

Casco Bay Steel Structures, Inc.

75 Spring Hill Road
Saco, Maine 04072

Phone: (207) 282-7360

Fax: (207) 282-1179

WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A709/A709M-Gr.36-50-50w(250-345-345w)
 Welding process STUD WELDER
 Manual or machine MACHINE
 Position of welding FLAT
 Filler metal classification NA
 Flux NA
 Shielding gas NA Flow rate NA
 Single or multiple pass SINGLE
 Single or multiple arc SINGLE
 Welding current DC EN
 Polarity DC EN
 Welding progression NA
 Root treatment Clean surface to be welded
 Preheat and interpass temperature To 3/4" 50° 3/4" to 1/2" 70° 1/2" to 2/4" 150° over 2 1/2" 205°
 Postheat temperature NA
 Heat input Min NA Max NA

RECEIVED
MAR 21 2008

By: R. Thel VT
 Proj: BRF-0241(32)06
 Rev: 31 - C.B.S.S. 2/27

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
	STUD size		Weld Time		AWS D1-1 Joint detail AWS D1-5
	1/2	350 650	.35 [±]		<p>NOTE: This procedure is only a guide to setup.</p>
	5/8	350 650	.35 [±]	NA	
	3/4	550 750	.40 [±]		
	7/8	650 850	.10 [±]		

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. # I S.W. Contractor Casco Bay Steel
 Revision no. _____ Authorized By [Signature]
 Form IIS-2 Date May 3-1998

