

Casco Bay Steel Structures, Inc.

75 Spring Hill Road
Saco, Maine 04072

Phone: (207) 282-7360

Fax: (207) 282-1179

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A909/A909M - Grade 30B50 50(45) 50W(345W)
 Welding process Flux Cored Arc welding (FCAW)
 Manual or machine Semi Auto
 Position of welding Flat (1F) Horizontal (2F)
 Filler metal specification AWS A5.20
 Filler metal classification E-71T-C1
 Flux NA
 Shielding gas 75% Ar 25% CO2 Flow rate 40 CFH ±5
 Single or multiple pass Single and multiple - Electrode Extension 3/8" (9.5)
 Single or multiple arc Single
 Welding current DC
 Polarity Reverse
 Welding progression To meet AWS specification
 Root treatment To meet AWS specification
 Preheat and interpass temperature 24(19):50(10):30(10):70(16):100(150):150(65)
 Postheat temperature NA over 2 1/2 (63) = 225 (110)
 Heat input Min NA Max NA Proj # BR-0147(328)
Royalton VT
CAS-250

(METRIC)

Pass no.	Electrode size	Welding current		Travel speed	AWS D.1.5 Joint detail
		Amps	Volts		
1/16	2.05	28.8	11.6	1F	 To 1/2 (12.7) V
	2.47.5	26.8	10.4		
	3.02.5	30.8	12.8		
1/8	2.05	28.8	294.6	2F	 To 3/8 (9.5) V
	2.47.5	26.8	244.2		
	3.02.5	30.8	325.12		

OK'D BY: JWC DATE: MAR 08 2005
 RESUBMIT: APPROVED:
 BY: JWC DATE: 3-17-05

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. 101 Contractor Casco Bay Steel
 Revision no. 1 Authorized By Paul E. Goodale
 Form W-2 Date 3/23/00

