

**Casco Bay Steel Structures, Inc.**

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South Portland, Maine 04106

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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: AWS/A5.1 - A5.5  
 Filler metal classification: E7018-R018 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/DCE  
 Polarity: Straight / Reverse  
 Welding progression: Meet AWS Specification  
 Root treatment: Meet AWS Specification  
 Preheat and interpass temperature: To 34(9) 50(40) 3/4(19) To 1/4(38) 70(20) 1/2(13) 150(65) over 1/2(13) 225(110)  
 Postheat temperature: NA  
 Heat Input Min: NA Max: NA

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 Barton VT Gr 10 G1  
 Proj No. BA0 1449 (29)  
 CB SS No 323

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
A5	7018 1/8 (3.2)	70-170	22-26	AS	IF
	5/32 (3.9)	120-225	22-26		
	3/16 (4.8)	170-300	24-27		
REQ	7018 1/8 (3.2)	90-160	22-26	REQ	2F
	5/32 (3.9)	120-225	22-26		
	3/16 (4.8)	180-290	24-27		
REQ	7028 5/32 (3.9)	170-270	22-26	REQ	3/16 to 5/16 (5 To 8)
	3/16 (4.8)	210-330	24-27		
	3/16 (4.8)	210-330	24-27		

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

Procedure no. 401  
 Revision no. 1  
 Form III-2  
 Contractor Casco Bay Steel  
 Authorized By Paul E. Hoodale  
 Date 3/2/00