

Casco Bay Steel Structures, Inc.
 75 Spring Hill Road
 Saco, Maine 04072

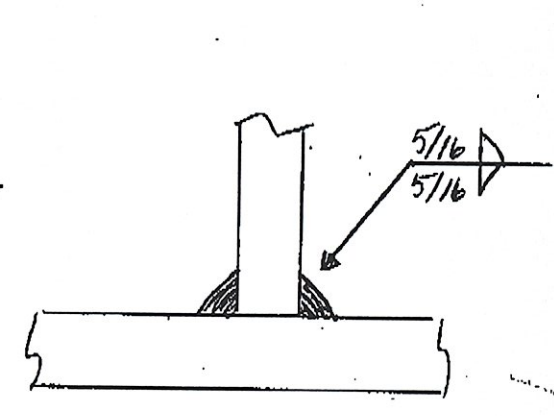
Phone: (207) 282-7360

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 709 - Gr 36-50-50W / A 709M Gr 250-345-345W
 Welding process Flux cored arc welding (FCAW)
 Manual or machine Semi AUTO
 Position of welding Flat - Horizontal
 Filler metal specification AWS A5-29
 Filler metal classification E81T1-Ni-HW ESAB
 Flux NA
 Shielding gas 75% Ar - 25% CO₂ Flow rate 35 CFH ± 4
 Single or multiple pass Single / Multiple Elec Ex 1/4 ± 1/4
 Single or multiple arc Single
 Welding current DCRP
 Polarity DCRP
 Welding progression See detail
 Root treatment wire brush - area to be Free of loose scale, slag, rust & moisture
 Preheat and interpass temperature To 200 (394) (1850), 80 (302) to 10 (1/2) 200 (394) 40 (1/2) 200 (394) 65 (150)
 Postheat temperature NA
 Heat Input Min 2.7 kJ/in Max 43.6 kJ/in PQR FCM # 8 39.6 kJ/in
 VT-AOT, BFN-5
 Reg. No. BHF 6400(2)
 12/1er ST Br, CBS 434

Pass no.	Electrode size	Welding current		Travel speed
		Amps	Volts	
1/16	2.87	29	13	AWS D1-5 Joint detail Fillet
	2.58	26.8	11.4	
	To	To	To	
	3.15	31	14	



VT TRANS RECEIVED
 CK'D BY: _____ DATE: _____
 JAN 27 2010
 APPROVED BY: _____ DATE: 02/14/10

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. 101 Contractor Casco Bay Steel
 Revision no. _____ Authorized By Paul C. Goodale
 Form II-2 Date 12-6-06