

Casco Bay Steel Structures, Inc.

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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 (PF) Horizontal (HF) RECEIVED
 Filler metal specification AST/AWS A5.1 - A5.5 OK'D BY JWC
 Flux E7018 - R01A 4/32 - 7028 DATE 9/2/10
 Shielding gas NA Flow rate NA REVISION APPROVED
 Single or multiple pass Single and multiple
 Single or multiple arc single DATE 9/1/10
 Polarity AC/DC
 Welding progression STRAIGHT / Reverse
 Root treatment ASCT AWS SPECIFICATION
 Preheat and interpass temperature To 34(9) 50°C(125) 3/16(1.5) To 1/4(3.2) 70°C(158) To 3/8(9.5) 150°C(300)
 Postheat temperature NA over 1/4(3.2) 225°C(425)
 Heat Input Min NA Max NA
 Vermont ASB
 Br. No. 9 - Proj. No. BRF-0221(00)
 Stockbridge, MASS 461

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail	Fillet
		Amperes	Volts			
AS REQ.	7028 1/8 (3.2)	70-170	22-26	AS REQ.	3/16 to 3/8 (5 to 10)	IF
	5/32 (3.9)	120-225	22-26			
	3/16 (4.8)	170-300	24-27			
7028	1/8 (3.2)	90-160	22-26	2F	3/16 to 3/8 (5 to 10)	1/2 to 5/8 (13 to 16)
	5/32 (3.9)	120-225	22-26			
	3/16 (4.8)	180-290	24-27			
7028	5/32 (3.9)	170-270	22-26	3/16 to 3/8 (5 to 10)	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 fabrication 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. _____ Authorized By Paul E. Hodale
 Form III-2 Date 8/28/10