



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	

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	18.1
	min	266.4	27.1	11.1
TC-P4-GF				

Type of groove	Single-bevel-groove PJP	Minimum groove angle	(deg)	40
		Minimum root opening	(in)	0
		Maximum root face	(in)	AS NOTED

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	Not applicable

NOTES

6/23/15
MJC

Signature 1	Signature 2
Name: <i>Matthew Cote</i>	Name: _____
Date: <i>6/23/15</i>	Date: _____
Signature 3	Signature 4
Name: _____	Name: _____
Date: _____	Date: _____

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