

Casco Bay Steel Structures, Inc.

5 Industry Road
South Portland, Maine 04106

Phone: (207) 772-2533

Fax: (207) 772-0580

III STRUCTURAL
STEEL

WELDING PROCEDURE SPECIFICATION







Material specification ASTM A109-Gr 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 ANSI/AWS A5.1 - A5.5
 Filler metal classification E7018 - 8018 1/32 - 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(9) 50°(10°) 3/4(9) TO 1 1/2(38) 70°(20°) 1 1/2(38) TO 2 1/2(63.5) 150°(65°) over 2 1/2(63.5) 225°(110°)
 Postheat temperature NA
 Heat Input Min NA Max NA

VT TRANS RECEIVED
 OK'D BY JWC
 DEC 07 2010
 RESUBMIT APPROVED
 BY DATE 12/07/10

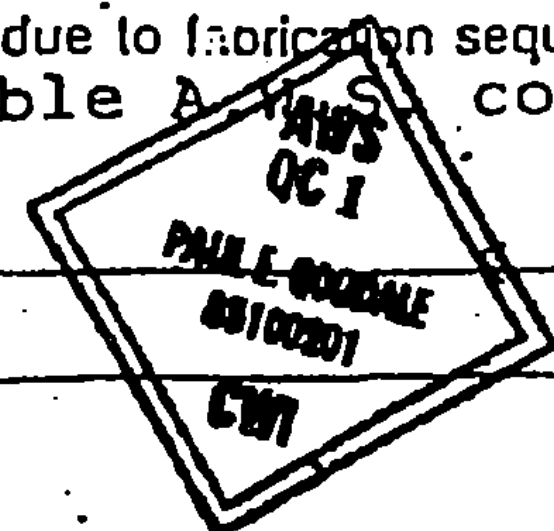
VT - ACT, BRIDGEWATER
 Proj # BRS 0149(4)
 BR # 14, CBSS 454

WELDING PROCEDURE

(Metric)

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

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

Revision no. _____

Form III-2

Contractor Casco Bay Steel

Authorized By Paul E. Hoodale

Date 8/28/10