

Casco Bay Steel Structures, Inc.

5 Industry Road
South Portland, Maine 04106

Phone: (207) 772-2533

Fax: (207) 772-0580

WELDING PROCEDURE SPECIFICATION

Material specification A36-A572-A588 (ASTM 709 Gr 36-50-50w)
 Welding process Flux Cored Arc Welding (FCAW)
 Manual or machine Semi-AUTO
 Position of welding FLAT
 Filler metal specification AWS E 70
 Filler metal classification E 70T-1
 Flux NA
 Shielding gas 75% AR 25% CO₂ Flow rate 40 F5
 Single or multiple pass Single Electrode STRAIGHT 3/16 E70
 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 0 to 374-50° (19-100°) + 341 to 170° (197 to 328-200°)
 Postheat temperature NA
 Heat Input Min NA Max NA

Woodford VT
 Proj # RHF-010-1 (29)
 Br # 11 CBSS-70

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1-5
		Amperes	Volts		
	1/16	280 ± 28	25 ± 1.7	17 IPM ± 1.7	Filler BUTT
	1/8	280 ± 28	25 ± 1.7	1432 ± 43.2	Joint detail

RECEIVED
 BY: JWC
 AUG 1 2006
 BY: 9-12-06

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. 105 Contractor Casco Bay Steel
 Revision no. _____ Authorized By Paul E. Goodale
 Form III-2 AWS-C1 Paul E. Goodale Date 2/2/99
 83100201 C.W.I.