

Casco Bay Steel Structures, Inc.

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Saco, Maine 04072

Phone: (207) 282-7360

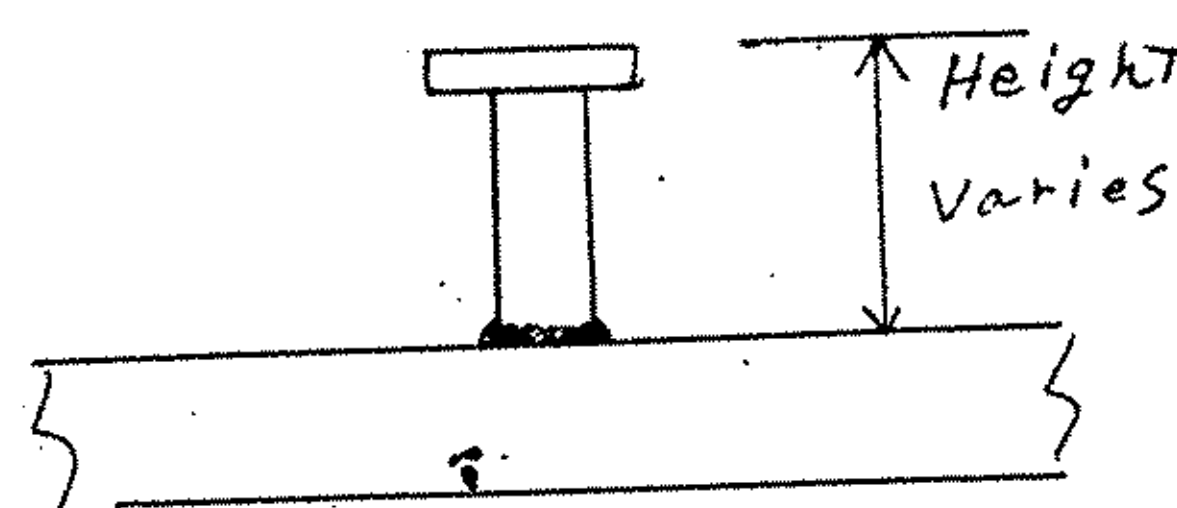
Fax: (207) 282-1179

WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A709/A709M-Gr36-50-50W(250-345-345W)
 Welding process STUD welder (S.W.)
 Manual or machine Machine
 Position of welding Flat
 Filler metal specification NA
 Filler metal classification NA
 Flux NA
 Shielding gas NA Flow rate NA
 Single or multiple pass single
 Single or multiple arc single
 Welding current DC
 Polarity DC EN
 Welding progression NA
 Root treatment Clean Surface To be welded
 Preheat and interpass temperature To 3/4"-50°F, 3/4" to 1 1/2" - 70°F, 1 1/2" to 2 1/2" - 150°F, over 2 1/2" - 225°F
 Postheat temperature NA
 Heat Input Min NA Max NA

Cambridge VT,
Proj # BH-030-249S
BY #20 CBSS #313

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
	STUD size		Weld TIME		AWS D1-1 Joint detail AWS D1-5 
	1/2	350 650	.35±	NA	
	5/8	350 650	.35±		
	3/4	550 750	.40±		
	7/8	650 VTRANS 850 RECEIVED	1.0±		

OK'D BY _____ OK'D BY JWC
 MAR 09 2007
 RESUBMIT _____ APPROVED _____
 DATE 3-22-07

Note:
This procedure is only a guide To set up.

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. # I S.W.

Revision no. _____

Form III-2

Contractor Casco Bay Steel
 Authorized By Paul E. Godale
 Date May 3-1999

