

Casco Bay Steel Structures, Inc.

5 Industry Road
South Portland, Maine 04106

Phone: (207) 772-2533

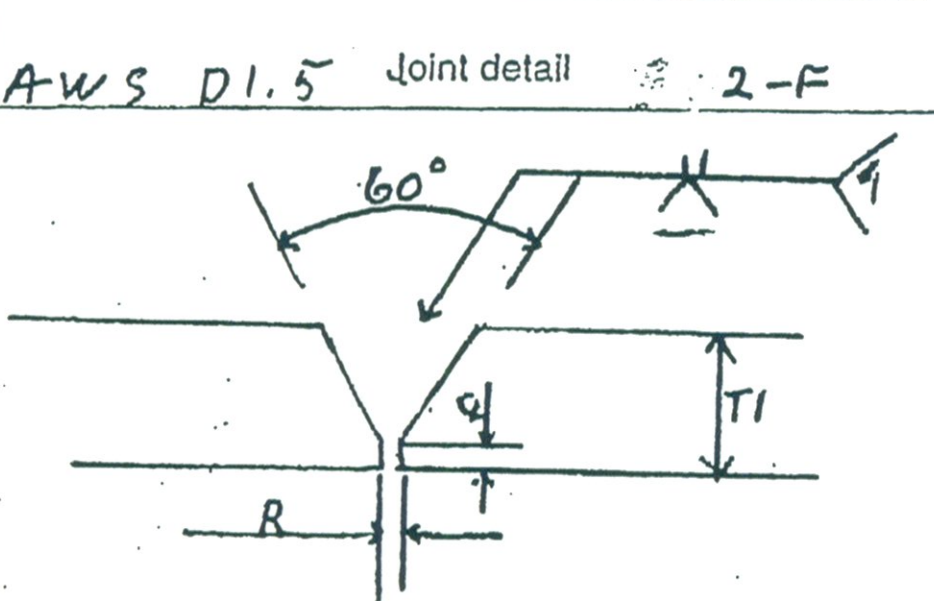
Fax: (207) 772-0580

WELDING PROCEDURE SPECIFICATION

Material specification A36-A572-A588 (ASTM 909 Gr 36-50-50w)
 Welding process Flux Cored Arc welding (FCAW)
 Manual or machine Semi-Auto
 Position of welding Flat-1G
 Filler metal specification AWS A5-20
 Filler metal classification E71T-1
 Flux NA
 Shielding gas 75% AR 25% CO₂ Flow rate 40 ± 5
 Single or multiple pass Both Electrode stick out 3/4 ± 1/4
 Single or multiple arc Single
 Welding current Direct Current
 Polarity Reverse Electrode positive
 Welding progression see Detail
 Root treatment weld side #1, backgauge side #2 - grind - then weld
 Preheat and interpass temperature To 3/4-50°F (+10°) + 3/4 to 1/2-70°F (+19 to 38-20°)
 Postheat temperature NA
 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		
	1/16	±28 280	±1.7 25	±1.1 11	 <p>Joint detail: 2-F</p> <p>T1 - UNLIMITED F - 0 to 1/2 / 0 to 3.2mm R - 0 to 1/8 / 0 to 3.2mm</p> <p>1 - Grind as required</p>
	1/6	±28 280	±1.7 25	±2.8 280	

OK'D BY: _____ OK'D BY: JWC

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. 104

Contractor Casco Bay Steel

Revision no. _____

Authorized By Paul E. Goodale

Form III-2
AWS-QC1
Paul E. Goodale
83100201
C.W.I.

Date 2/2/99