

Casco Bay Steel Structures, Inc.

75 Spring Hill Road
Saco, Maine 04072

Phone: (207) 282-7360

Fax: (207) 282-1179

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A36 Gr 36-50-50W (250-345-345W)
 Welding process Shielded Metal Arc welding (SMAW)
 Manual or machine Manual
 Position of welding Flat (1G), Horizontal (2G)
 Filler metal specification AWS/A5-1 - A5-5
 Filler metal classification E7018 - 8018 1/8" - 7028
 Flux NA
 Shielding gas NA Flow rate NA
 Single or multiple pass Single and multiple
 Single or multiple arc Single
 Welding current AC / DC
 Polarity Straight / Reverse
 Welding progression _____
 Root treatment To AWS specification
 Preheat and interpass temperature To 3/4" (19) 50°F (100) 3/4" (19) To 1/2" (36) 70°F (200)
 Postheat temperature NA
 Heat Input Min NA Max NA

Cambridge VT,
Proj# BH-030-2 (AS)
BR# 20 CBSS# 313

WELDING PROCEDURE

(METRIC)

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
AS	7018 1/8 (3.2)	70-170	22-26	AS	AWS D1.5 Joint detail B-U46
	5/32 (3.9)				
REQ	8018 1/8 (3.2)	90-160	22-26	REQ	
	5/32 (3.9)				
	7028 5/32 (3.9)	170-270	22-26		<p>RECEIVED</p> <p>CK'D BY _____ CK'D BY JUC</p> <p>MAR 09 2007</p> <p>RESUBMIT _____ APPROVED _____</p> <p>BY _____ DATE 3-22-07</p> <p>T1 = UNLIMITED, Note - Grind Flush as REQ.</p>

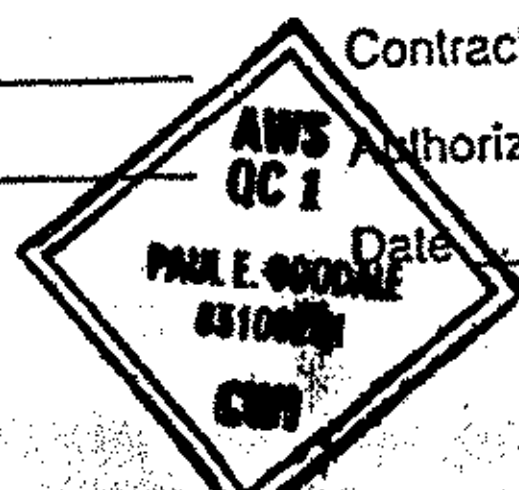
This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in applicable A.W.S. codes or contract specifications

Procedure no. 402

Revision no. _____

Form III-2

Contractor Casco Bay Steel
 Authorized By Paul E. Goodale
 Date 10-16-01



090 EJ