

**Casco Bay Steel Structures, Inc.**

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**WELDING PROCEDURE SPECIFICATION**

Material specification A36-A572-A588 (ASTM 709 Gr 36-50-50w)  
 Welding process Flux Cored Arc welding (FCAW)  
 Manual or machine Semi-AUTO  
 Position of welding Flat-IG  
 Filler metal specification AWS A5-20  
 Filler metal classification E71T-1  
 Flux NA  
 Shielding gas 75% AR 25% CO<sub>2</sub> Flow rate 40 ± 5  
 Single or multiple pass Both Electrode stick out 3/4 ± 1/4  
 Single or multiple arc Single  
 Welding current Direct Current  
 Polarity Reverse Electrode Positive  
 Welding progression See Detail  
 Root treatment weld side + backgauge side + grind + then weld  
 Preheat and interpass temperature To 34-50° F (1-10°) + 34 to 110° (1-10 to 38-20°)  
 Postheat temperature NA  
 Height 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	11 ± 1.1
1.6	280 ± 28	25 ± 1.7	280 ± 28	280 ± 28

Joint detail BU2-F

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

APPROVED BY: [Signature] DATE: 05/04/99

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. AWS-OC1 Authorized By Paul E. Goodale  
 Form III-2 Paul E. Goodale Date 2/2/99  
 C.W.I.