

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-A209-G-36-50-50W/A209M 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-N11-H4 ESAB
 Flux EA
 Shielding gas 75% AR - 25% CO₂ Flow rate 35 CFH ± 4
 Single or multiple pass Single / Multiple Elec EX 90 ± 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 20(100) to 10(50), 80(300) to 40(100), 40(100) to 65(150)
 Postheat temperature NA Over 6.8(2 1/2) 110(225)
 Heat Input Min 27.7 kJ/in Max 43.6 kJ/in PQR FCN # 8 39.6 kJ/in

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
		287	29	13	
	1/16	258 TO	26.8 TO	11.4 TO	
		315	31	14	

AWS 5-13
 AWS D1-5
 Joint detail Fillet
 VERMONT A&T
 101 No. 9 - Proj. No. BRP-0221(00)
 STOCKBRIDGE - CRSS 461

VTRANS RECEIVED
 OK'D BY: [Signature]
 SEP 02 2010
 RE-SUBMIT BY: [Signature] DATE 9/9/10
 APPROVED: [Signature]

AWS OCT
 PAUL GOODALE
 20100301
 CWI

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 Goodale
 Form II-2 Date 12-6-06