

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 (1F) Horizontal (2F)
 Filler metal specification AWS A5-20
 Filler metal classification E71T-1
 Flux NA
 Shielding gas 75% AR 25% CO2 Flow rate 40 CFH ± 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 _____
 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)
 Postheat temperature NA
 Heat input Min NA Max NA

Cambridge VT,
Proj # BH-030-2(4) S
Br # 20 CBSS # 313

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
1/16		275	28.8	11.6	1F 
		247.5	26.8	10.4	
		To 302.5	To 30.8	To 12.8	
1.6		285	28.8	294.6	2F 
		247.5	26.8	264.2	
		To 302.5	To 30.8	To 325.12	

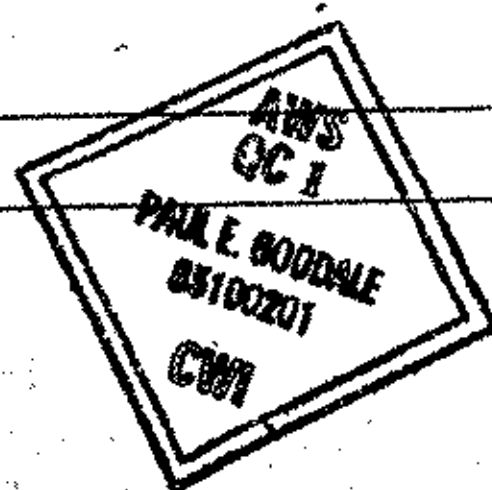
To 1/2 (12.7) VTRANS
 RECEIVED
 CK'D BY _____ OK'D BY Juc
 MAR 09 2007
 RESUBMIT _____ APPROVED
 BY _____ DATE 3-22-07
 To 3/8 (9.5)

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

Revision no. _____

Form III-2



Contractor Casco Bay Steel

Authorized By Paul E. Goodale

Date 3/23/07

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