

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A36 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) REVERSE
 Filler metal classification AST/AWS A51-A52
 Filler metal classification E7018-R018 C/25-7028
 Flux NA Flow rate NA
 Shielding gas NA
 Single or multiple pass Single and multiple
 Single or multiple arc Single
 Welding current AC/DCE
 Polarity Straight / Reverse
 Welding progression AS per AWS SPECIFICATION
 Preheat and interpass temperature To 3/4 (9) 50 (10) 3/4 (11) To 1 1/4 (8) 70 (10) 1 1/4 (8) To 2 1/4 (15) 150 (65)
 Preheat and interpass temperature over 2 1/4 (15) 225 (110)
 Postheat temperature NA
 Heat Input Min NA Max NA CHESTER VERMONT
BY NO. 43 Proj. No. BRP016(05)
CBSS No 369

WELDING PROCEDURE

Pass no	Electrode size	Welding current		Travel speed	AWS D1.5 Joint Detail	Fillet
		Amperes	Volts			
AS REQ	<u>2028</u> 1/8 (3.2)	70-170	22-26	AS REQ	1F	
	<u>5/32</u> (3.9)	120-225	22-26			
	<u>3/16</u> (4.8)	170-300	24-27			
	<u>2028</u> 1/8 (3.2)	90-160	22-26			
	<u>5/32</u> (3.9)	120-225	22-26			
	<u>3/16</u> (4.8)	180-290	24-27			
REQ	<u>2028</u> 5/32 (3.9)	170-270	22-26	REQ	2F	
	<u>3/16</u> (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 codes or contract specifications.

Procedure no 401 Contractor Casco Bay Steel
 Revision no _____ Authorized By Paul E. Hoodale
 Date 3/2/00

