat and interpass temperature MIN 50 (65) - MAX 550 (290) - MAX interpass 550 (290)
 Postheat temperature N/A
 Heat Input Min 28.6 (1.126) Max 45.0 (1.772) PQR #2 40.9 (1.610)

WELDING PROCEDURE

Size	Pass no.	Electrode size	Welding current		Travel speed	AWS 5.13	Joint detail
			Amperes	Volts			
5/16	1	1/16	275	29	11	AWS D1.5	Joint detail: Fillet
			To 303	To 31	To 13		
2	"	"	"	"	11		
8	1	1.6	275	29	2.95	AWS 5.13	Joint detail: Fillet
			To 303	To 31	To 3.25		
2	"	"	"	"	11		



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 BY ST. OF ME. Contractor Casco Bay Steel
 Revision no. #2 Authorized By Paul E. Struble
 Form III-2 Date 4-14-00