

# 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 (1F), Horizontal (2F)  
 Filler metal specification ANSI/AWS A5.1 - A5.5  
 Filler metal classification E7018 - 8018 C/C3 - 702B  
 Flux NA  
 Shielding gas NA Flow rate NA  
 Single or multiple pass Single and multiple  
 Single or multiple arc Single  
 Welding current AC/DC  
 Polarity Straight / Reverse  
 Welding progression  
 Root treatment MEET AWS SPECIFICATION  
 Preheat and interpass temperature To 3/4 (9) 50° (10°) 3/4 (9) To 1 1/2 (38) 70° (20°) 1 1/2 (38) To 2 1/2 (63.5) 150° (65°)  
 Postheat temperature NA  
 Heat Input Min NA Max NA

VT TRANS RECEIVED

FEB 09 2011

RESUBMIT APPROVED  
DATE 02/15/11

VT DOT  
Stockbridge  
Brno 9 Expan.  
CBSS 461

### WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5	Joint detail
		Amperes	Volts			
AS REQ.	7018 1/8 (3.2)	70-170	22-26	AS REQ.	1F	
	5/32 (3.9)	120-225	22-26			
	3/16 (4.8)	170-300	24-27			
	8018 1/8 (3.2)	90-160	22-26			
	5/32 (3.9)	120-225	22-26			
	3/16 (4.8)	180-290	24-27			
AS REQ.	702B 5/32 (3.9)	170-270	22-26	AS REQ.	2F	
	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 AWS codes or contract specifications

Procedure no. 401  
 Revision no. \_\_\_\_\_  
 Contractor Casco Bay Steel  
 Authorized By Paul E. Hoodale  
 Date 3/2/00