

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A109-Gr B 50-50W (250-345-345W)
 Welding process Shielded Metal Arc Welding (SMAW)
 Manual or machine Manual
 Position of welding Flat (1F) Horizontal (2F) ✓ TRANS
 Filler metal specification ANSI/AWS A5.1 - A5.5
 Filler metal classification E7018 - R018 C₃₅ - 7028
 Flux NA
 Shielding gas NA Flow rate NA
 Single or multiple pass Single and multiple 1.1.1.2-2.1.1.1
 Single or multiple arc Single
 Welding current AC/DC RESUBMIT APPROVED
 Polarity STRAIGHT/REVERSE BY DATE 04/19/00
 Welding progression NA
 Root treatment MEET AWS SPECIFICATION
 Preheat and interpass temperature 70(165) 50(125) 3/16(8) 1/4(9) 7/16(18) 1/2(20) 5/8(25) 3/4(35) 1(45) 1 1/4(60) 1 3/4(75) 2(90)
 Postheat temperature NA
 Heat input Min NA Max NA VT-ACT, BY NO-5
Reg. NO. B.H.F. 6400(6D)
TOLIER ST. RT. CBS 434

(Metric) WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5	Joint detail	Fillet
		Amps	Volts				
AS	3/16 (4.8)	70-170	22-26	AS	1F		
	5/32 (3.9)	120-225	22-26				
REQ	3/16 (4.8)	170-300	24-27	REQ	2F		
	1/8 (3.2)	90-160	22-26				
REQ	5/32 (3.9)	120-225	22-26	REQ	3/16 to 5/8 (5 to 16)		
	3/16 (4.8)	180-290	24-27				
REQ	5/32 (3.9)	170-270	22-26	REQ	3/8 (10)		
	3/16 (4.8)	210-330	24-27				

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in applicable codes or contract specifications.

Procedure no. 401 QC 1 Contractor Casco Bay Steel
 Revision no. 1 Authorized by Paul E. Hurdale
 Form III-2 Date 3/2/00