



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

WPS record number Date	201 4/24/2014	Revision 2	Qualified to Company name	AWS D1.5 Casco Bay Steel Structures
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JOINTS: Typical joint(s). See actual production drawings and engineering specifications for details.

	5/16 single pass Horizontal	CBSS 696 RT 110 over 1st Branch White River Br #9 Proj BHF 0169(9) CBSS 697 RT 110 over South Washington Brook Br #11 Proj BHF 169(10) Chelsea, VT														
	<table border="1"> <thead> <tr> <th></th> <th>Amps</th> <th>Volts</th> <th>Travel Speed</th> </tr> </thead> <tbody> <tr> <td>AVG</td> <td>604 /</td> <td>29.5 /</td> <td>17.1 IPM</td> </tr> <tr> <td>MIN</td> <td>569 /</td> <td>27.4 /</td> <td>15.5 IPM</td> </tr> <tr> <td>MAX</td> <td>625.1 /</td> <td>31.0 /</td> <td>18.7 IPM</td> </tr> </tbody> </table>			Amps	Volts	Travel Speed	AVG	604 /	29.5 /	17.1 IPM	MIN	569 /	27.4 /	15.5 IPM	MAX	625.1 /
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<p>CK'D BY R. Foster OK'D BY R. Foster March 8, 2017 RESUBMIT No Approved BY Kristin Higgins DATE 3/10/2017</p>																

Type of groove	Fillet weld	Minimum groove angle (deg.)	N/A
		Minimum root opening (in.)	N/A
		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)
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TECHNIQUE

Supplementary MF control	
Peening	
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	None

NOTES

Signature 1		Signature 2	
Name	Signature	Name	Signature
Matthew Cote			
Date		Date	
6/2/2014	Matthew J. Cote CWI 08051341 QC1 EXP. 5/1/2017		
Signature 3		Signature 4	
Name	Signature	Name	Signature
Date		Date	