

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A572-50 (250-345-345W)
 Welding process Shielded Metal Arc Welding (SMAW)
 Manual or machine Manual Hot
 Position of welding Flat (1G) Horizontal (2G) Vertical (3G) Overhead (4G)
 Filler metal specification A572 AWS E50-5
 Filler metal classification E7018-B01R023-7028 OK'D BY _____
 Flux NA Flow rate NA MAR 08 2005
 Shielding gas NA
 Single or multiple pass Single and multiple RESUBMIT APPROVED ✓
 Single or multiple arc Single
 Welding current AC D.C. BY _____ DATE 3-17-05
 Polarity Straight / Reverse
 Welding progression _____
 Post treatment To AWS specification
 Preheat and interpass temperature To 34(19) 50(10) 34(19) 40(14) 200(20)
 Postheat temperature _____
 Heat input Min NA Max NA Proj: # 085-0147(52)
Royalton VT
CBS-250

(METRIC)

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amps	Volts		
AS	7018 1/8 (3.2)	70-170	22-26	AS REQ	
	5/32 (3.9)	120-225	22-26		
REQ	8018 1/8 (3.2)	90-160	22-26		
	5/32 (3.9)	120-225	22-26		
	7028 5/32 (3.9)	170-270	22-26		

Tl = UNLIMITED, Note - Omitting Flux

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. 407 Contractor Casco Bay Steel
 Revision no. _____ Authorized By Paul S. ...
 Form III-2 _____ 10-16-01