

Casco Bay Steel Structures, Inc.

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A570-50W
 Welding process Shielded Metal ARC
 Manual or machine Manual
 Position of welding Flat, Horizontal
 Filler metal specification AWS/A5.1-A5-5
 Filler metal classification E7018-E8018 C/C3
 Flux NA
 Shielding gas NA Flow rate NA
 Single or multiple pass single & multiple
 Single or multiple arc single
 Welding current AC/DC
 Polarity STraight & Reverse
 Welding progression See Detail
 Root treatment Grind-wire brush-Area Free of Slag-RUST-Moisture
 Preheat and interpass temperature _____
 Postheat temperature NA
 Heat Input Min NA Max NA

VTrans
 Received
 CK'D OK'd BY JWC

Minimum Preheat and Interpass Temperature, °C [°F]

Welding Process (Base Metal)	Thickness of Thickest Part at Point of Welding, mm [in]			
	To 20 mm [3/4 in] Incl.	Over 20 mm [3/4 in] to 40 mm [1-1/2 in] Incl.	Over 40 mm [1-1/2 in] to 65 mm [2-1/2 in] Incl.	Over 65 mm [2-1/2 in]
SAW; GMAW; FCAW; SMAW (M270M [M270] [A 709M [A 709]], Cr. 250 [36], 345 [50], 345W [50W], HPS 345W [HPS 50W])	10 [50]	20 [70]	65 [150]	110 [225]

APR 05 2013

Resubmit BY _____ APPROVED DATE 4/5/13

Vermont AOT
 Cambridge B# 21
 Proj NO. ARE-027-1(4)
 CBSS-524

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail
		Amperes	Volts		
AS	7018	70 To 170	22-26	AS	AWS D1.5 Joint detail Fillet
	5/32	120 To 225	22-26		
Reg	3/16	170 To 300	24-27	Reg	3/16 To 5/16
	8018	90 To 160	22-26		
	1/8	120 To 225	22-26		1F
	5/32	150 To 290	24-27		
	3/16				3/16 To 3/8

This procedure may vary due to fabrication sequence, fit up, pass size, etc., within the limitation of variables given in applicable A.W.S. codes or contract specifications.

Procedure no. 401
 Date _____
 Contact for _____
 Approved by _____
 Date _____