

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 572 Gr 50 (250-355 MPa)
 Welding process Shielded Arc Welding - Auto (SAW)
 Manual or machine Machine
 Position of welding Flat (1G)
 Filler metal specification AWS A5.17 AWS A5.23
 Filler metal classification E70T1-K11
 Flux 960 Flux - Lincoln Flow rate SA
 Shielding gas Ar
 Single or multiple pass single
 Welding current Direct Electrode Positive
 Polarity Reverse
 Welding progression Meet AWS Specification - Back
 Postheat and interpass temperature None
 Postheat temperature None
 Heat input Min 1.65 Max 6.45 PAR 1-59.5

APPROVED
 DATE 3/12/00
 BY BRS
 BRS-0289 (B)
 BRS-CBSS 293

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
5/32	605	29.5	18.5	AWS D1.5 Joint detail B-22c-s side 1
	544.5	27.4	15.3	
	665.5	31.56	20.7	
3/9	605	29.5	457.2	T1 1/2 to 1" 1/4 min 1 1/2 to 2 1/4" (6) 2 1/2 to 3 1/2" 3/8 min 3 1/2 to 4 1/2" (9.5) 4 1/2 to 6" 1/2 min 6" to 8" (12)
	544.5	27.4	388.6	
	665.5	31.56	525.8	

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limits of variables given in applicable A.W.S. codes or contract specifications.

Procedure no. 202
 Revision no. _____
 Form W-2

Contractor Casco Bay Steel
 Authorized By T. E. [Signature]
 Date 3/12/00