

# Casco Bay Steel Structures, Inc.

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## WELDING PROCEDURE SPECIFICATION

Material specification ASTM A109 Gr 36-50-50W (250-345-345W)  
 Welding process Shielded Metal Arc Welding (SMAW)  
 Manual or machine Manual  
 Position of welding FLAT (1F), HORIZONTAL (2F)  
 Filler metal specification ANSI/AWS A5.1 - A5.5  
 Filler metal classification E7018 - 8018 C/C3 - 7028  
 Flux NA  
 Shielding gas NA Flow rate NA  
 Single or multiple pass Single and multiple  
 Single or multiple arc single  
 Welding current AC/DC  
 Polarity STRAIGHT / Reverse  
 Welding progression \_\_\_\_\_  
 Root treatment MEET AWS SPECIFICATION  
 Preheat and interpass temperature To 3/4(19) 50°F (10°C) 3/4(19) To 1 1/2(38) 70°F (20°C) 1 1/2(38) To 2 1/2(63.5) 150°F (65°C)  
 Postheat temperature NA  
 Heat Input Min NA Max NA

VT TRANS RECEIVED  
 OK'D BY JWC  
 SEP 21 2009  
 APPROVED  
 DATE 9/21/09

## WELDING PROCEDURE

VT-A.C.T.  
 Moretown-Middlesex  
 Proj No C284(14)  
 CBSS No 421

(Metric)

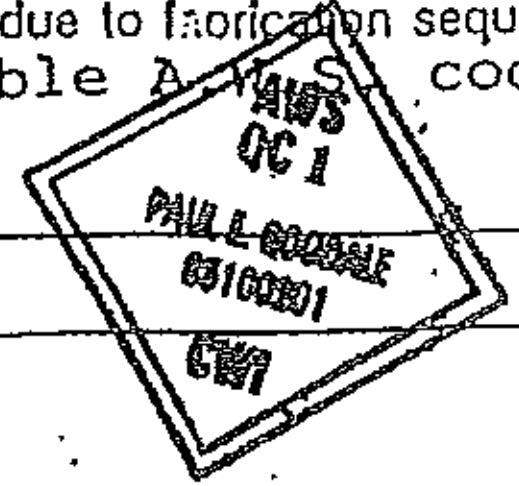
| Pass no. | Electrode size        | Welding current |       | Travel speed | AWS D1.5 joint detail   |
|----------|-----------------------|-----------------|-------|--------------|---|
|          |                       | Amperes         | Volts |              |   |
| AS REQ.  | 7018<br>1/8<br>(3.2)  | 70-170          | 22-26 | AS REQ.      | 1F<br><br>3/16 To 3/8 (5 To 10)    3/8 To 1/2 (10 To 13)    1/2 To 5/8 (13 To 16) |
|          | 5/32<br>(3.9)         | 120-225         | 22-26 |              |   |
|          | 3/16<br>(4.8)         | 170-300         | 24-27 |              |   |
|          | 8018<br>1/8<br>(3.2)  | 90-160          | 22-26 |              |   |
|          | 5/32<br>(3.9)         | 120-225         | 22-26 |              |   |
|          | 3/16<br>(4.8)         | 180-290         | 24-27 |              |   |
| AS REQ.  | 7028<br>5/32<br>(3.9) | 170-270         | 22-26 | AS REQ.      | 2F<br><br>3/16 To 5/16 (5 To 8)    3/8 (10)    7/16 To 5/8 (11 To 16)             |
|          | 3/16<br>(4.8)         | 210-330         | 24-27 |              |   |

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

Procedure no. 401

Revision no. \_\_\_\_\_

Form III-2



Contractor Casco Bay Steel

Authorized By Paul E. Hoodale

Date 3/2/00