



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

WPS record number	664	Revision	Qualified to	AWS D1.5
Date	5/06/2016		Company name	Casco Bay Steel Structures
Supporting PQR(s)	613 FCM			
Reference docs.				

Scope	Groove
Joint	Joint details for this welding procedure specification in JOINTS section of this WPS

BASE METALS				THICKNESS RANGE QUALIFIED (n)			
Type	Gr 50	P-no.	Grp-no.	As-welded		With PWHT	
Welded to	Gr 50	P-no.	Grp-no.	Min.	Max.	Min.	Max.
Backing:	None	P-no.	Grp-no.	Complete pen.	-	-	-
Retainers				Impact tested	-	-	-
Notes				Partial pen.	-	-	-
				Fillet welds	-	-	-

FILLER METALS				DIAMETER RANGE QUALIFIED (n)			
SFA	Classification	F-no.	A-no.	As-welded		With PWHT	
				Min.	Max.	Min.	Max.
GMAW	E70C-6MH4	6					
Sup. filler	-	-	-				

FILLER METALS				THICKNESS RANGE QUALIFIED (n)			
SFA	Classification	F-no.	A-no.	As-welded		With PWHT	
				Min.	Max.	Min.	Max.
GMAW	E70C-6MH4	6					
Sup. filler	-	-	-				

WELDING PROCEDURE		GMAW
Welding process		Semi-automatic
Type		SEE BACKPAGE
Minimum preheat/interpass temperature (°F)		390 F
Maximum interpass temperature (°F)		.052
Filler metal size (n)		F,H
Layer number		Not applicable
Position		DCEP (reverse polarity)
Weld progression		296
Current/polarity		29.1
Amperes		13.1
Volts		39.5
Travel speed (in/min)		
Maximum heat input (kJ/in)		
Wire feed speed (in/min)		
Arc transfer mode		Spray
Shielding: Gas type		Argon/CO2, 90/10
Flow rate (cfh)		35
Trailing: Gas type		
Flow rate (cfh)		
Backing: Gas type		
Flow rate (cfh)		
String or weave		Stringer or Weave
Orifice/gas cup size		5/8
C.T.W.D (in)		Single or Multiple passes
Multi/Single pass per side		Single electrode
Multi/Single electrode		
Maximum pass thickness (in)		E70C-6MH4
Weld deposit chemistry		
Notes		

*Approved for
 Waitsfield Hopper
 5/13/16 RSP*