

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification A36-A572-A588 (ASTM A36 Gr 36-50-50w)
 Welding process Flux Cored Arc welding (FCAW)
 Manual or machine Semi-AUTO
 Position of welding Flat-1G
 Filler metal specification AWS A5-20
 Filler metal classification E71T-1
 Flux NA
 Shielding gas 75% AR 25% CO₂ Flow rate 40 ES
 Single or multiple pass Both Electrode Stick out 3/4" ± 1/4"
 Single or multiple arc Single
 Welding current Direct current
 Polarity Reverse Electrode positive
 Welding progression see Detail
 Root treatment weld side #1, backgauge side #2, grind - then weld
 Preheat and interpass temperature To 34-50° (19-10°) + 34 to 1/2-70° (19 to 38-20°)
 Postheat temperature NA
 Heat Input Min NA Max NA

WELDING PROCEDURE

Woodford VT
 Proj # BHF-010-1(23)
 Br # 11 CBSS 200

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
1/16	280	±28	25 ±1.9	11 ±1.1
1.6	280	±28	25 ±1.9	280 ±28

Joint detail BU2-F

T1 - UNLIMITED
 P - 0 To 1/8 / 0 To 3.2 mm
 R - 0 To 1/8 / 0 To 3.2 mm

1 - Grind as required

APPROVED BY: [Signature] DATE: 9-14-06

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. 104 Contractor Casco Bay Steel

Revision no. _____ Authorized By Paul E. Goodale

Form III-2 AWS-QC1 Paul E. Goodale Date 2/2/99

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