

**Casco Bay Steel Structures, Inc.**

5 Industry Road  
South Portland, Maine 04106

Phone: (207) 772-2533

Fax: (207) 772-0580

**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  
 Filler metal specification AWS 5.20  
 Filler metal classification E71T-1  
 Flux AA  
 Shielding gas 75% Ar 25% CO<sub>2</sub> Flow rate 40 F<sup>5</sup>  
 Single or multiple pass single Electrode stickout 3/4" ± 1/4"  
 Single or multiple arc single  
 Welding current Direct Current  
 Polarity Reverse Electrode Positive  
 Welding progression see Detail  
 Postheat and interpass temperature 275-345° (19-102) 7/16 to 1/2" (19 to 38-100)  
 Preheat temperature NA  
 Heat input Min NA Max NA

VT-AOT, BRN0-5  
 B01 NO. BHE 640063D  
 TOLER ST BC, CBS 434

**WELDING PROCEDURE**

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5
		Amps	Volts		
1/16	2/80	25 ± 1.7	17.5 ± 1.7	175 in/min ± 1.7	Square groove joint detail BUTT
1.6	2/80 ± 2/8	25 ± 1.7	43.2 ± 4.32	432 in/min ± 43.2	Butt

RESUBMIT APPROVED DATE 01/13/10

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. 1.05 Contractor Casco Bay Steel  
 Revision no. \_\_\_\_\_ Authorized By Paul E. G...  
 Form III-2 AWS-CES-10-01 Paul E. G... 83100001 Date 2/2/99  
 C.W.I.