

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification A36-A572-A588 (ASTM 709 Gr 36-50-50w)
 Welding process FLUX Cored Arc welding (FCAW)
 Manual or machine Semi-AUTO
 Position of welding FLAT-1G
 Filler metal specification AWS A5-20
 Filler metal classification E71T-1
 Flux NA
 Shielding gas 75% AR 25% CO₂ Flow rate 40 ± 5
 Single or multiple pass BOTH Electrode STICK OUT 3/4 ± 1/4
 Single or multiple arc SINGLE
 Welding current DIRECT CURRENT
 Polarity Reverse Electrode positive
 Welding progression see Detail
 Root treatment weld side #1, backgauge side #2 - grind - then weld
 Preheat and interpass temperature To 3/4-50° (19-10°) + 3/4 to 1 1/2-70° (+19 to 38-20°)
 Postheat temperature NA
 Heat Input Min NA Max NA

Cambridge VT,
 Proj# BH-030-209S
 Br#20 CBSS#313

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
	1/16	280 ± 28	25 ± 1.7	11 ± 1.1
	1/8	280 ± 28	25 ± 1.7	280 ± 28

OK'D BY _____ OK'D BY JUC

RESUBMIT _____ APPROVED ✓

BY _____ DATE 3-22-07

AWS D1.5 Joint detail BU2-F

T1 - UNLIMITED
 F - 0 to 1/8 / 0 to 3.2mm
 R - 0 to 1/8 / 0 to 3.2mm

1-GRIND as required

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. 104 Contractor Casco Bay Steel
 Revision no. _____ Authorized By Paul E. Goodale
 Form III-2 AWS-QC1 Paul E. Goodale Date 2/2/99
 8310201 C.W.I.

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