

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709/A709M Grade-36(250), 50(345), 50W(345w)
 Welding process Flux Cored Arc welding
 Manual or machine Semi-Auto
 Position of welding Flat (1F) Horizontal (2F)
 Filler metal specification AWS-A5-29
 Filler metal classification E81T1-N11 - LINCOLN OUTERSHIELD 81W11-H
 Flux NA
 Shielding gas 75% AR / 25% CO₂ Flow rate 35CFH +8.6 = -3.5
 Single or multiple pass Single and Multiple
 Single or multiple arc Single
 Welding current Direct
 Polarity Reverse Electrode Positive
 Welding progression See Joint Detail
 Root treatment See AWS SPECIFICATION
 Preheat and interpass temperature 30(19) to 34(19) To 1 1/2(3F) 70(20) 1 1/2(3F) To 2 1/2(6.3) 150(65)
 Postheat temperature NA 2 1/2(6.3) 225(110)
 Heat Input Min 28.6 Max 45.0 ST OF VT AOT
40.9 RQR 2 (11.8) (1.8 kJ/in) Springfield-BR 64
(1.6 kJ/in) (Metric) Proj BHF 016-204

Pass no.	Electrode size	Welding current		Travel speed	AWS D1-5	Joint detail
		Amperes	Volts			
AS Req	1/16	275 (247.5 302.5)	28.8 (26.8 30.8)	11.6 (10.4 12.8)	1F	
		275 (247.5 302.5)	28.8 (26.8 30.8)	294.6 (264.2 325.12)		

TRAVIS
RECEIVED
CHK'D BY JWC OK'D BY JWC
 JUN 29 2009
 REQUEST APPROVED
 BY Cue DATE 7/9/09

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 Paul E. Woodale
 Form III-2 Date _____