

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A99 Gr 36-50-50W (250-345-345W)
 Welding process Shielded Metal Arc Welding (SMAW)
 Manual or machine Manual
 Position of welding Flat (1F), Horizontal (2F)
 Filler metal specification AWS/A51-A5.5
 Filler metal classification E7018-R01B C703-7028
 Flux NA
 Shielding gas NA Flow rate NA
 Single or multiple pass Single and multiple
 Single or multiple arc Single
 Welding current AC/DC
 Polarity Straight/Reverse
 Welding progression NA
 Root treatment MEET AWS SPECIFICATION
 Preheat and interpass temperature 3/4 (19) 50 (10) 3/4 (19) TO 1 1/2 (38) 70 (160) 1 1/2 (38) TO 2 1/2 (63) 150 (160)
 Postheat temperature NA
 Heat input Min NA Max NA

Wood Field VITRANS
 Proj # RHF-010-120
 Br # 11 CBSS 290

(Metric) WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
	<u>7018</u>				<u>1F</u>
	<u>1/8 (3.2)</u>	<u>70-170</u>	<u>22-26</u>		
	<u>5/32 (3.9)</u>	<u>120-225</u>	<u>22-26</u>		
	<u>3/16 (4.8)</u>	<u>170-300</u>	<u>24-27</u>		
	<u>8018</u>				<u>2F</u>
	<u>1/8 (3.2)</u>	<u>90-160</u>	<u>22-26</u>		
	<u>5/32 (3.9)</u>	<u>120-225</u>	<u>22-26</u>		
	<u>3/16 (4.8)</u>	<u>180-290</u>	<u>24-27</u>		
	<u>7018</u>				
	<u>5/32 (3.9)</u>	<u>170-270</u>	<u>22-26</u>		
	<u>3/16 (4.8)</u>	<u>210-330</u>	<u>24-27</u>		

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in applicable codes or contract specifications.

Procedure no. 401 Contractor Casco Bay Steel
 Revision no. _____ Authorized By Paul E. Hoodale
 Date 3/2/00