

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION


Material specification ASTM A36 Gr 36-50-50W (250-345-345W)
 Welding process EMAW
 Manual or machine Semi-Auto
 Position of welding Flat - Horizontal
 Filler metal specification AWS 5-18
 Filler metal classification EA 705-6 Hobart
 Flux A
 Shielding gas 75% AR - 25% CO₂ Flow rate 40 CFH ± 5
 Single or multiple pass single Electrode stickout 3/8 to 3/4
 Single or multiple arc single
 Welding current DC
 Polarity DC EP
 Welding progression AS. REG.
 Root treatment TO AWS Spec clean rust free
 Preheat and interpass temperature TO 34-50° 3/4 TO 1/2 700°
 Postheat temperature NA
 Heat Input Min NA Max NA

Rochester VT
Proj. BR-0241(32)16
BY 31 - CBSS:2002

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amps	Volts		
1	.045	±20 180	±2 22	52 10IPM	AWS D1.5 Joint detail FILLET

Horizontal Flat



weld size 3/8 to 1/4

RECEIVED

OK'D BY _____ OK'D BY JLR

MAR 21 2006

RESUBMIT _____ APPROVED _____

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. 302 Contractor Casco Bay Steel
 Revision no. _____ Authorized By Paul C. Fontaine
 Form III-2 Date 6-24-04