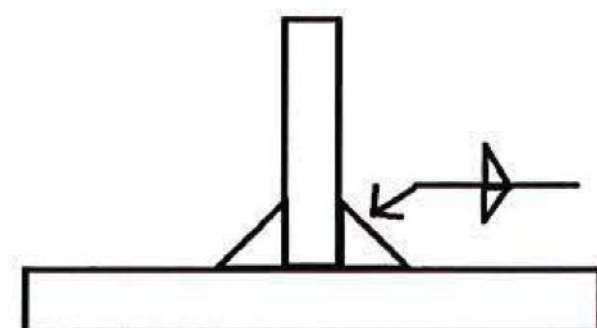




**Casco Bay Steel Structures**  
 One Wallace Avenue, South Portland ME 04106  
**AWS - Welding Procedure Specification (WPS)**  
 WeldOffice WPS

WPS record number	603	Revision	Qualified to
Date	6/23/2015		Company name

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



	A	V	TS
rqd	296	29.1	13.1
max	325.6	31.14	14.41
min	294.9	28.51	12.835

**SIZES**  
**FLAT-1/2 MAX**  
**HORIZONTAL-3/8**  
**\*\*MULTIPLE PASSES ARE**  
**REQUIRED IF LARGER SIZE**  
**FILLET WELD IS REQUIRED\*\***

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

Type of groove	Fillet weld	Minimum groove angle (deg)	
		Minimum root opening (in.)	
		Maximum root face (in.)	

**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).
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Only qualified for  
 1/2" multi-pass,  
 and 5/16" single  
 pass.

Vermont Agency of Transportation  
**RECEIVED**

CK'D BY R. Foster OK'D BY R. Foster  
 March 8, 2017

RESUBMIT No Approved AsNoted  
 BY Kristin Higgins DATE 3/10/2017

**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**

Empty box for notes.

Signature 1 Name: Matthew Cote Date: 6/23/15	Signature  Matthew J Cote CWI 08051341 QC1 EXP. 5/1/2017	Signature 2 Name: _____ Date: _____	Signature Name: _____ Date: _____
Signature 3 Name: _____ Date: _____	Signature Name: _____ Date: _____	Signature 4 Name: _____ Date: _____	Signature Name: _____ Date: _____