

Casco Bay Steel Structures, Inc.

5 Industry Road
South Portland, Maine 04106

Fax: (207) 772-0580

Phone: (207) 772-2533

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A109 Gr 36-50-50w (250-345-345w)
 Welding process Shielded Metal Arc Welding (SMAW)
 Manual or machine Manual
 Position of welding Flat (F), Horizontal (HF)
 Filler metal specification ANSI/AWS A5.1 - A5.5
 Filler metal classification E7018 - R018 C₆₃ - 702B
 Flux NA
 Shielding gas NA Flow rate NA
 Single or multiple pass Single and multiple
 Single or multiple arc single
 Welding current AC/DC
 Polarity STRAIGHT / Reverse
 Welding progression
 Root treatment ASME SPECIFICATION
 Preheat and interpass temperature 34(9) 50(C) 3/4(1.9) To 1 1/2(3.8) 70(20) 1 1/2(3.8) To 2 1/2(6.3) 150(65)
 Postheat temperature NA
 Heat input Min NA Max NA

OK'D BY: TWC DATE: MAR 21 2006
 RESUBMIT APPROVED
 BY: ReThel VT DATE: 4/6/06
 Proj: BRF-024103
 BR 31 - C.B.S.S.

WELDING PROCEDURE (Metric)

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

This procedure may vary due to fabrication 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. Hoodale
 Form III-2 Date 3/2/00

167c