

Casco Bay Steel Structures, Inc.

75 Spring Hill Road
Saco, Maine 04072

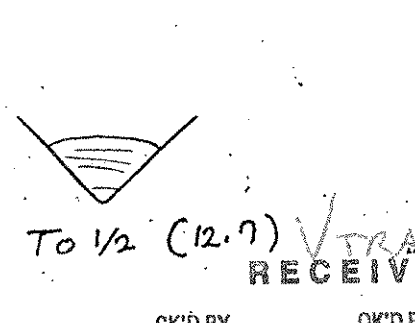
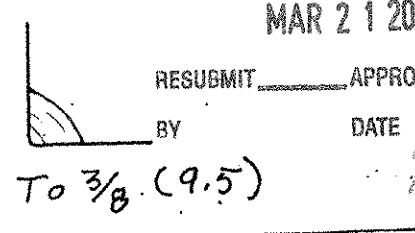
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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 909/A 909M - Grade 36 (250) 50 (345) 50w (345w)
 Welding process Flux Cored Arc welding (FCAW)
 Manual or machine Semi Auto
 Position of welding Flat (1F) Horizontal (2F)
 Filler metal specification AWS A5-20
 Filler metal classification E71T-1
 Flux NA
 Shielding gas 75% AR 25% CO2 Flow rate 40 CFH ±5
 Single or multiple pass Single and Multiple - Electrode Extension 3/8" ±4 (5.2) ±6 (35)
 Single or multiple arc Single
 Welding current DC
 Polarity Reverse
 Welding progression _____
 Post treatment To meet AWS specification
 Preheat and interpass temperature To 3/4 (19) 50 (10) 3/4 (19) To 1/2 (12.7) 70 (20) 1/2 (12.7) To 3/8 (9.5) 150 (65)
 Postheat temperature NA over 2 1/2 (6.3) - 225 (110)
 Heat Input Min NA Max NA Bethel, VT
 Proj. BRF-024(32)W
 BY 31 - C.B.S.

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
1/16	1/16	29.5	28.8	11.6	1F 
		24.5	26.8	10.4	
		To 30.5	To 30.8	To 12.8	
1.6	1.6	29.5	28.8	294.6	2F 
		24.5	26.8	264.2	
		To 30.5	To 30.8	To 325.12	

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 Contractor Casco Bay Steel
 Revision no. _____ Authorized By Bill J. Fardale
 Form III-2 Date 3/23/00

