



Casco Bay Steel Structures
 One Wallace Ave, South Portland ME 04106
AWS - Prequalified Welding Procedure Specification (pWPS)
 WeldOffice WPS

Company name	Casco Bay Steel Structures
Welding process	SMAW
Process type	Manual

Joint design used	
Joint type	T - T joint
Joint design	Fillet Weld
Backing	No
Backing material	Not Applicable
Root opening (R)* (in.)	
Root face (f)* (in.)	
Groove angle (a)* (deg.)	
Radius (J - U)* (deg.)	
Back gouging	No
Back gouging method	None

Base metals * Datum, As Detailed (As Fit-Up)	
Spec., type or grade	Gr 50/ Gr50W
Thickness: Groove (in.)	
Fillet (in.)	1/8" and above
Diameter (Pipe) (in.)	

Filler metals	
AWS Specification	A5.5
AWS Classification	E-8018 H4R

Shielding	
Flux	-
Electrode-flux (class)	-
Gas composition	-
Gas flow rate (cfh)	-
Gas cup size (in.)	-

Welding procedure

Layer	Pass	Process	Filler metal class	Filler metal diameter (in.)	Current type / polarity	Amps	Wire feed speed (in./min)	Volts	Travel speed (in./min)	Joint details
1	All	SMAW	E-8018 H4R	1/8	DCEP	100-160	-	n/a	varies	
1	All	SMAW	E-8018 H4R	1/8	AC	90-160	-	n/a	varies	
1	All	SMAW	E-8018 H4R	5/32	DCEP	140-210	-	n/a	varies	
1	All	SMAW	E-8018 H4R	5/32	AC	130-210	-	n/a	varies	
1	All	SMAW	E-8018 H4R	3/16	DCEP	200-300	-	n/a	varies	
1	All	SMAW	E-8018 H4R	3/16	AC	180-300	-	n/a	varies	

Designation **FILLET**

Notes

LINCOLN ELECTRIC EXCALIBUR 8018-C3 MR
 SEE BACKSIDE FOR MORE DETAILS

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		Signature 2	
Name	Signature	Name	Signature
Matthew J Cote			
Date		Date	
7/22/2014	Matthew J Cote CWI 08051341 OC1 EXP 5/1/2017		
Signature 3		Signature 4	
Name	Signature	Name	Signature
Date		Date	