# Casco Bay Steel Structures, Inc.

75 Spring Hill Road
Saco, Maine 04072

Phone: (207) 282-7360 Fax: (207) 282-1179

## WELDING PROCEDURE SPECIFICATION

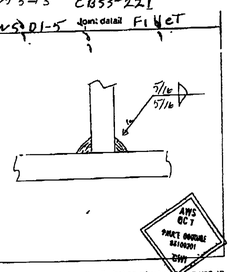
Material specification: ASTM-709-Gr36-50-50W / A709M Gr 250-345-345W
Welding process: Flux Cored Arc welding (FCAW)
Manual or machine: Semi AUTO
Position of welding: Flat - Horizontal
Filler metal specification: AWS A5-29
Filler metal classification: E81T1-Ni1-H4 ESAB
Flux: NA
Shielding gas: 75% AR - 25% CO2 Flow rate: 35 CFH +5-4
Single or multiple pass: Single / Multiple Elec Ex 5/64" N
Single-or multiple arc: Single
Welding current: DC
Polarity: DCEP
Welding progression: See detail
Root treatment: wire brush - arm To be free of loose scale, slag rust & moisture
Preheat and interpass temperature: To 20° (68) 10(50), 20(68) to 40(104) 20(0), 40(104) To 60(212) 65°C (150) over 60(212) 110(225)
Postheat temperature: NO
Heat Input Min 20 KJ/in Max 43.6 KJ/in PQR FCM#8 39.6 KJ/in

Johnson VT
Bx:#0.37 - Proj no. BRF030-261
CBS#221

### WELDING PROCEDURE

AWS 5-13
AWS D1-5 Joint detail FILLET

| Pass no. | Electrode size | Welding current Amperes | Volts | Travel speed |
|---|---|---|---|---|
| | | 287 | 29 | 13 |
| | 1/16 | 258 To 315 | 26.6 To 31 | 11.4 To 14 |




VTRANS RECEIVED
JUN 21 2007

OK'D BY ____ OK'D BY JWC
RESUBMIT ____ APPROVED ✓
BY ____ DATE 6/21/07

AWS QC 7 PRACT. GROOVE & FILLET WELDS

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 Mass
Revision no. ____
Form III-2

Contractor Casco Bay Steel
Authorized By Paul E. Goodale
Date 12-6-06