Casco Bay Steel Structures, Inc.

WELDING PROCEDURE SPECIFICATION

Material specification: ASTM Gr 50-50W
Welding process: Shielded Metal ARC
Manual or machine: Manual
Position of welding: Flat, Horizontal
Filler metal specification: ANSI/AWS A5.1-A5-5
Filler metal classification: E 7018 - E8018 C1 C3
Flux: NA
Shielding gas: NA Flow rate: NA
Single or multiple pass: Single & Multiple
Single or multiple arc: Single
Welding current: AC / DC
Polarity: STraight & Reverse
Welding progression: See Detail
Root treatment: Grind-wire brush-Area Free of Slag-RUST-Moisture
Preheat and interpass temperature:
Posfheat temperature: NA
Heat Input Min: NA Max: NA

Minimum Preheat and Interpass Temperature, °C (°F)

Welding Process (Base Metal)	To 20 mm [3/4 in] Incl.	Over 20 mm [3/4 in] to 40 mm [1-1/2 in] Incl.	Over 40 mm [1-1/2 in] to 65 mm [2-1/2 in] Incl.	Over 65 mm [2-1/2 in]
		Thickness of Thicker Part at Point of Welding, mm [in]		
SAW; GMAW; FCAW; SMAW (M270M [M270] [A 709M [A 709]] Gr. 250 [36], 345 [50], 345W [50W], HPS 345W (HPS 50W))	10 [50]	20 [70]	65 [150]	110 [225]

VT-AOT: Bristol
Bridge NO. 31
Proj No. BRO 1445(39)
CBSS NO. 534

WELDING PROCEDURE

Pass no.	Electrode size	Welding current: Amperes	Welding current: Volts	Travel speed
	7018			
AS	1/8	70 To 190	22-26	
	5/32	120 To 225	22-26	AS
Req	3/16	170 To 300	24-27	
	8018			Req
	1/8	90 To 160	22-26	
	5/32	120 To 225	22-26	
	3/16	180 To 290	24-27	

AWS D1-5 Joint detail Fillet

2F

1F

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. 401
Revision no

Contractor Casco Bay Steel
Authorized By Robert E. Goodrich
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