

Casco Bay Steel Structures, Inc.

75 Spring Hill Road
Saco, Maine 04072

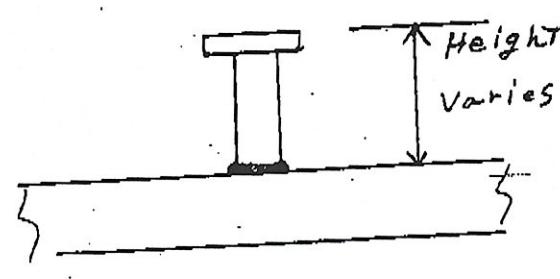
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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709/A709M - Gr36-50-50w (250-345-345W)
Welding process STUD WELDER
Manual or machine MACHINE
Position of welding FLAT
Filler metal specification NA
Filler metal classification NA
Flux NA Flow rate NA
Shielding gas NA
Single or multiple pass SINGLE
Single or multiple arc SINGLE
Welding current DC EN
Polarity NA
Welding progression Surface to be welded
Root treatment Clean
Preheat and interpass temperature 34-50° 3/4" to 1/2-70° 1/2" to 1/2-150° over 2 1/2-225°
Postheat temperature NA Heat input Min NA Max NA

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Ampere	Volts		
	STUD SIZE		Weld TIME	NA	
1/2	350	350	35±		
5/8	350	350	35±		
3/4	550	750	40±		
7/8	650	850	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. #1 S.W.

Revision no. _____

Form III-2

Contractor Casco Bay Steel

Authorized By [Signature]

Date May 3-1996

