

# Casco Bay Steel Structures, Inc.

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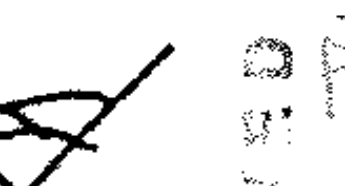
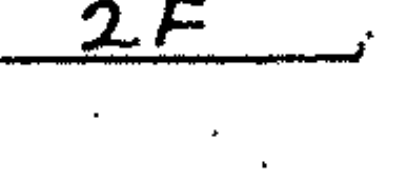
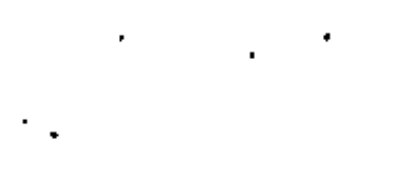

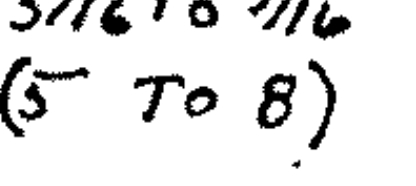
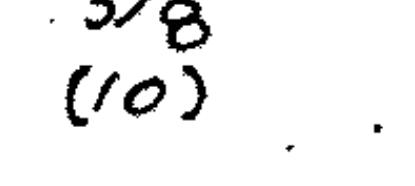
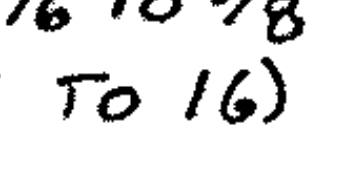
## WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 36-50-50W (250-345-345W)  
 Welding process Shielded Metal Arc Welding (SMAW)  
 Manual or machine Manual  
 Position of welding Flat (1F), Horizontal (2F)  
 Filler metal specification AST/AWS A5.1 - A5.5  
 Filler metal classification E7018 - 8018 C/C3 - 7028  
 Flux NA  
 Shielding gas NA Flow rate NA  
 Single or multiple pass Single and Multiple  
 Single or multiple arc Single  
 Welding current AC/DC  
 Polarity Straight / Reverse  
 Welding progression \_\_\_\_\_  
 Root treatment MEET AWS SPECIFICATION  
 Preheat and interpass temperature To 3/4(19) 50°(10°) 3/4(19) To 1 1/2(38) 70°(20°) 1 1/2(38) To 2 1/2(63.5) 150°(65°)  
 Postheat temperature NA over 2 1/2(63.5) 225°(110°)  
 Heat Input Min NA Max NA

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

## WELDING PROCEDURE

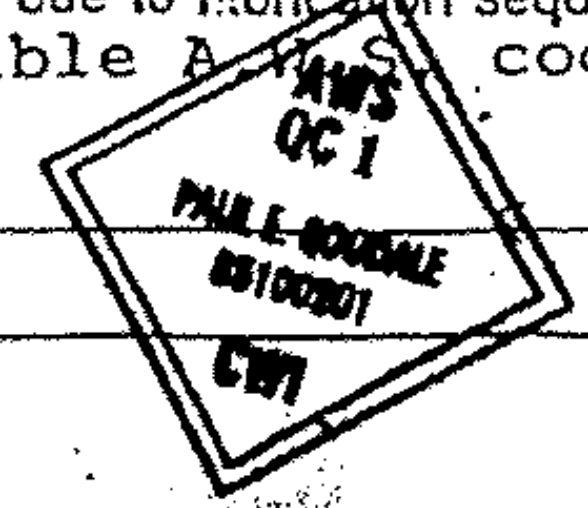
(Metric)

Pass no.	Electrode size	Welding current		Travel speed	Joint detail		
		Amperes	Volts		AWS D1.5 Fillet		
AS REQ.	<u>7018</u>				<u>1F</u>		
	<u>1/8 (3.2)</u>	<u>70-170</u>	<u>22-26</u>	<u>AS REQ.</u>			
	<u>5/32 (3.9)</u>	<u>120-225</u>	<u>22-26</u>		<u>3/16 To 3/8 (5 To 10)</u>	<u>3/8 To 1/2 (10 To 13)</u>	<u>1/2 To 5/8 (13 To 16)</u>
	<u>3/16 (4.8)</u>	<u>170-300</u>	<u>24-27</u>				
	<u>8018</u>				<u>2F</u>		
	<u>1/8 (3.2)</u>	<u>90-160</u>	<u>22-26</u>				
<u>5/32 (3.9)</u>	<u>120-225</u>	<u>22-26</u>	<u>3/16 To 5/16 (5 To 8)</u>		<u>3/8 (10)</u>	<u>7/16 To 5/8 (11 To 16)</u>	
REQ.	<u>3/16 (4.8)</u>	<u>180-290</u>	<u>24-27</u>				
	<u>7028</u>						
	<u>5/32 (3.9)</u>	<u>170-270</u>	<u>22-26</u>				
	<u>3/16 (4.8)</u>	<u>210-330</u>	<u>24-27</u>				

RECEIVED

JUN 23 2010  
 RESUBMIT \_\_\_\_\_ APPROVED ✓  
 BY \_\_\_\_\_ DATE 7-8-10

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



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