

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 - 1G
 Filler metal specification AWS A5-20
 Filler metal classification E71T-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
 Single or multiple arc single
 Welding current Direct current
 Polarity Reverse Electrode positive
 Welding progression see detail
 Root treatment see detail
 Preheat and interpass temperature To 3/4 50° (1" - 10°) 3/4 to 1 1/2 70° (1 1/2 to 38-20°)
 Postheat temperature NA
 Heat Input Min NA Max NA

VT-AOT, BKNO-5
For AWS E640 (3d)
For 1st Ar, CBS430

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
1/16	2.80	±28	±1.7	11 ±1.1
1.6	2.80	±28	±1.7	2.80 ±2.8

Joint detail BU2-F
 AWS D1.5
 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

APPROVED BY: AS DATE: 2/14/10

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. 104 Contractor Casco Bay Steel
 Revision no. AWS-OC1 Authorized By Paul E. Goodale
 Form III-2 Paul E. Goodale Date 2/2/99
 83100201
 C.W.I.