

Casco Bay Steel Structures, Inc.

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South Portland, Maine 04106

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WELDING PROCEDURE SPECIFICATION

Material specification A36-A572-A588 (ASTM 709 Gr 36-50-50W)
 Welding process Flux Cored Arc welding (FCAW)
 Manual or machine Semi-AUTO
 Position of welding Flat
 Filler metal specification AWS 5.20
 Filler metal classification E71T-1
 Flux NA
 Shielding gas 75% AR 25% CO₂ Flow rate 40 F5
 Single or multiple pass single Electrode stick out 3/4 ± 1/4
 Single or multiple arc single
 Welding current Direct Current
 Polarity Reverse Electrode Positive
 Welding progression see Detail
 Root treatment meat A.W.S. weld from one side only
 Preheat and interpass temperature 0 to 3/4-50° (19-10°) + 3/4 to 1 1/2-70° (19 to 38-20°)
 Postheat temperature NA
 Heat Input Min NA Max NA

VT. 15 over LaMille Rd
Cambridge VT
Proj. BHF-030-2-19-5
By No. 20, CBSS 313

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1-5 Square groove joint detail Fillet BUTT
		Amperes	Volts		
	1/16	280 ± 28	25 ± 1.7	17 IPm ± 1.7	
	1.6	280 ± 28	25 ± 1.7	432 ± 43.2	

CK'D BY _____ OK'D BY JWC
 FEB 21 2007
 RESUBMIT _____ APPROVED

BY _____ DATE 3-5-07
 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. 105
 Revision no. _____
 Form III-2
 AWS-QC1
 Paul E. Goodale
 8310201
 C.W.I.

Contractor Casco Bay Steel
 Authorized By Paul E. Goodale
 Date 2/2/99