

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A36 Gr 36-50-50W (250-345-345W)
 Welding process Shielded Metal Arc Welding (SMAW)
 Manual or machine Manual
 Position of welding Overhead (4F)
 Filler metal specification A51-A5.5 TRANS
 Filler metal classification E7018-8018
 Flux NA
 Shielding gas NA Flow rate NA
 Single or multiple pass Single - multiple
 Single or multiple arc Single
 Welding current DC
 Polarity Positive
 Welding progression Sec. Detail
 Root treatment Area to be free of loose scale - slag - rust or moisture
 Preheat and interpass temperature 30(19) 50(100) 34(70) to 120(250) 120(250)
 Postheat temperature NA
 Heat Input Min NA Max NA

(Metric) WELDING PROCEDURE VT-AOT, B10-5
Reg. No. R.H.F. 640(3D)
Case No. ST. RC. CBS434

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
7018				
1/8 (3.2)	95-160	22-26		
5/32 (3.9)	120-190	22-26		
8018				
1/8 (3.2)	110-150	22-26		
5/32 (3.9)	130-190	22-26		

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. 404 Contractor Casco Bay
 Revision no. 1 Authorized By Paul E. Gagnier
 Form III-2 Date 6-3-04