

**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 A209/A209M - Grade 36 (A50) 50 (A45) 50W (34W)  
 Welding process Flux Cored Arc Welding (FCRW)  
 Manual or machine Semi Auto  
 Position of welding Flat (1F) Horizontal (2F)  
 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 48" ± 4 (15.2) ± 6.35  
 Single or multiple arc single  
 Welding current DC  
 Polarity Reverse  
 Welding progression \_\_\_\_\_  
 Root treatment To meet AWS specification  
 Preheat and interpass temperature 3/16 (8) = 70 (20) - 1/2 (8) = 224 (63) 150 (65)  
 Postheat temperature NA  
 Heat Input Min NA Max NA 1/4 (6) = 225 (110)  
BY B.S. COLE (B)  
678 - 0355 293

(METRIC)

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
1/16	2.05	25.8	11.6	10.4 TO 12.8	1F
	24.7.5	26.8			
	30.2.5	30.8			
1.6	2.05	28.8	294.6	244.2 TO 325.12	2F
	24.7.5	26.8			
	30.2.5	30.8			

Joint detail: Fillet

RESUBMITTED BY me DATE 3/23/06

MAR 14 2006

OK'D BY \_\_\_\_\_ OK'D BY JWC

To 1/2 (12.7) RECEIVED

To 3/8 (9.5)

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. 101 Contractor Casco Bay Steel  
 Revision no. 2 Authorized By R.L. Hoodole  
 Form 112 Date 3/23/06

