

Casco Bay Steel Structures, Inc.

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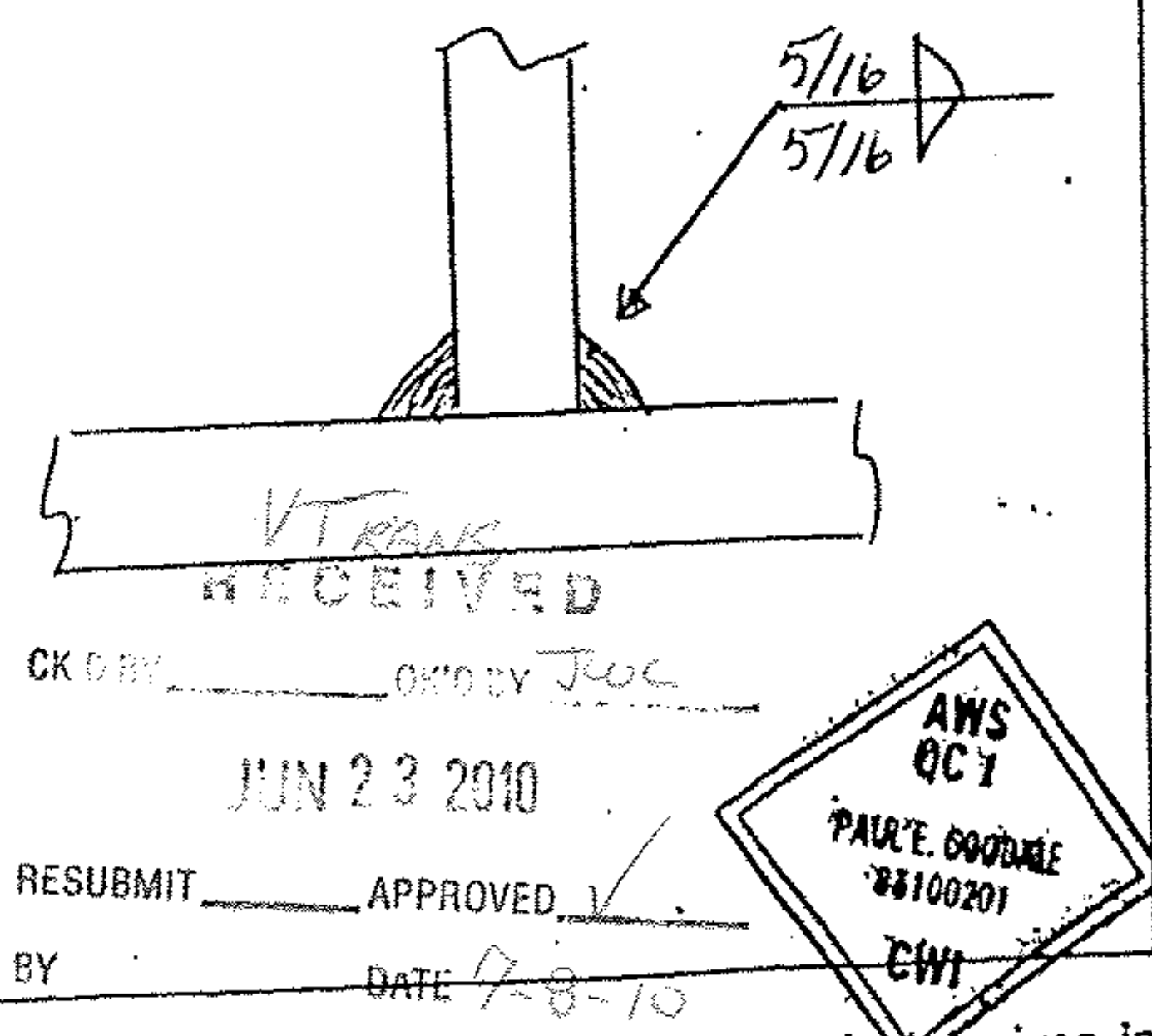
WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A709-G+36-50-50W/A709M GR 250-345-345W
 Welding process Flux Cored Arc Welding (FCM)
 Manual or machine Semi AUTO
 Position of welding Flat - Horizontal
 Filler metal specification AWS A5-29
 Filler metal classification E81T1-Ni1-H4 ESAB
 Flux NA
 Shielding gas 75% AR - 25% CO₂ Flow rate 35 CFH ± 4
 Single or multiple pass Single / Multiple Elec EX 5/8 = 1/4
 Single or multiple arc Single
 Welding current DC
 Polarity DC EP
 Welding progression See detail
 Root treatment wire brush - area to be free of loose scale, slag, rust & moisture
 Preheat and interpass temperature To 20^{mm} (74) 10(50), 20^{mm} (3/4) TO 40 (1 1/2) 20(20), 40 (1 1/2) TO 60 (2 1/2) 65 C 150
 Postheat temperature NA
 Heat Input Min 27.7 kJ/in Max 43.6 kJ/in PQR FCM # 8 39.6 kJ/in

WELDING PROCEDURE

VT - AOT, Br No 9
 Proj No. - BR5 0172 (6)
 Cor NW Wall - CBSS-457

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
	1/16	28.7	29	13	Fillet
		25.8	26.8	11.4	
		To	To	To	
		31.5	31	14	



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

Revision no. _____

Form III-2

Contractor Casco Bay Steel
 Authorized By Paul E. Goodale
 Date 12-6-06