

# Casco Bay Steel Structures, Inc.

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## WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709/A709M-Grade 36(250) 50(345) 50W(345W)  
 Welding process Flux Cored Arc welding (FCAW)  
 Manual or machine Semi Auto  
 Position of welding FLAT (1G) Horizontal (2G)  
 Filler metal specification AWS A5-20  
 Filler metal classification E71T-1  
 Flux NA  
 Shielding gas 75% AR 25% CO2 Flow rate 40CFH ±5  
 Single or multiple pass Single and Multiple - Electrode Extension 5/8 ± 1/4 (15.87 ± 6.35)  
 Single or multiple arc Single  
 Welding current DC  
 Polarity Reverse  
 Welding progression See Joint Detail  
 Root treatment To meet AWS specification  
 Preheat and interpass temperature To 3/4 (19) = 50° (10°) - 3/4 (19) To 1/2 (38) = 70° (20) - 1/2 (38) To 2 1/2 (63) = 150° (65) over 2 1/2 (63) = 225° (110°)  
 Postheat temperature NA  
 Heat input Min \_\_\_\_\_ Max \_\_\_\_\_

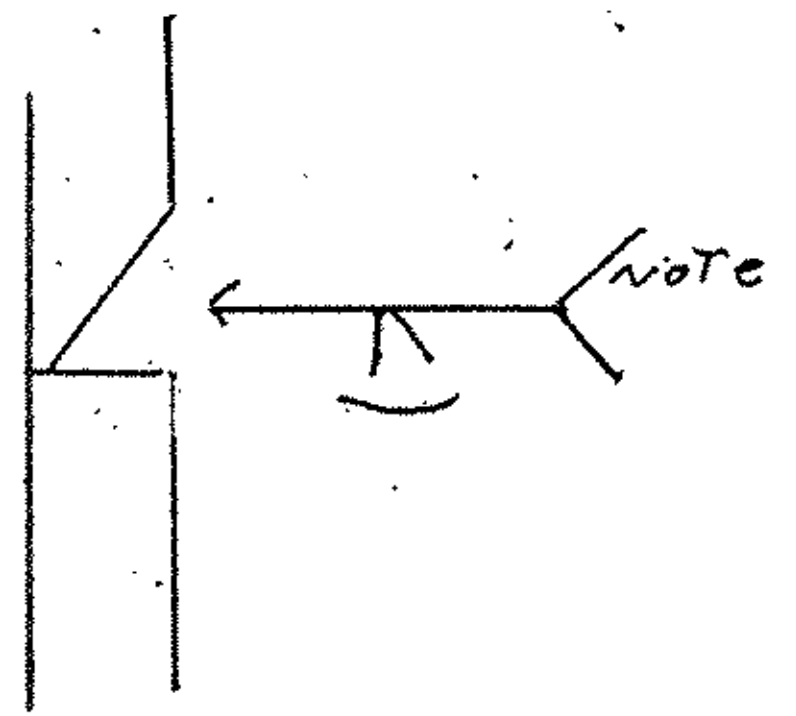
VT. 15 over Lammille Rd  
Cambridge VT  
Proj. BHF-030-2-19-5  
BPN No. 20, CBSS 313

## WELDING PROCEDURE

(METRIC)

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
	1/16	275	28.8	11.6
		247.5	26.8	10.4
		To 302.5	To 30.8	To 12.8
	1.6	275	28.8	294.6
		247.5	26.8	264.2
		To 302.5	To 30.8	To 325.12

Joint detail: AWS D1.5 T&P4-F



NOTE: GRIND FLUSH AS REQ

RECEIVED

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

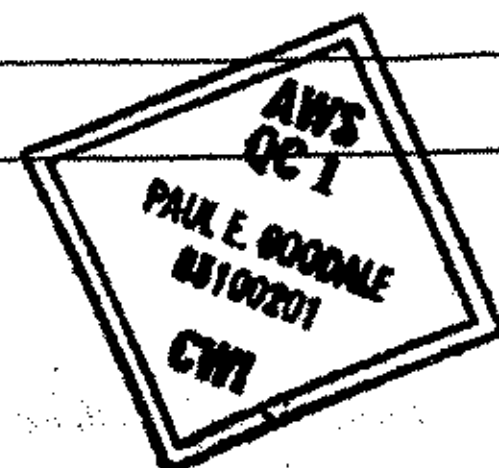
FEB 21 2007

RESUBMIT \_\_\_\_\_ APPROVED \_\_\_\_\_  
 BY 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. 103  
 Revision no. \_\_\_\_\_

Contractor Casco Bay Steel  
 Authorized By Paul E. Goodale  
 Date 3/23/00

Form III-2



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