

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 36 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) VTRANS
 Filler metal specification AWS/A5.1 - A5.5 RECEIVED
 Filler metal classification E7018 - 8018 C/C3 - 702B OK'D BY JWC
 Flux NA
 Shielding gas NA Flow rate NA FEB 21 2007
 Single or multiple pass Single and multiple RESUBMIT APPROVED
 Single or multiple arc single
 Welding current AC/DC BY DATE 2-23-07
 Polarity Straight / Reverse
 Welding progression
 Root treatment MEET AWS SPECIFICATION
 Preheat and interpass temperature To 3/4(9) 50°F(10°) 3/4(9) TO 1 1/2(38) 70°F(20°) 1 1/2(38) TO 2 1/2(63.5) 150°F(65°)
 Postheat temperature NA over 2 1/2(63.5) 225°F(110°)
 Heat Input Min NA Max NA

VT. 15 over Lamille Rd.
Cambridge VT
Proj. BHF-030-2-19-5
B/F No. 20, CBSS 313

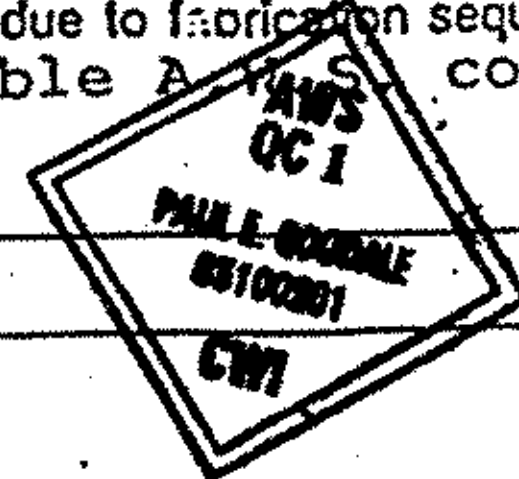
WELDING PROCEDURE

(Metric)

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5	Joint detail	Fillet
		Amperes	Volts				
AS REQ.	<u>7018</u>				<u>1F</u>		
	<u>1/8 (3.2)</u>	<u>70-170</u>	<u>22-26</u>				
	<u>5/32 (3.9)</u>	<u>120-225</u>	<u>22-26</u>				
	<u>3/16 (4.8)</u>	<u>170-300</u>	<u>24-27</u>				
	<u>8018</u>						
	<u>1/8 (3.2)</u>	<u>90-160</u>	<u>22-26</u>				
AS REQ.	<u>5/32 (3.9)</u>	<u>120-225</u>	<u>22-26</u>		<u>2F</u>		
	<u>3/16 (4.8)</u>	<u>180-290</u>	<u>24-27</u>				
	<u>702B</u>						
	<u>5/32 (3.9)</u>	<u>170-270</u>	<u>22-26</u>				
	<u>3/16 (4.8)</u>	<u>210-330</u>	<u>24-27</u>				

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