



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.

	5/16 single pass Horizontal			
		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	Grind/Blast/chemical/wirebrush clean to be free of moisture, slag, millscale, oils, dust
Surface preparation	Brushing and Grinding
Initial/interpass cleaning	None
Back gouging method	None

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	6/10/14	Date	
Signature 3	Signature	Signature 4	Signature
Name		Name	
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