

**Casco Bay Steel Structures, Inc.**

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**WELDING PROCEDURE SPECIFICATION**

Material specification: ASTM A109 Gr 36-50 (250-345-345W)  
 Welding process: Shielded Metal Arc Welding (SMAW)  
 Manual or machine: Manual  
 Position of welding: Flat (F), Horizontal (HF)  
 Filler metal specification: AWS A5.1 - E7018  
 Filler metal classification: E7018 - R01A 5/16 - 7/16  
 Flux: NA  
 Shielding gas: NA Flow rate: NA  
 Single or multiple pass: Single and multiple  
 Single or multiple arc: Single  
 Welding current: AC/D  
 Polarity: Straight / Reverse  
 Welding progression: NA  
 Root treatment: See AWS Specification  
 Preheat and interpass temperature: 340 (9) 50 (10) 3/16 (13) 70 (16) 1/2 (18) 120 (24) 5/8 (21) 150 (30)  
 Postheat temperature: NA  
 Heat input: Min NA Max NA

WELDING PROCEDURE  
 BY: BRB/269 (B)  
 BY: 9 - COSS 293

Pass no.	Electrode size	Welding current		Travel speed	AWS 01.5 Joint detail
		Amperes	Volts		
AS	7/32 (3.2)	70-170	22-26	AS	Fillet
	5/32 (3.9)	120-225	22-26		
	3/16 (4.8)	170-300	24-27		
	1/8 (3.2)	90-160	22-26		
REQ	7/32 (3.9)	120-225	22-26	REQ	Fillet
	3/16 (4.8)	180-290	24-27		
	5/32 (3.9)	170-270	22-26		
	1/8 (3.2)	110-330	24-27		

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

Procedure no. 401 Contractor Casco Bay Steel  
 Revision no. 001 Authorized By Paul E. Hurdale  
 Form III-2 Date 3/2/00