

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification A36-A572-A588 (ASTM 909 Gr 36-50-50w)
 Welding process Flux Cored Arc welding (FCAW)
 Manual or machine semi-AUTO
 Position of welding Flat-1G
 Filler metal specification AWS A5-20
 Filler metal classification E91T-1
 Flux NA
 Shielding gas 75% AR 25% CO₂ Flow rate 40 ± 5
 Single or multiple pass Both Electrode stick out 3/4 ± 1/4
 Welding current Direct current
 Polarity Reverse Electrode positive
 Welding progression see detail
 Root treatment weld side 1, backgauge side 2 - grind - then weld
 Preheat and interpass temperature To 34-50° (19-10°) 3/4 to 1 1/2 - 70° (19 to 38-20°)
 Postheat temperature NA
 Heat Input Min NA Max NA

BRIDGE No. 5
MONTPELIER, VT.
CBSS Job # 434

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
1/16	280 ± 28	25 ± 1.7	11 ± 1.1	AWS D1.5 Joint detail BU2-F
1.6	280 ± 28	25 ± 1.7	280 ± 28	

CK'D BY: [Signature]
 APR 22 2000
 RESUBMIT: [Signature]
 BY DATE: 5/24/00

T1 - UNLIMITED
 P - 0 to 1/8 / 0 to 3.2 mm
 R - 0 to 1/8 / 0 to 3.2 mm
 1-Grind as required

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. 104 Contractor Casco Bay Steel
 Revision no. _____ Authorized By [Signature]
 Form III-2 AWS-OC1 Paul E. Goodale Date 2/2/99
 B310201
 C.W.I.