

# 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 E7018-E8018 CVC3  
 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 \_\_\_\_\_  
 Postheat temperature NA  
 Heat Input Min NA Max NA

Vermont Agency of Transportation

**RECEIVED**

CK'D BY JWC OK'D BY \_\_\_\_\_

November 4, 2013

RESUBMIT No Approved


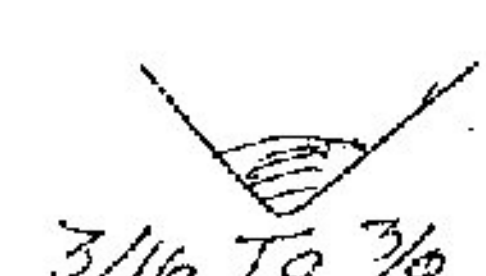
BY James Lacroix DATE 11/08/2013

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

Welding Process (Base Metal)	Thickness of Thickest Part at Point of Welding, mm (in)			
	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)
SAW; GMAW; FCAW; SMAW (M270M [M270] [A 709M [A 709]] Cr. 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. BRD 1445(30)  
C.B.S.S. NO. 534

### WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail
		Amperes	Volts		
AS Req	<u>7018</u>				<u>2F</u>
	<u>1/8</u>	<u>70 to 190</u>	<u>22-26</u>	AS Req	
	<u>5/32</u>	<u>120 to 225</u>	<u>22-26</u>		
	<u>3/16</u>	<u>170 to 300</u>	<u>24-27</u>		
	<u>8018</u>				<u>1F</u>
	<u>1/8</u>	<u>90 to 160</u>	<u>22-26</u>		
<u>5/32</u>	<u>120 to 225</u>	<u>22-26</u>			
<u>3/16</u>	<u>180 to 290</u>	<u>24-27</u>			

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

Contractor Casco Bay Steel

Revision no. \_\_\_\_\_

Authorized By Paul E. Dondant

Date April 13, 2012