

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709/A709M Gr 36(250)-50(345)-50W(345W)
 Welding process Flux Cored Arc welding
 Manual or machine Semi-Auto
 Position of welding Flat (F) - Horizontal (2F)
 Filler metal specification AWS A5-29
 Filler metal classification E81T1-A11
 Flux NA
 Shielding gas 75% AR / 25% CO₂ Flow rate 35 CFH ± 8.6
 Single or multiple pass single and multiple
 Single or multiple arc single
 Welding current Direct
 Polarity Reverse Electrode Positive
 Welding progression
 Root treatment To meet AWS D1.5 specifications
 Preheat and interpass temperature To 34(9) 50(10) 70(14) to 112(140) 122(146) 150(165)
 Postheat temperature NA
 Heat input Min 2.8 (1.15 kJ/in) Max 4.0 (1.57 kJ/in) P.Q.R. # 2 = 40.9 (1.58)

(Metric) WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
AS	1/16	27.5	28.8	11.6	IF
		24.7	26.8	10.4	
		30.25	30.8	12.8	
Req	(Metric)	27.5	28.8	29.6	2F
		24.7	26.8	26.4	
		30.25	30.8	25.12	

Woodford VT
 Proj # SHF-010-160
 Br # 11 CBS 2002

V groove detail: To 1/2 (12.7)
 Fillet detail: To 5/8 (9.5)

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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-A
 Revision no. 1
 Form III-2

Contract Casco Bay Steel
 Authorized CE Foodil
 Date 9/2002
 CWI