

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification A96-A572-55 (ASTM A99 Gr 36-50-50w)
 Welding process Flux Cored Arc Welding (FCAW)
 Manual or machine Stick
 Position of welding Flat-1G
 Filler metal specification AWS A5-20
 Filler metal classification E70T-1
 Flux NA
 Shielding gas 75% Ar 25% CO₂ Flow rate 40-55
 Single or multiple pass BATH Electrode stick out 3/4-1 1/4
 Single or multiple arc SINGLE
 Welding current DIRECT CURRENT
 Polarity Reverse Electrode Positive
 Welding progression see detail
 Root treatment see detail
 Preheat and interpass temperature see detail
 Postheat temperature see detail
 Heat input Min NA Max NA

Proj: #085-0147(2)S
 RAYBURN VT
 C.B.S.S-250

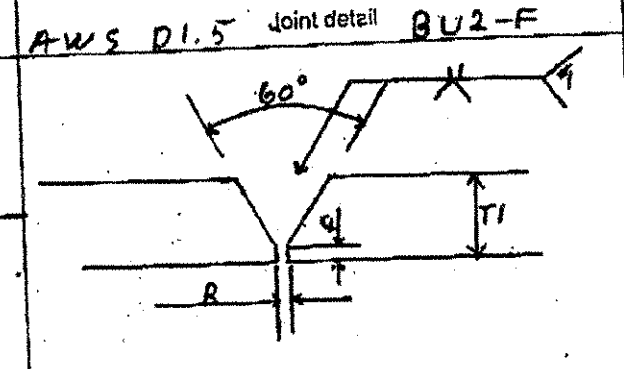
WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
1/16	2-80	25 ± 1.7	25 ± 1.7	11 ± 1.1
1/6	2-80	25 ± 1.7	25 ± 1.7	2.80 ± 2.8

OK'D BY: [Signature] DATE: 3-17-05

RESUBMIT: [Signature] DATE: 3-17-05

APPROVED: [Signature] DATE: 3-17-05



T1 - UNLIMITED
 P - 0 to 1/8 / 0 to 3.2mm
 R - 0 to 1/8 / 0 to 3.2mm
 1-ground as required

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. 104 Contractor Casco Bay Steel
 Revision no. AWS-COI Authorized By Paul E. Goodale
 Form 8-2 Paul E. Goodale Date 2/2/99
8510221
C.W.I.