

**Casco Bay Steel Structures, Inc.**

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**WELDING PROCEDURE SPECIFICATION**

Material specification ASTM A242-Gr 36-50-50w / 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 A5-24  
 Filler metal classification E81T1-N11-H4 ESAB  
 Flux EA  
 Shielding gas 75% AR - 25% CO<sub>2</sub> Flow rate 35 CFH ± 4  
 Single or multiple pass Single / Multiple Elec Ex 3/16 ± 1/4  
 Single or multiple arc Single  
 Welding current DC  
 Polarity DCEP  
 Welding progression See detail  
 Root treatment wire brush - area to be free of loose scale, slag, rust & moisture  
 Preheat and interpass temperature To 200 (375) 10(50), 80(300) to 40(100) 20(0), 40(100) to 60(225)  
 Postheat temperature over 60 (225) 40 (225)  
 Heat input Min 22.7 kJ/in Max 43.6 kJ/in PQR FCM # 8 39.6 kJ/in

**WELDING PROCEDURE**

Vermont A&T  
Pr. No. 9 - Proj No. BR-024100  
Stockbridge - CBSS 461

Pass / no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
		28.7	29	13	
	1/16	25.8	26.8	11.4	
		To	To	To	
		31.5	31	14	
RECEIVED OK'D BY <u>JWC</u> SEP 02 2010 RESUBMIT _____ APPROVED <input checked="" type="checkbox"/> BY _____ DATE <u>9/9/10</u>					



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 Contractor Casco Bay Steel  
 Revision no. \_\_\_\_\_ Authorized By Paul G. Woodale  
 Form III-2 Date 12-6-06