



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

WPS record number	661	Revision	Qualified to	
Date	6/23/2015		Company name	
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 (in)			
Type	Gr 50	P-no.	Grp-no.	As-welded		With PWHT	
Welded to	Gr 50	P-no.	Grp-no.	Min.	Max.	Min.	Max.
Backing:	as reqd	P-no.	Grp-no.	-	-	-	-
Retainers				-	-	-	-
Notes				-	-	-	-

DIAMETER RANGE QUALIFIED (in)			
As-welded		With PWHT	
Min.	Max.	Min.	Max.
-	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-

FILLER METALS						THICKNESS RANGE QUALIFIED (in)			
	SFA	Classification	F-no.	A-no.	Chemical analysis or Trade name	As-welded		With PWHT	
						Min.	Max.	Min.	Max.
GMAW	5.36	E70C-6MH4	6		ESAB Core Weld CG	-	-	-	-
Sup. filler	-	-	-	-	-	- None -			

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

*Approved For
 Waitfield Joint
 RSF 5/13/16*