Casco Bay Steel Structures

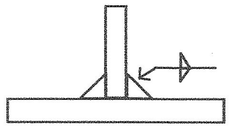
One Wallace Avenue, South Portland ME 04106

AWS - Welding Procedure Specification (WPS)

WeldOffice WPS

WPS record number	250	Revision		Qualified to	AWS D1.5
Date	6/10/2014			Company name	Casco Bay Steel Structures

JOINTS: Typical joint(s). See actual production drawings and engineering specifications for details.



3/8 single pass flat
5/16 single pass Horizontal

	Amps		Volts		Travel Speed
AVG	363.3	/	31.6	/	12.8
MIN	326.9	/	29.4	/	10.8
MAX	399.6	/	33.8	/	14.7

*** Multiple passes may be used if drawing details call for a larger size fillet weld than noted above in the position welding is being performed**

Type of groove	Fillet weld	Minimum groove angle	(deg.)	N/A
		Minimum root opening	(in.)	N/A
		Maximum root face	(in.)	N/A

PREHEAT TABLE

Applicable standard	
AWS D1.5 Bridge Welding Code	For thickness 1/8 to 3/4(in.): 50(°F). Preheat to 70(°F) if the base metal temperature is below 32(°F). Over 3/4 thru 1-1/2(in.): 70(°F). Over 1-1/2 thru 2-1/2(in.): 150(°F). Over 2-1/2(in.): 225(°F). Refer to AWS D1.5 2010 Table 4.3 (pg 85)
AWS D1.5 2010 FCM	For thickness 1/8 to 3/4(in.): 100°F). Over 3/4 thru 1-1/2(in.): 200(°F). Over 1-1/2 thru 2-1/2(in.): 300(°F). Over 2-1/2(in.): 350(°F). No welding to be done if ambient temperature in immediate area is below 0(°F)
New York SCM	Up to 3/4 ----------100 (F) Over 3/4 to 1-1/2 ----------200 (F) Over 1-1/2 to 2-1/2 --------300 (F) Over 2-1/2 ----------350 (F)

TECHNIQUE

Supplementary MF control	
Peening	Not used
Surface preparation	Grind/Blast/chemical/wirebrush clean to be free of moisture, slag, millscale, oils, dust
Initial/interpass cleaning	Brushing and Grinding
Back gouging method	None

NOTES

AWS FCM preheats are taken from AWS D1.5 2010 Clause 12 Table 12.4 and are based upon calculated heat input calculated in accordance with section 5.12 with an as welded H8 designation for the electrode combination we are using. This higher preheat will be used on non weathering steels also.

Vermont Agency of Transportation
RECEIVED
CK'D BY _____ OK'D BY Rob Young
April 4, 2016
RESUBMIT NO Approved
BY Rob Young DATE 04/08/2016

Signature 1

Name	Signature
Matthew Cote	Matthew J Cote CWI 08051341 QC1 EXP. 5/1/2017
Date	
6/10/14	

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Date	

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Date	

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Date	