

Casco Bay Steel Structures, Inc.  
WELDING PROCEDURE SPECIFICATION

Material specification ASTM A36 - Gr 50 - 50W  
 Welding process Shielded Arc welding (Power wave)  
 Manual or machine Manual  
 Position of welding Flat  
 Filler metal specification A5-23  
 Filler metal classification E 7018 - EN11-Ni1-H8  
 Flux Lincoln 780 - E7018  
 Shielding gas Ar Flow rate Ar  
 Single or multiple pass Single / Multiple  
 Single or multiple arc Single  
 Welding current AC  
 Polarity AC  
 Welding progression See details  
 Root treatment Grind - wire brush - To be free of slag - Rust - Moisture  
 Preheat and interpass temperature see table  
 Postheat temperature As Req.  
 Heat input Min 47.1 kJ/in Max 74.0 kJ/in P.Q.R - PW-1 - 67.3 kJ/in

Minimum Preheat and Interpass Temperature, °C (°F)

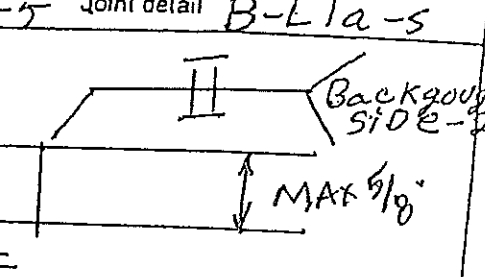
Thickness of Thicker Part at Joints of Welding, mm (in)	Preheat	Interpass
Over 20 mm (3/4 in) to 40 mm (1-1/2 in)	10 (50)	20 (70)
Over 40 mm (1-1/2 in) to 60 mm (2-1/4 in)	15 (60)	25 (75)
Over 60 mm (2-1/4 in) to 100 mm (4 in)	20 (70)	30 (85)

Welding Process (Base Metal)

SAW (Shielded Arc Welding)	SAW (Shielded Arc Welding)	SAW (Shielded Arc Welding)
SAW (Shielded Arc Welding) (A5.1)	SAW (Shielded Arc Welding) (A5.2)	SAW (Shielded Arc Welding) (A5.3)
SAW (Shielded Arc Welding) (A5.4)	SAW (Shielded Arc Welding) (A5.5)	SAW (Shielded Arc Welding) (A5.6)

WELDING PROCEDURE

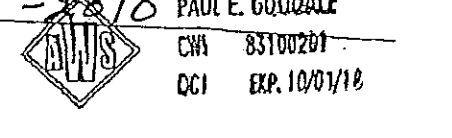
Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
As Req	5/32	82-9	38	28 IPH
		70	35	24

Sec 513  
 AWS-D1.5 Joint detail B-L1a-s  
 SIDE-1  

 SIDE-2  
 MAX INTERPASS TEMP 450°F

This procedure may vary due to fabrication sequence, fit-up, joint preparation and the limitation of variables given in applicable A.W.S. codes or contract specifications

Procedure no. 3-PW-STOP-VT  
 Revision no. 1-8-3-10

Contractor Casco Bay Steel  
 Authorized By Paul E. Goodale  
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