

Casco Bay Steel Structures, Inc.

75 Spring Hill Road
Saco, Maine 04072

Phone: (207) 282-7360

Fax: (207) 282-1179

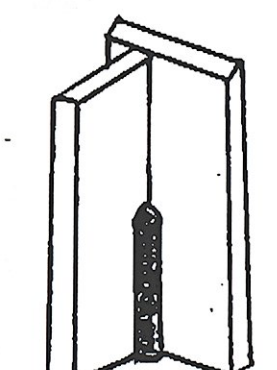
WELDING PROCEDURE SPECIFICATION

Material specification ASTM A572 Gr 50 (250-345-345W)
 Welding process Shielded Metal Arc welding (SMAW)
 Manual or machine Manual
 Position of welding vertical up (3F)
 Filler metal specification AWS E7018 A5.1 - A5.5 V TRAYS
 Filler metal classification E7018 - R018 0%3
 Flux NA
 Shielding gas NA Flow rate NA
 Single or multiple pass single - multiple
 Welding current DC
 Polarity Positive
 Welding progression see Detail
 Root treatment Area To be Free of loose Scale, Slag, Rust or Moisture
 Preheat and interpass temperature To 34 (19) 50 (10), 34 (19) To 120 (38) To 200 (149) To 210 (100)
 Postheat temperature NA
 Heat Input Min NA Max NA


VT-AOT, BRNO-5
 Proj. NO. B4F6400(AD)
 Job, 1er St. Br., CBSS432

(Metric) WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS DI-5 Joint detail
		Amperes	Volts		
7018 1/8 (3.2)	70-170	22-26	22-26		FILLET
		120-190			
8018 1/8 (3.2)	90-160	22-26	22-26		FILLET
		130-200			



NOTE:
For Tacking and repair welding
To Code 5-27-06



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. 403 Contractor Casco Bay Steel
 Revision no. 1 Authorized By Paul F. [Signature]
 Form III-2 Date 4-24-03