

# Casco Bay Steel Structures, Inc.

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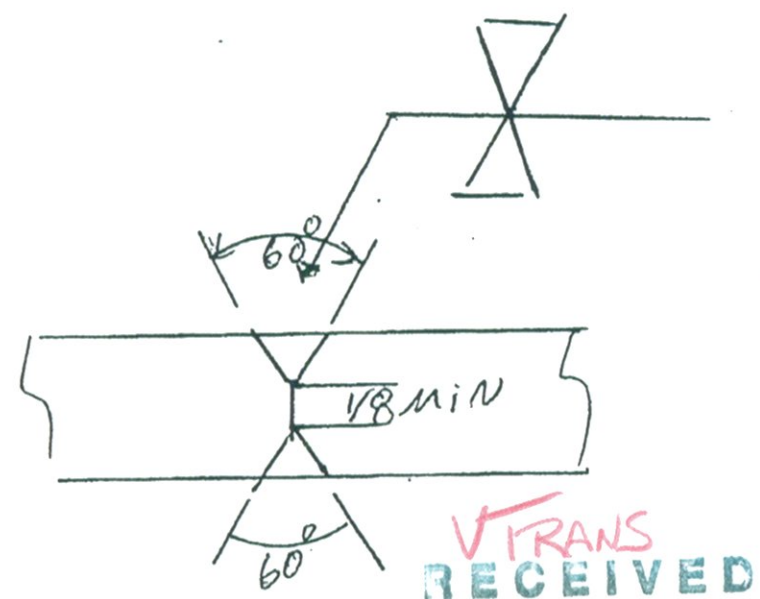
## WELDING PROCEDURE SPECIFICATION

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 (IG) Horizontal (2G)  
 Filler metal specification AWS A5.20  
 Filler metal classification E71T-1  
 Flux NA  
 Shielding gas 75% AR 25% CO2 Flow rate 40CFH ±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 See Joint Detail  
 Root treatment To meet AWS specification  
 Preheat and interpass temperature To 3/4" (19): 50°(10°) - 3/4" (19°) To 1 1/2" (38): 70°(20) - 1 1/2" (38) To 2 1/2" (63): 150°(65)  
 Postheat temperature NA  
 Heat Input Min \_\_\_\_\_ Max \_\_\_\_\_

VT DOT  
 STOCKbridge  
 B r n o 9 Expan.  
 CBSS 461

### WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
1/16	1/16	275	28.8	11.6
		247.5	26.8	10.4
		302.5	30.8	12.8
1.6	1.6	275	28.8	294.6
		247.5	26.8	264.2
		302.5	30.8	325.12



OK'D BY \_\_\_\_\_ OK'D BY JWC  
 FEB 09 2011  
 RESUBMIT \_\_\_\_\_ APPROVED   
 BY \_\_\_\_\_ DATE 04/15/11

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. 105 Contractor Casco Bay Steel  
 Revision no. \_\_\_\_\_ Authorized By Paul E. Goodale  
 Form III-2 Date 1-31-11