

Casco Bay Steel Structures, Inc.

75 Spring Hill Road
Saco, Maine 04072

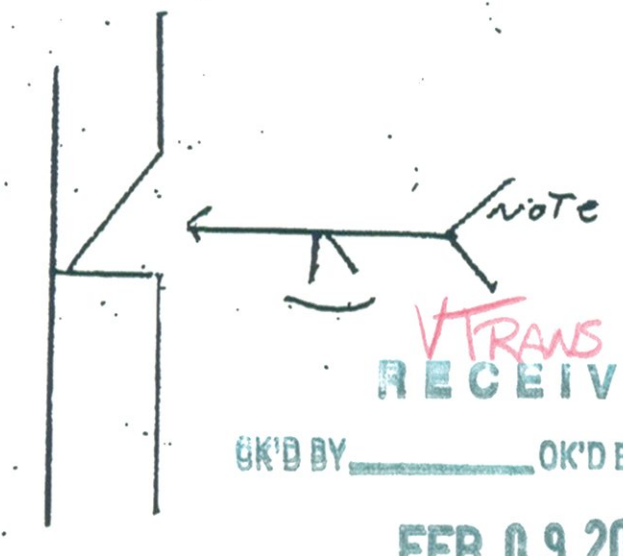
Phone: (207) 282-7360

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A109/A109M - Grade 36(250) 50(345) 50W(345W)
 Welding process Flux Cored Arc welding (FCAW)
 Manual or machine Semi Auto
 Position of welding Flat (0G) Horizontal (2G)
 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 1/8" ± 1/4" (5.8) ± 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 1/2" (13) = 70° (20) - 1/2" (13) To 3/8" (9.5) = 150° (65)
 Postheat temperature NA over 2 1/2" (63) = 225° (110)
 Heat Input Min _____ Max _____

VT DOT
Stockbridge
BRMO 9 Expan.
CBS 461

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
	1/16	27.5	28.8	11.6	AWS D1.5 Joint detail TCP4-F 
		247.5	26.8	10.4	
		To 302.5	To 30.8	To 12.8	
	1.6	(METRIC) 27.5	28.8	294.6	
		247.5	26.8	264.2	
		To 302.5	To 30.8	To 325.12	

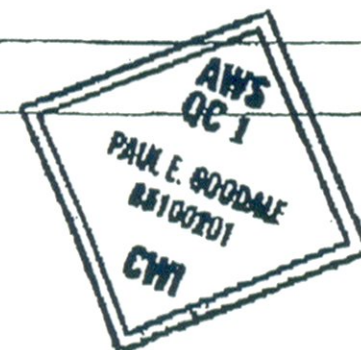
note: GRIND Flush as Req
 VTRANS RECEIVED
 OK'D BY _____ OK'D BY JWC
 FEB 09 2011
 RESUBMIT _____ APPROVED
 BY _____ DATE 02/15/11

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. 103

Revision no. _____

Form III-2



Contractor Casco Bay Steel

Authorized By Paul E. Goodale

Date 3/23/00