

CASCO BAY STEEL STRUCTURES, LLC.

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WELDING PROCEDURE SPECIFICATION

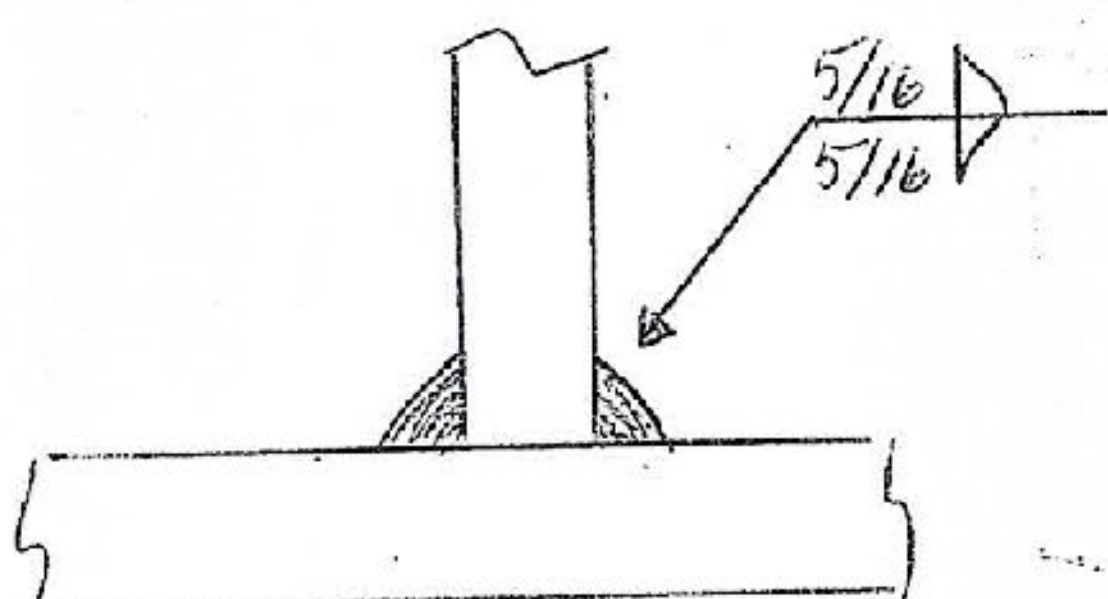

Material specification ASTM-A240-04 304/304L OR 250-345-345W
 Welding process Flux Cored Arc welding (FCM)
 Manual or machine Semi AUTO
 Position of welding Flat-Horizontal
 Filler metal specification AWS A5-29
 Filler metal classification E81T1-N11-H4 ESAB
 Flux NA
 Shielding gas 75% AR - 25% CO₂ Flow rate 35 CFH ± 4
 Single or multiple pass single / multiple Elec Ex 5/8 ± 1/4
 Single or multiple arc single
 Welding current DC
 Polarity DCEP
 Welding progression See detail
 Root treatment wire brush - area to be free of loose scale, slag, rust & moisture
 Preheat and interpass temperature To 20 (34) 10(50), 80 (34) To 40 (1 1/2) 20(20), 40 (1 1/2) To 60 (2 1/2) 65 (150)
 Postheat temperature NA over 60 (2 1/2) 110 (225)
 Heat Input Min 27.7 kJ/in Max 43.6 kJ/in PQR FCM #8 39.6 kJ/in

WELDING PROCEDURE

VERMONT-ACT
BENNINGTON - Ramp AFD
BR. NO. BKS-N
PROJ. NO. AC-NH-019-1 (51)
CLASS. NO. 408-152
Joint detail FILE

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
		287	29	13
	1/16	258	26.8	11.4
		To	To	To
		315	31	14

CK'D BY _____ OK'D BY JWC
OCT 03 2009
 RELEASHT _____ APPROVED ✓
 BY _____ DATE 10/27/09

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
 Revision no. _____

Contractor Casco Bay Steel
 Authorized By Paul E. Goodale
 Date 12-6-06