



**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	5/09/2016		Company name	Casco Bay Steel Structures

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

	<b>PARAMETERS</b>			
		<b>A</b>	<b>V</b>	<b>TS</b>
	rqd	296	29.1	13.1
	max	325.6	31.1	15.1
	min	266.4	27.1	11.1
<b>TC-P6-GF</b>				
Fillet weld may be placed on second side as required by plans				

Type of groove	Single-U-groove PJP	Minimum groove angle	(deg)	15
		Minimum root opening	(in)	0
		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)

**TECHNIQUE**

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	Grinding or Air Carbon Arc Gouging

**NOTES**

5/13/16  
RSF

Signature 1	Signature	Signature 2	Signature
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