

Casco Bay Steel Structures, Inc.

5 Industry Road
South Portland, Maine 04106

one: (207) 772-2533

Fax: (207) 772-0580

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 (1F), Horizontal (2F)
 Filler metal specification AST/AWS A5.1 - A5.5
 Filler metal classification E7018 - 8018 3/16 - 7028
 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 MEET AWS SPECIFICATION
 Preheat and interpass temperature To 3/4(19) 50°F(10°) 3/4(19) To 1/2(38) 70°F(20°) 1/2(38) To 2 1/2(63.5) 150°F(65°)
over 2 1/2(63.5) 225°F(110°)
 Postheat temperature NA
 Heat Input Min NA Max NA

V. TRAWS
RECEIVED
OCT 09 2009
APPROVED
DATE 10/27/09

VERMONT-AOT
Bennington - Ramp AFD
Br NO. BKS-N
Proj NO. AC-NH-019-1(51)
CHSS NO. HCPA-152

WELDING PROCEDURE

(Metric)

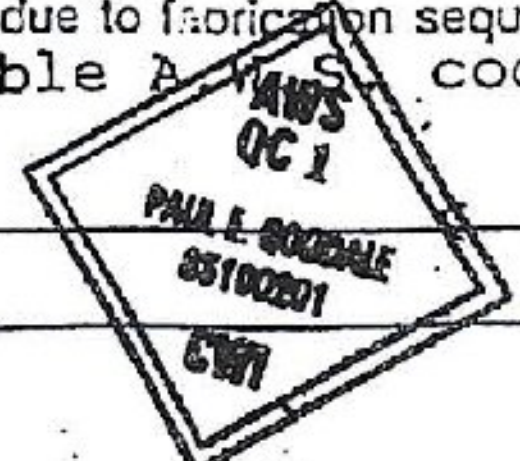
Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5	Joint detail
		Amperes	Volts			
AS	7018 1/8 (3.2)	70-170	22-26	AS	1F	Fillet
	5/32 (3.9)	120-225	22-26			
	3/16 (4.8)	170-300	24-27			
REQ.	8018 1/8 (3.2)	90-160	22-26	REQ.	2F	Fillet
	5/32 (3.9)	120-225	22-26			
	3/16 (4.8)	180-290	24-27			
REQ.	7028 5/32 (3.9)	170-270	22-26	REQ.	Fillet	Fillet
	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 AWS codes or contract specifications

Procedure no. 401

Revision no. _____

Form III-2



Contractor Casco Bay Steel

Authorized By Paul E. Hoodale

Date 3/2/00