

Casco Bay Steel Structures, Inc.

5 Industry Road
South Portland, Maine 04106

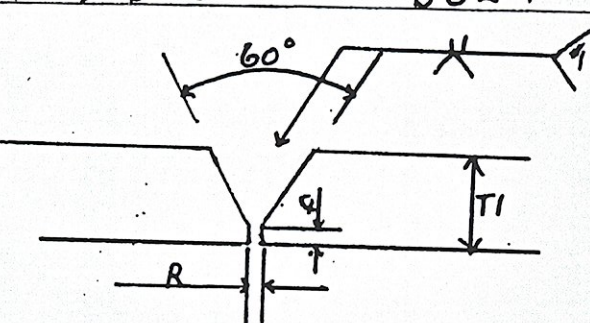
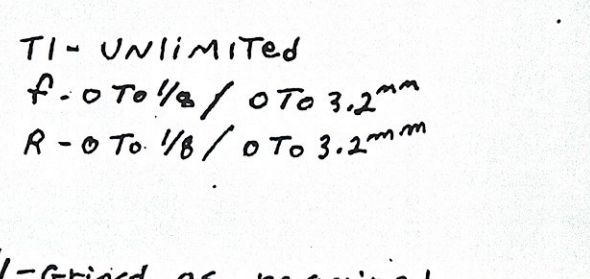
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WELDING PROCEDURE SPECIFICATION

Material specification A36-A572-A588 (ASTM A36-A572-A588)
Welding process Flux Cored Arc welding (FCAW)
Manual or machine SEMI-AUTO
Position of welding FLAT-IG
Filler metal specification AWS A5-20
Filler metal classification E71T-1
Flux NA
Shielding gas 75% AR 25% CO₂ Flow rate 40 ± 5
Single or multiple pass BOTH Electrode stick out 3/4 ± 1/4
Single or multiple arc SINGLE
Welding current DIRECT CURRENT
Polarity REVERSE ELECTRODE POSITIVE
Welding progression SEE DETAIL
Root treatment WELD SIDE * 1 BACKGROUNDE SIDE * 2 GRIND * THEN WELD
Preheat and interpass temperature TO 34-50° F (1-10° * 34 TO 114-120° (19 TO 38-20°)
Postheat temperature NA
Heat Input Min NA Max NA BRIDGE No. 5
MONTPELIER, VT.
CBSS Job # 434

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail BU2-F
		Amperes	Volts		
	1/16	280 ± 28	25 ± 1.7	11 ± 1.1	
	1/8	280 ± 28	25 ± 1.7	280 ± 28	

TRANS RECEIVED
CK'D BY JWC
APR 22 2010
RESUBMIT APPROVED
BY DATE 05/04/10

T1 - UNLIMITED
R - 0 TO 1/8 / 0 TO 3.2mm
R - 0 TO 1/8 / 0 TO 3.2mm
1-Grind as required

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. 104 Contractor Casco Bay Steel
Revision no. AWS-OC1 Authorized By Paul E. Goodale
Form III-2 Paul E. Goodale Date 2/2/99
G.W.I.