

Casco Bay Steel Structures, Inc.

5 Industry Road  
South Portland, Maine 04106

Phone: (207) 772-2533

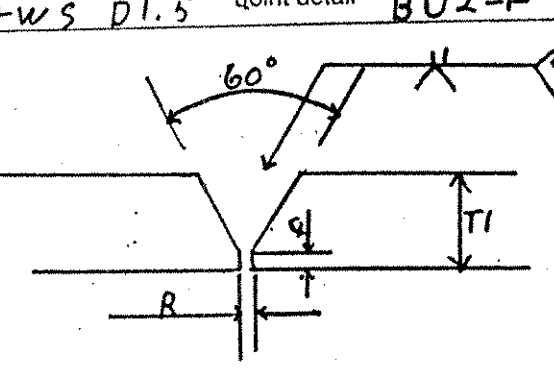
Fax: (207) 772-0580

WELDING PROCEDURE SPECIFICATION

Material specification A36-A572-A588 (ASTM 709 Gr 36-50-50w)  
 Welding process Flux Cored Arc welding (FCAW)  
 Manual or machine Semi-AUTO  
 Position of welding FLAT-1G  
 Filler metal specification AWS A5-20  
 Filler metal classification E71T-1  
 Flux AAA  
 Shielding gas 75% AR 25% CO<sub>2</sub> Flow rate 40 ± 5  
 Single or multiple pass Both Electrode stick out 3/4 ± 1/4  
 Single or multiple arc Single  
 Welding current Direct Current  
 Polarity Reverse Electrode positive  
 Welding progression see detail  
 Root treatment see detail  
 Preheat and interpass temperature To 3/4-50° (1/4-10°) + 3/4 to 1/2-70° (+19 to 38-20°)  
 Postheat temperature NA  
 Heat Input Min NA Max NA

Rochester VT  
 Proj. BRF-0241(33)1/6  
 BP 31 - CBSS

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Notes
		Amperes	Volts		
	1/16	±28 25	±1.7 11	±1.1	AWS D1.5 Joint detail BU2-F  T1 - UNLIMITED P - 0 To 1/8 / 0 To 3.2mm R - 0 To 1/8 / 0 To 3.2mm 1-Grind as required
	1/6	±28 280	±1.7 25	±28	

This procedure may vary due to fabrication sequence, fitup, pass size, etc., within the limitation of variables given in applicable A.W.S. codes or contract specifications

Procedure no. 104 Contractor Casco Bay Steel  
 Revision no. \_\_\_\_\_ Authorized By Paul E Goodale  
 Form III-2 AWS-QC1 Paul E. Goodale Date 2/2/99  
 8310201 C.W.I. (67)