

**Casco Bay Steel Structures, Inc.**

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**WELDING PROCEDURE SPECIFICATION**

Material specification ASTM A572-Gr36-50-50W (250-345-342W)  
 Welding process Shielded Metal Arc Welding (SMAW)  
 Manual or machine Manual  
 Position of welding Flat (1G) Horizontal (2G)  
 Filler metal specification A572/A575-A5-1-A5-5 ✓ TRANS  
 Filler metal classification E7018-B018023-025B  
 Flux NA  
 Shielding gas NA Flow rate NA  
 Single or multiple pass Single and multiple 1/11/10  
 Single or multiple arc Single  
 Welding current AC DCE RESUBMIT APPROVED ✓  
 Polarity STRAIGHT / Reverse BY DATE 02/12/10  
 Welding progression  
 Root treatment To AWS SPECIFICATION  
 Preheat and interpass temperature To AWS (100) 1/2 (100) 70° (200)  
 Postheat temperature NA  
 Heat input Min NA Max NA

**WELDING PROCEDURE (METRIC)**

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amps	Volts		
A5	7018 1/8 (3.2)	70-170	22-26	AWS D1.5	B-U46
	5/32 (3.9)	120-225	22-26		
REQ	8018 1/8 (3.2)	90-160	22-26	REQ	
	5/32 (3.9)	120-225	22-26		
	7028 5/32 (3.9)	170-270	22-26		

*TI: UNLIMITED WATER-COOLING FLOW*

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. 402 Contractor Casco Bay Steel  
 Revision no. 10-16-01 Authorized By Tom J. Boudreau  
 Form III-2

