

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification: ASTM A109 Gr 36-50 (250-345-345W)
 Welding process: Shielded Metal Arc Welding (SMAW)
 Manual or machine: Manual
 Position of welding: Flat (1F), Horizontal (2F)
 Filler metal specification: E7018 AWS A5.1 - E7018 AWS A5.5
 Filler metal classification: E7018 - R018 5/32 - 7/32
 Flux: NA
 Shielding gas: NA Flow rate: NA
 Single or multiple pass: Single and multiple
 Single or multiple arc: Single
 Welding current: AC/D
 Polarity: Straight/Reverse
 Welding progression: NA
 Root treatment: Met AWS Specification
 Preheat and interpass temperature: 3/4(19) to 1(18) 3/4(19) to 1(18) 1(18) to 1 1/2(32) 1 1/2(32) to 2(35) 2(35) to 2 1/2(45) 2 1/2(45) to 3(48) 3(48) to 3 1/2(55) 3 1/2(55) to 4(60) 4(60) to 4 1/2(65) 4 1/2(65) to 5(70) 5(70) to 5 1/2(75) 5 1/2(75) to 6(80) 6(80) to 6 1/2(85) 6 1/2(85) to 7(90) 7(90) to 7 1/2(95) 7 1/2(95) to 8(100) 8(100) to 8 1/2(105) 8 1/2(105) to 9(110) 9(110) to 9 1/2(115) 9 1/2(115) to 10(120) 10(120) to 10 1/2(125) 10 1/2(125) to 11(130) 11(130) to 11 1/2(135) 11 1/2(135) to 12(140) 12(140) to 12 1/2(145) 12 1/2(145) to 13(150) 13(150) to 13 1/2(155) 13 1/2(155) to 14(160) 14(160) to 14 1/2(165) 14 1/2(165) to 15(170) 15(170) to 15 1/2(175) 15 1/2(175) to 16(180) 16(180) to 16 1/2(185) 16 1/2(185) to 17(190) 17(190) to 17 1/2(195) 17 1/2(195) to 18(200) 18(200) to 18 1/2(205) 18 1/2(205) to 19(210) 19(210) to 19 1/2(215) 19 1/2(215) to 20(220) 20(220) to 20 1/2(225) 20 1/2(225) to 21(230) 21(230) to 21 1/2(235) 21 1/2(235) to 22(240) 22(240) to 22 1/2(245) 22 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