

**Casco Bay Steel Structures, Inc.**

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STRUCTURES COPY

**WELDING PROCEDURE SPECIFICATION**

Material specification ASTM A109 GR 36-50-50W (250-345-345W)  
 Welding process Shielded Metal Arc Welding (SMAW)  
 Manual or machine Manual  
 Position of welding Flat (FE) Horizontal (HF)  Vertical (VF)  
 Filler metal specification A51/AWS A5.1 - A5.5 RECEIVED  
 Filler metal classification E7018-R018 E63-7028 OK'D BY JWC  
 Flux NA  
 Shielding gas NA Flow rate NA SEP 07 2010  
 Single or multiple pass Single and multiple RESUBMIT APPROVED  
 Single or multiple arc Single  
 Welding current AC / D.C. BY JWC DATE 9/7/10  
 Polarity STRAIGHT / REVERSE  
 Welding progression  
 Root treatment SELECT AWS SPECIFICATION  
 Preheat and interpass temperature To 3/4 (19) 50 (10) 3/8 (10) To 1/2 (38) 70 (Ac) 1/2 (38) To 3/4 (35) 150 (Ac)  
 Postheat temperature NA over 2 1/2 (63.5) 225 (110)  
 Heat input Min NA Max NA  
 Veriment AAT  
 BR No. 9 - Proj No. BRP-0221(00)  
 Stockbridge, CBSS 4&1

(Metric)

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5	Joint detail	Fillet
		Amperes	Volts				
AS	1/8 (3.2)	70-170	22-26	AS	1F		
	5/32 (3.9)	120-225	22-26				
	3/16 (4.8)	170-300	24-27				
REQ.	1/8 (3.2)	90-160	22-26	REQ.	2F		
	5/32 (3.9)	120-225	22-26				
	3/16 (4.8)	180-290	24-27				
REQ.	5/32 (3.9)	170-270	22-26	REQ.	3/16 To 3/8 (5 To 8)	3/8 (10)	7/16 To 5/8 (11 To 16)
	3/16 (4.8)	210-330	24-27				

This procedure may vary due to isonon 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. 01 Authorized By Paul E. Hodale  
 Date 8/28/10