



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

WPS record number Date	204 4/22/2014	Revision 2 4.14.17	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.

	<table border="1"> <tr> <td>Amps</td> <td>Volts</td> <td>Travel Speed</td> </tr> <tr> <td>AVG 604 /</td> <td>29.5 /</td> <td>17.1 IPM</td> </tr> <tr> <td>MIN 569 /</td> <td>27.4 /</td> <td>15.5 IPM</td> </tr> <tr> <td>MAX 625.1 /</td> <td>31.0 /</td> <td>18.7 IPM</td> </tr> </table>	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													
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Type of groove	Double-V-groove	Minimum groove angle (deg)	55 to 70
		Minimum root opening (in.)	0 to 1/16
		Maximum root face (in.)	varies

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.): 150(°F). Over 1-1/2 thru 2-1/2(in.): 225(°F). Over 2-1/2(in.): 300(°F). Refer to AWS D1.5 2010 Table 4.3 (pg 85)
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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	Air carbon arc

NOTES

Vermont Agency of Transportation

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CK'D BY _____ OK'D BY RSF

May 7, 2017

RESUBMIT No Approved
 BY C. Carlson DATE 05/09/2017

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