

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709/A709M - Grade 36(250) 50(345) 50W(345W)
 Welding process Flux Cored Arc welding (FCAW)
 Manual or machine Semi Auto
 Position of welding Flat (1F) Horizontal (2F)
 Filler metal specification AWS A5-20
 Filler metal classification E71T-1
 Flux NA
 Shielding gas 75% AR 25% CO2 Flow rate 40 CFH ± 5
 Single or multiple pass Single and Multiple - Electrode Extension 5/8 ± 1/4 (15.87 ± 6.35)
 Single or multiple arc Single
 Welding current DC
 Polarity Reverse
 Welding progression _____
 Root treatment To meet AWS specification
 Preheat and interpass temperature To 3/4 (19): 50°(10°) - 3/4 (19°) To 1/2 (38): 70°(20°) - 1/2 (38°) To 2/4 (63): 150°(65°)
 Postheat temperature NA over 2 1/2 (63) = 225°(110°)
 Heat Input Min NA Max NA

VT DOT
Stockbridge
Br no 9 Expan.
CBS 461

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1-5 Joint detail
		Amperes	Volts		
	<u>1/16</u>	<u>275</u>	<u>28.8</u>	<u>11.6</u>	<u>1F</u>
		<u>247.5</u>	<u>26.8</u>	<u>10.4</u>	
		<u>To 302.5</u>	<u>To 30.8</u>	<u>To 12.8</u>	
	<u>1.6</u>	<u>275</u>	<u>28.8</u>	<u>294.6</u>	<u>2F</u>
		<u>247.5</u>	<u>26.8</u>	<u>264.2</u>	
		<u>To 302.5</u>	<u>To 30.8</u>	<u>To 325.12</u>	



To 1/2 (12.7)

To 3/8 (9.5)

RECEIVED
 OK'D BY _____ OK'D BY JWC
FEB 09 2011
 RESUBMIT _____ APPROVED
 BY _____ DATE 02/15/11

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 E. Goodale
 Form III-2 Date 3/23/00

