

**Casco Bay Steel Structures, Inc.**

75 Spring Hill Road  
Saco, Maine 04072

Phone: (207) 282-7360

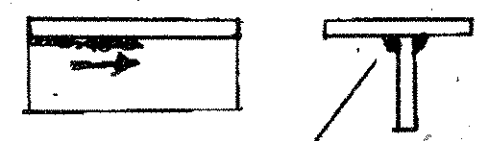
Fax: (207) 282-1179

**WELDING PROCEDURE SPECIFICATION**

Material specification ASTM A 36 - Gr 36 - 50-50W (250-345-345W)  
 Welding process Shielded Metal Arc Welding (SMAW)  
 Manual or machine Manual  
 Position of welding Overhead (UF)  
 Filler metal specification AWS/AWS A 5.1 - A 5.5  
 Filler metal classification E 7018 - 8018 C<sub>1</sub>3  
 Flux NA  
 Shielding gas NA Flow rate NA  
 Single or multiple pass Single - multiple  
 Single or multiple arc Single  
 Welding current D.C.  
 Polarity POSITIVE  
 Welding progression See Detail  
 Root treatment Area to be free of (scale - slag - rust or moisture)  
 Preheat and interpass temperature 34(19) 50(100) 34(19) to 145(100) 70(150) 120(250) 140(300)  
 Postheat temperature NA  
 Heat Input Min NA Max NA

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878 - 0855 293

**WELDING PROCEDURE**

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
	<u>7018</u>			AWS D 1.5 Joint detail <u>Filler</u>  VTRANS RECEIVED OK'D BY _____ OK'D BY <u>JWC</u> MAR 14 2006 RESUBMIT _____ APPROVED <input checked="" type="checkbox"/> BY <u>AWL</u> DATE <u>3/22/06</u>
	<u>1/8 (3.2)</u>	<u>95-160</u>	<u>22-26</u>	
	<u>3/32 (3.9)</u>	<u>120-190</u>	<u>22-26</u>	
	<u>1/8 (3.2)</u>	<u>110-150</u>	<u>22-26</u>	
	<u>5/32 (3.9)</u>	<u>130-190</u>	<u>22-26</u>	

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. 404 Contractor Casco Bay Steel Structures, Inc.  
 Revision no. \_\_\_\_\_ Authorized By [Signature]  
 Form III-2 Date 6-3-04