

Casco Bay Steel Structures, Inc. 101 STRUCTURAL STEEL

WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A709-Gr50
 Welding process Flux Cored Arc welding
 Manual or machine Semi AUTO
 Position of welding Flat - Horizontal
 Filler metal specification AWS A5-29
 Filler metal classification E-81T1-Ni1Mn-H4 - Dual Shield 1180-Ni1-H4
 Flux NA
 Shielding gas 75% AR - 25% CO₂ Flow rate 35 CFH ±8, -4
 Single or multiple pass Single & Multiple
 Single or multiple arc Single
 Welding current DC
 Polarity DC EP
 Welding progression See Detail
 Root treatment Area to be free of Rust-slag - loose scale & moisture
 Preheat and interpass temperature See Table
 Postheat temperature NA
 Heat Input Min 34 kJ/in Max 43.7 kJ/in PAR-#3 - 33.6 kJ/in

Minimum Preheat and Interpass Temperature, °C [°F]

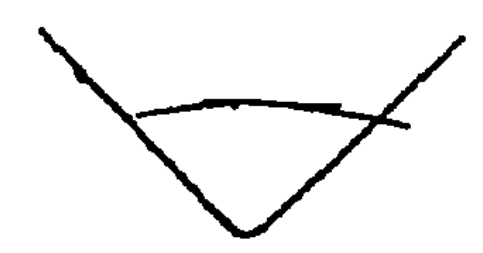
Welding Process (Base Metal)	Thickness of Thickest Part at Point of Welding, mm (in)				RESUBMIT	APPROVED
	To 20 mm [3/4 in] Incl.	Over 20 mm [3/4 in] to 40 mm [1-1/2 in] Incl.	Over 40 mm [1-1/2 in] to 65 mm [2-1/2 in] Incl.	Over 65 mm [2-1/2 in]		
SAW; OMAW; PCAW; SMAW (M270M [M270]) 345 [50]	10 [50]	20 [70]	65 [150]	110 [225]	BY	DATE 12/07/10

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VT - A ST, Bridgewater
 Proj. # BRS 0149(4)
 Br # 14, CBSS 454

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Sec 5-13 and NY-SCM AWS D1-5 Joint detail Fillet
		Amperes	Volts		
AS REQ	1/16	320	28	16	Flat Horizontal  To 1/2 To 3/8 INTERPASS Temp MAX - 260 °F
		288	27	14	
		To 340	To 30	To 18	

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 ST OF VT

Revision no. 1 - 8-3-09

Contractor Casco Bay Steel

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OCI

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