

# Casco Bay Steel Structures, Inc.

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**VT RECEIVED**

CK'D BY \_\_\_\_\_ OK'D BY JUC

APR 29 2009  
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RESUBMIT \_\_\_\_\_ APPROVED

BY \_\_\_\_\_ DATE 5/11/09

## WELDING PROCEDURE SPECIFICATION

Material specification ASTM A36-50-50W (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 A51-A5.5  
 Filler metal classification E7018-8018 3/16 - 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  
 Pre-heat and interpass temperature To 3/4(9) 50°F(10°) 3/4(9) To 1/2(3.8) 70°F(20°) 1/2(3.8) To 2/4(6.3.5) 150°F(65°) over 2/4(6.3.5) 225°F(110°)  
 Post-heat temperature NA  
 Heat Input Min NA Max NA

VT AOT  
 E MONTPELLIER  
 Br # 74-Prj # 283(36)  
 CBSS LLC

### WELDING PROCEDURE

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>		
	<u>5/32</u> (3.9)				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>3/16</u> (4.8)						
REQ	<u>8018</u> 1/8 (3.2)	90-160	22-26	REQ	<u>2F</u>		
	<u>5/32</u> (3.9)				3/16 To 5/16 (5 To 8)	3/8 (10)	7/16 To 5/8 (11 To 16)
	<u>3/16</u> (4.8)						
REQ	<u>7028</u> 5/32 (3.9)	170-270	22-26	REQ			
	<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 AWS codes or contract specifications.

Procedure no 401  
 Revision no \_\_\_\_\_  
 Form III 2



Contractor Casco Bay Steel  
 Authorized By Paul E. Hoodale  
 Date 3/2/00