

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification AWS D1.1/A572 Gr 50
 Welding process Shielded Metal Arc Welding (SMAW)
 Manual or machine Manual
 Position of welding Vertical (2F)
 Filler metal specification E 7018
 Filler metal classification E 7018
 Flux None
 Shielding gas None Flow rate None
 Single or multiple pass Single
 Single or multiple etc. None
 Welding current 175-225
 Polarity Direct
 Welding progression None
 Root treatment None
 Preheat and interpass temperature None
 Postheat temperature None
 Heat Input Min 1.8 Max 4.5 0.007 = 40' Chest 2v
 (1.15 kJ/in) (1.8 kJ/in) Br N.C. 43 Proj. No. BR F01610
C.B.S.S. 1/6 369

(Metric) WELDING PROCEDURE

Pass no	Electrode size	Welding current		Travel speed	AWS D1.1 Joint detail
		Amperes	Volts		
AS	1/16	275	28.8	11.6	1F
		247	26.8	10.4	
		302.5	30.8	12.8	
R64	6.1mm	275	28.8	2.946	2F
		247	26.8	2.642	
		302.5	30.8	3.2512	

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

Prepared by _____
 Revisions _____
 Form 112
 Contract _____
 Date _____