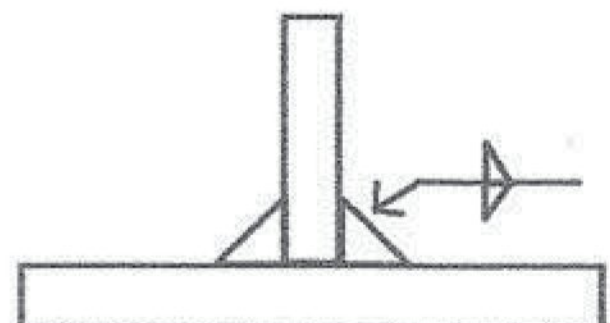





**Casco Bay Steel Structures**  
 One Wallace Avenue, South Portland ME 04106  
**AWS - Welding Procedure Specification (WPS)**  
 WeldOffice WPS

WPS record number	250	Revision	1	Qualified to	AWS D1.5
Date	6/10/2014	Company name			Casco Bay Steel Structures

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

	<b>5/16 single pass Horizontal</b>	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>363.3 /</td> <td>31.6</td> <td>/ 12.8</td> </tr> <tr> <td>MIN</td> <td>324.9 /</td> <td>29.9</td> <td>/ 11.7</td> </tr> <tr> <td>MAX</td> <td>379.2 /</td> <td>33.2</td> <td>/ 13.5</td> </tr> </tbody> </table>			Amps	Volts	Travel Speed	AVG	363.3 /	31.6	/ 12.8	MIN	324.9 /	29.9	/ 11.7	MAX	379.2 /
	Amps	Volts	Travel Speed													
AVG	363.3 /	31.6	/ 12.8													
MIN	324.9 /	29.9	/ 11.7													
MAX	379.2 /	33.2	/ 13.5													
																

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)

**TECHNIQUE**

Supplementary MF control	Not used
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

Signature 1	Signature 2
Name	Name
Matthew Cote	
Date	Date
6/10/14	
Signature 3	Signature 4
Name	Name
Date	Date


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