

Casco Bay Steel Structures, Inc.

WELDING PROCEDURE SPECIFICATION

Material specification ASTM Gr 50-50W
 Welding process Shielded Metal ARC
 Manual or machine Manual
 Position of welding Flat, Horizontal
 Filler metal specification AST/AWS A5.1-A5-5
 Filler metal classification E 7018 - E 8018 C/C3
 Flux NA
 Shielding gas NA Flow rate NA
 Single or multiple pass single & multiple
 Single or multiple arc Single
 Welding current AC/DC
 Polarity STRAIGHT & REVERSE
 Welding progression See Detail
 Root treatment Grind - Wire brush - Area Free of slag - RUST - MOISTURE
 Preheat and Interpass temperature _____
 Postheat temperature NA
 Heat Input Min NA Max NA



VTrans
 Received
 OK'd by JWX
 DEC 12 2013
 APPROVED
 DATE 11/17/13

Minimum Preheat and Interpass Temperature, °C [°F]

| Welding Process (Base Metal) | Thickness of Thickest Part at Point of Welding, mm [in.] | | | |
|---|--|---|---|------------------------|
| | To 20 mm [3/4 in.] Incl. | Over 20 mm [3/4 in.] to 40 mm [1-1/2 in.] Incl. | Over 40 mm [1-1/2 in.] to 65 mm [2-1/2 in.] Incl. | Over 65 mm [2-1/2 in.] |
| SAW; OMAW; FCAW; SMAW (E270M [E270] [A 709M [A 709] Or, 250 [36], 345 [50], 345W [50W], HPS 345W [HPS 50W]) | 10 [50] | 20 [70] | 65 [150] | 110 [225] |

VERMONT AOT
 CAVENDISH VT RTE 131
 OVER TWENTYMILE STREAM
 PROJ # ER BRP 0146 (13)
 CBSS Job No. 541

WELDING PROCEDURE

| Pass no. | Electrode size | Welding current | | Travel speed |
|-----------|----------------|-------------------|--------------|---|
| | | Amperes | Volts | |
| AS REQ | <u>7018</u> | | | AWS D1.5 Joint detail Fillet <u>2F</u>  <u>3/16 to 5/16</u> <u>1F</u>  <u>3/16 to 3/8</u> |
| | <u>1/8</u> | <u>70 to 170</u> | <u>22-26</u> | |
| | <u>5/32</u> | <u>120 to 225</u> | <u>22-26</u> | |
| | <u>3/16</u> | <u>170 to 300</u> | <u>24-27</u> | |
| | <u>8018</u> | | | |
| | <u>1/8</u> | <u>90 to 160</u> | <u>22-26</u> | |
| | <u>5/32</u> | <u>120 to 225</u> | <u>22-26</u> | |
| | <u>3/16</u> | <u>180 to 290</u> | <u>24-27</u> | |

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. 401
 Revision no. _____
 Contractor Casco Bay Steel
 Authorized By Paul E. Dondait
 Date April 13, 2012