

# Casco Bay Steel Structures, Inc.

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## WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709/A709M Gr 36 (250) -50 (345) -50w (345w)  
 Welding process Flux Cored Arc welding  
 Manual or machine Semi-Auto  
 Position of welding Flat (1F) - Horizontal (2F)  
 Filler metal specification AWS-A5-29  
 Filler metal classification E 81T1-Ni1  
 Flux NA  
 Shielding gas 75% AR / 25% CO<sub>2</sub> Flow rate 35 LFH ± 8.6  
 Single or multiple pass Single and Multiple  
 Single or multiple arc Single  
 Welding current Direct  
 Polarity Reverse Electrode Positive  
 Welding progression \_\_\_\_\_  
 Root treatment To meet AWS D1.5 specification  
 Preheat and interpass temperature To 3/4 (19) 50° (104) - 3/4 (19) To 1/2 (12.7) 150° (65°) over 2/2 (64) 225° (110°)  
 Postheat temperature NA  
 Heat Input Min 28.6 (1.1 kJ/in) Max 45.0 (1.8 kJ/mm) PQR #2 = 40.9 (1.59) VT. AOT  
 E. MONTPELLIER  
 Br # 74-Prj # 028363  
 CBSS 400

(Metric) WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail Filler
		Amperes	Volts		
AS Req	1/16	275	28.8	11.6	
		TO	TO	TO	
		302.5	30.8	12.8	
	1-6	275	28.8	294.6	
		TO	TO	264.2	
		302.5	30.8	325.12	

TRANS RECEIVED  
 CR'D BY \_\_\_\_\_ OK'D BY JUL  
 APR 29 2009  
 RESUBMIT \_\_\_\_\_ APPROVED \_\_\_\_\_  
 BY \_\_\_\_\_ DATE 5/1/09

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-A  
 Revision no 1  
 Form III 2

Contract Casco Bay Steel  
 Authorize [Signature]  
 Date 9/2007