



**Casco Bay Steel Structures**  
 One Wallace Avenue, South Portland ME 04106  
**AWS - Welding Procedure Specification (WPS)**  
 WeldOffice WPS

WPS record number	201	Revision	2	Qualified to	AWS D1.5
Date	4/24/2014	Company name	Casco Bay Steel Structures		

JOINTS: Typical joint(s). See actual production drawings and engineering specifications for details.

	<b>5/16 single pass Horizontal</b>	TH1 FAS RT 0211 Huntington River Rural Major Collector BR 8 Proj BF-0211(32) CBSS 695															
	<table border="1"> <thead> <tr> <th></th> <th>Amps</th> <th>Volts</th> <th>Travel Speed</th> </tr> </thead> <tbody> <tr> <td>AVG</td> <td>604</td> <td>29.5</td> <td>17.1 IPM</td> </tr> <tr> <td>MIN</td> <td>569</td> <td>27.4</td> <td>15.5 IPM</td> </tr> <tr> <td>MAX</td> <td>625.1</td> <td>31.0</td> <td>18.7 IPM</td> </tr> </tbody> </table>		Amps	Volts	Travel Speed	AVG	604	29.5	17.1 IPM	MIN	569	27.4	15.5 IPM	MAX	625.1	31.0	18.7 IPM
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Type of groove	Fillet weld	Minimum groove angle	(deg.)	N/A
		Minimum root opening	(in.)	N/A
		Maximum root face	(in.)	N/A

**PREHEAT TABLE**

Applicable standard	AWS D1.5 Bridge Welding Code		
	For thickness 1/8 to 3/4(in.): 50(°F). Preheat to 70(°F) if the base metal temperature is below 32(°F).		
	Over 3/4 thru 1-1/2(in.): 70(°F).		
	Over 1-1/2 thru 2-1/2(in.): 150(°F).		
	Over 2-1/2(in.): 225(°F).	Refer to AWS D1.5 2010 Table 4.3 (pg 85)	

**TECHNIQUE**

Supplementary MF control	
Peening	
Surface preparation	Grind/Blast/chemical/wirebrush clean to be free of moisture, slag, millscale, oils, dust
Initial/interpass cleaning	Brushing and Grinding
Back gouging method	None

**NOTES**

Vermont Agency of Transportation  
**RECEIVED**  
 CK'D BY \_\_\_\_\_ OK'D BY Rob Young  
 February 16, 2017  
 RESUBMIT Approved AsNoted  
 BY Rob Young DATE 03/06/2017

<b>Signature 1</b>		<b>Signature 2</b>	
Name	Signature	Name	Signature
Matthew Cote			
Date		Date	
6/2/2014			
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Name	Signature	Name	Signature
Date		Date	