

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

Phone: (207) 282-7360

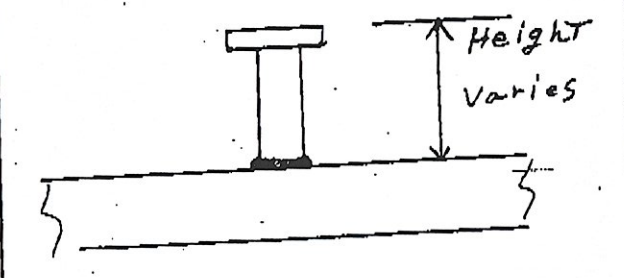
Fax: (207) 282-1179

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709/A709M - Gr 36-50-50w (250-345-345W)
 Welding process STUD WELDER
 Manual or machine MACHINE
 Position of welding FLAT
 Filler metal specification NA
 Flux NA Flow rate NA
 Shielding gas NA
 Single or multiple pass SINGLE
 Single or multiple arc SINGLE
 Welding current DC EN
 Polarity DC EN
 Welding progression NA
 Root treatment Clean
 Preheat and interpass temperature 1/2" To 1/2-70° 3/4" To 1/2-150° over 2 1/2" 225°
 Postheat temperature NA
 Heat input Min NA Max NA

WELDING PROCEDURE
VT-AOT, BY NO-5
Proj. No. RHF 6400(3)
Taylor St. Br. CB5434

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
	5/16	350	35±	NA
	1/2	650	35±	
	5/8	650	35±	
	3/4	550	40±	
	7/8	650	1.0±	



Note:
 This procedure is only a guide to setup.

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. # I S.W.
 Revision no. _____
 Form W-2

Contractor Casco Bay Steel
 Authorized By [Signature]
 Date May 3-1998

