

Casco Bay Steel Structures, Inc.

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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
Filler metal specification AWS 5.20
Filler metal classification E71T-1
Flux AA
Shielding gas 75% Ar 25% CO₂ Flow rate 40 F5
Single or multiple pass Single Electrode stick out 3/4" ± 1/4"
Single or multiple arc Single
Welding current Direct Current
Polarity Reverse Electrode Positive
Welding progression see Detail
Post treatment None AWS vs. 16 from one side only
Preheat and interpass temperature 275-345° (19-100° F) 1/4" to 3/8" (19-100° F)
Postheat temperature None AWS VT-AOT, BPA-5
Heat input Min NA Max NA Boiler Code 640063D
Per ST BC, CBSS 434

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5
		Amps	Volts		
	1/16	280 ± 20	25 ± 1.7	175 in ± 1.7	Square groove joint detail Butt
	1/8	280 ± 20	25 ± 1.7	175 in ± 1.7	Butt

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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

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Form III-2
Contractor Casco Bay Steel
Authorized By Paul E. G.
Date 2/2/99