

Casco Bay Steel Structures, Inc.
WELDING PROCEDURE SPECIFICATION

Material specification ASTM A36 - Gr 50 50W
 Welding process Submerged Arc welding (Power Wave)
 Manual or machine Machine
 Position of welding Flat
 Filler metal specification E7018
 Filler metal classification E7018-Ni1-H8
 Flux Lincoln 780 - Elec. 6A78
 Shielding gas Ar Flow rate NA
 Single or multiple pass Single / Multiple
 Single or multiple arc Single
 Welding current Alternating
 Polarity AC
 Welding progression See details
 Root treatment Grind with brush - free of slag - rust - moisture
 Preheat and interpass temperature See Table
 Postheat temperature As Req.
 Heat input Min 49.1 kJ/in Max 74.0 kJ/in PQR - PW-1 - 69.3 kJ/in

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

Welding Process (Base Metal)	Thickness of Thicker Part Pole of Welding, mm (in)			
	To 20 mm (3/4 in) Incl.	Over 20 mm (3/4 in) to 40 mm (1 1/2 in) Incl.	Over 40 mm (1 1/2 in) to 60 mm (2 1/2 in) Incl.	Over 60 mm (2 1/2 in)
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