

**Casco Bay Steel Structures, Inc.**

75 Spring Hill Road  
Saco, Maine 04072

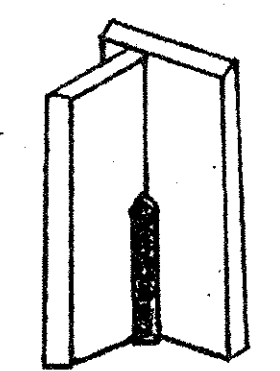

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**WELDING PROCEDURE SPECIFICATION**

Material specification ASTM A36 Gr. 36-50-50W (250-345-345W)  
 Welding process Shielded Metal Arc welding (SMAW)  
 Position of welding Manual  
 Position of machine Vertical up (3F)  
 Filler metal specification AWS/A5.1 A5.1-A5.5  
 Filler metal classification E7018 - R618 OK  
 Flux NA Flow rate NA  
 Shielding gas NA  
 Single or multiple pass Single - multiple  
 Single or multiple arc Single  
 Welding current DC  
 Polarity Positive  
 Welding progression see Detail  
 Root treatment Area To be Free of Loose Scale, Slag, Rust or Moisture  
 Preheat and interpass temperature 70 (19) 50 (100), 200 (380) 200 (380) 200 (380) 200 (380)  
 Postheat temperature NA  
 Heat input Min NA Max NA  
 LYNDA V.T.  
 BY BRS 0269 (B)  
 DTB - 0255 293

(Metric)

Pass no.	Electrode size	Welding current		Travel speed	Notes
		Amperes	Volts		
7018	1/8	70-170	22-26		AWS D1.5 Joint detail Fillet
	3/32	120-190	22-26		
8018	1/8	90-160	22-26		VTRAS RECEIVED OK'D BY: _____ OK'D BY: JWC MAR 14 2006 RESUBMIT: _____ APPROVED: _____ BY: CWC DATE: 3/29/06 
	3/32	130-200	22-26		
	5/32	130-200	22-26		

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. 403 Contractor Casco Bay Steel  
 Revision no. \_\_\_\_\_ Authorized By Paul H. Hordel  
 Form III-2 Date 4-24-05