



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

WPS record number	653	Revision	Qualified to	AWS D1.5
Date	10/5/2015		Company name	Casco Bay Steel Structures

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

	PARAMETERS			
		A	V	TS
	rqd	296	29.1	13.1
	max	326.6	31.1	15.1
	min	266.4	27.1	11.1
B-U2-GF				

Type of groove	Single-V-groove	Minimum groove angle	(deg)	40
		Minimum root opening	(in)	0
		Maximum root face	(in)	3/16

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
RSP

Signature 1		Signature 2	
Name	Signature	Name	Signature
Matthew J Cote			
Date		Date	
10/5/15			
Signature 3		Signature 4	
Name	Signature	Name	Signature
Date		Date	

Matthew J Cote
 CWI 08051341
 QC1 EXP 5/1/2017