



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

WPS record number	202	Revision	3	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.

	<table border="1"> <thead> <tr> <th>Amps</th> <th>Volts</th> <th>Travel Speed</th> </tr> </thead> <tbody> <tr> <td>AVG 604 /</td> <td>29.5 /</td> <td>17.1 IPM</td> </tr> <tr> <td>MIN 589 /</td> <td>27.4 /</td> <td>15.5 IPM</td> </tr> <tr> <td>MAX 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 589 /	27.4 /	15.5 IPM	MAX 625.1 /	31.0 /	18.7 IPM	TH1 FAS RT 0211 Huntington River Rural Major Collector BR 8 Proj BF-0211(32) CBSS 695
		Amps	Volts	Travel Speed										
AVG 604 /	29.5 /	17.1 IPM												
MIN 589 /	27.4 /	15.5 IPM												
MAX 625.1 /	31.0 /	18.7 IPM												
B-L1a-S * Second side shall be ground out and/or backgouged to sound metal prior to welding														

Type of groove	Square-groove	Minimum groove angle	(deg.) 0
		Minimum root opening	(in.) 0 to 1/16
		Maximum root face	(in.) 5/8

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 (pg85)
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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	Grinding or Air Carbon Arc Gouging

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

Signature 1		Signature 2	
Name	Signature	Name	Signature
Matthew Cote			
Date		Date	
6/2/14	Matthew J Cote CWI 08051341 QC1 EXP. 5/11/2017		
Signature 3		Signature 4	
Name	Signature	Name	Signature
Date		Date	