

**Casco Bay Steel Structures, Inc.**

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South Portland, Maine 04106

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**WELDING PROCEDURE SPECIFICATION**

Material specification: ASTM A109 Gr B 50-50W (250-345-345W)  
 Welding process: Shielded Metal Arc Welding (SMAW)  
 Manual or machine: Manual  
 Position of welding: Flat (PF), Horizontal (HF)  
 Filler metal specification: AWS A5.1 - A5.5  
 Filler metal classification: E6018 R018 C/A - 70B  
 Flux: NA  
 Shielding gas: NA Flow rate: NA  
 Single or multiple pass: Single and multiple  
 Single or multiple arc: Single  
 Welding current: A5.108  
 Polarity: Straight / Reverse  
 Welding progression: NA  
 Root treatment: meet AWS specification  
 Preheat and interpass temperature: 70(170) to 140(280) to 210(400) to 270(515) 150(315)  
 Postheat temperature: NA  
 Heat input: NA Max: NA

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 APPROVED  
 DATE 6/21/07

John S. VT  
 BR NO. 37 - Proj. No. BR F030 2(LV)  
 CBS 22 J

(METRIC)

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5	Joint detail	Filler
		Amps	Volts				
AS	7/32 (A-2)	70-100	22-26	AS	LF		REQ
	5/32 (B-2)	120-225	22-26				
	3/16 (C-8)	170-300	24-27				
RFQ	7/32 (B-2)	90-160	22-26	RFQ	2F		REQ
	5/32 (B-2)	120-225	22-26				
	3/16 (C-8)	180-290	24-27				
RFQ	5/32 (B-2)	170-270	22-26	RFQ		REQ	
	3/16 (C-8)	210-330	24-27				

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

Procedure no: 401  
 Revision no: 001  
 Contractor: Casco Bay Steel  
 Authorized By: Paul E. Hoodale  
 Date: 3/2/00