

# Casco Bay Steel Structures, Inc.

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## WELDING PROCEDURE SPECIFICATION

Material specification ASTM A109 Gr 36-50-50W (250-345-345W)  
 Welding process Shielded Metal Arc welding (SMAW)  
 Manual or machine Manual  
 Position of welding FLAT (1F), HORIZONTAL (2F)  
 Filler metal specification ANSI/AWS A5.1 - A5.5  
 Filler metal classification E7018-8018 C/C3 - 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 MEET AWS SPECIFICATION  
 Preheat and interpass temperature To 3/4(19) 50°F(10°C) 3/4(19) To 1 1/2(38) 70°F(20°C) 1 1/2(38) To 2 1/2(63.5) 150°F(65°C) over 2 1/2(63.5) 225°F(110°C)  
 Postheat temperature NA  
 Heat Input Min NA Max NA

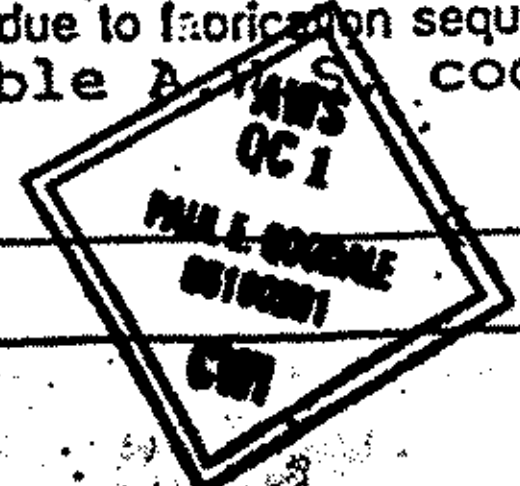
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## WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5	Joint detail	Fillet
		Amperes	Volts				
AS. REQ.	<u>7018</u> 1/8 (3.2)	70-170	22-26	AS REQ.	1F		
	5/32 (3.9)	120-225	22-26				
	3/16 (4.8)	170-300	24-27				
	<u>8018</u> 1/8 (3.2)	90-160	22-26				
	5/32 (3.9)	120-225	22-26				
	3/16 (4.8)	180-290	24-27				
REQ.	<u>7028</u> 5/32 (3.9)	170-270	22-26		2F		
	3/16 (4.8)	210-330	24-27				

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

Procedure no. 401  
 Revision no. \_\_\_\_\_  
 Contractor Casco Bay Steel  
 Authorized By Paul E. Hoodeale  
 Date 3/2/00



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