



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

WPS record number	201	Revision	2	Qualified to	AWS D1.5
Date	4/24/2014	Company name	Casco Bay Steel Structures		

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

	5/16 single pass Horizontal		
	Amps	Volts	Travel Speed
	AVG 604 /	29.5 /	17.1 IPM
	MIN 569 /	27.4 /	15.5 IPM
	MAX 625.1 /	31.0 /	18.7 IPM

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	
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

Vermont Agency of Transportation
RECEIVED
 CK'D BY _____ OK'D BY RSF
 May 7, 2017
 RESUBMIT No **Approved**
 BY C. Carlson DATE 05/09/2017

Signature 1		Signature 2	
Name	Matthew J Cole	Name	
Date	6/2/2014	Date	
Signature 3		Signature 4	
Name		Name	
Date		Date	

