

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION




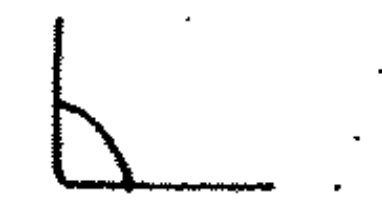


Material specification ASTM A36 Gr 36-50-50W (250-345-345W)
 Welding process Shielded Metal Arc Welding (SMAW)
 Manual or machine Manual
 Position of welding Flat (1F), Horizontal (2F)
 Filler metal specification AWS/A5.1 - A5.5
 Filler metal classification E7018-8018 C/C3 - 7028
 Flux NA
 Shielding 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 _____
 Root treatment MEET AWS SPECIFICATION
 Preheat and interpass temperature To 3/4(19) 50°F(10°) 3/4(19) To 1 1/2(38) 70°F(20°) 1 1/2(38) To 2 1/2(63.5) 150°F(65°)
 Postheat temperature NA over 2 1/2(63.5) 225°F(110°)
 Heat Input Min NA Max NA

VT-AOT Chester
BrNO.9 - Proj No. BRF025137

WELDING PROCEDURE

(Metric)

CBSS NO 476

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail Fillet		
		Amperes	Volts				
AS REQ.	<u>7018</u> 1/8 (3.2)	70-170	22-26	AS REQ.	<u>1F</u>		
	5/32 (3.9)						
	3/16 (4.8)	3/16 To 3/8 (5 To 10)	3/8 To 1/2 (10 To 13)				
	<u>8018</u> 1/8 (3.2)	90-160	22-26		<u>2F</u>		
	5/32 (3.9)						
	3/16 (4.8)	180-290	24-27				
<u>7028</u> 5/32 (3.9)	170-270	22-26					
3/16 (4.8)			210-330	24-27			

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

Procedure no. 401

Contractor Casco Bay Steel

Revision no. _____

Authorized By Paul E. Hoodale

Form III-2

Date 8/28/10

