

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

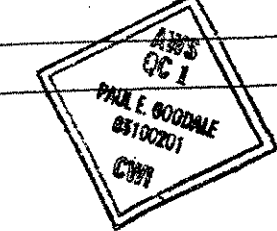
Material specification ASTM A209/A209M - Grade 36 (250) 50 (45) 50w (345w)
 Welding process Flux Cored Arc welding (FCAW)
 Manual or machine Semi Auto
 Position of welding Flat (1F) Horizontal (2F)
 Filler metal specification AWS A5-20
 Filler metal classification E71T-1
 Flux NA
 Shielding gas 75% AR 25% CO2 Flow rate 40 CFH ± 5
 Single or multiple pass Single and Multiple - Electrode Extension 8/8 ± 4 (5.8) ± 6.35
 Single or multiple arc Single
 Welding current DC
 Polarity Reverse
 Welding progression To meet AWS specification
 Root treatment To meet AWS specification
 Preheat and interpass temperature To 3/4 (19) 50 (110) - 3/4 (19) To 1 1/2 (38) 70 (150) To 2 1/4 (63) 150 (65) over 2 1/2 (63) = 225 (110)
 Postheat temperature NA
 Heat Input Min NA Max NA Boston VT 6/10/01
Proj No. BRC 1449 (29)
CBS 20 323

(METRIC) WELDING PROCEDURE

| Pass no. | Electrode size | Welding current | | Travel speed | Joint detail |
|----------|----------------|-----------------|-------|--------------|--|
| | | Amperes | Volts | | |
| 1/16 | 1/16 | 2.75 | 28.8 | 11.6 | 1F To 1/2 (12.7) TRANS RECEIVED DATE 6/25/07 |
| | | 247.5 | 26.8 | 10.4 | |
| | | 302.5 | 30.8 | 12.8 | |
| 1.6 | 1.6 | 2.75 | 28.8 | 294.6 | 2F To 3/8 (9.5) |
| | | 247.5 | 26.8 | 244.2 | |
| | | 302.5 | 30.8 | 325.12 | |

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. 101 Contractor Casco Bay Steel
 Authorized By Paul E. Goodale
 Date 3/23/00



103 bJ