

Casco Bay Steel Structures, Inc.

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Saco, Maine 04072

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709/A 709M - Grade 36 (50) 50 (45) 50w (345w)
 Welding process Flux Cored Arc welding (FCAW)
 Manual or machine Semi Auto
 Position of welding FLAT (G) Horizontal (2G)
 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 5/8" ± 4 (5.8) ± 6.35
 Single or multiple arc SINGLE
 Welding current DC
 Polarity Reverse
 Welding progression See Joint Detail
 Root treatment To meet AWS SPECIFICATION
 Preheat and Interpass temperature To 3/4 (19): 50 (10) - 3/4 (19) To 1 1/2 (38): 70 (20) - 1 1/2 (38) To 2 1/4 (63) 150 (65)
 Postheat temperature NA
 Heat Input Min _____ Max Barton VT 610 61
Proj: MGRG 1449 (29)
CLASS NO 323

(METRIC)

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
1/16	275	28.8	11.6	
	247.5	26.8	10.4	
	70	70	70	
	302.5	30.8	12.8	
1.6	275	28.8	294.6	
	247.5	26.8	264.2	
	70	70	70	
	302.5	30.8	325.12	

Joint detail: TC P4-F

NOTE: Grind Flush as Req

APPROVED BY: _____ DATE: 6/27/07

RESUBMIT: _____ APPROVED: _____

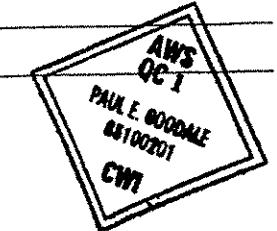
OK'D BY: _____ OK'D BY: JWC

JUN 25 2007

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. 103
 Revision no. _____
 Form III-2

Contractor Casco Bay Steel
 Authorized By: P.O. Goodell
 Date 3/23/07



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