



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

WPS record number	203	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.

	<table border="1"> <thead> <tr> <th>Amps</th> <th>Volts</th> <th>Travel Speed</th> </tr> </thead> <tbody> <tr> <td><b>AVG 604 /</b></td> <td><b>29.5 /</b></td> <td><b>17.1 IPM</b></td> </tr> <tr> <td>MIN 569 /</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	<b>AVG 604 /</b>	<b>29.5 /</b>	<b>17.1 IPM</b>	MIN 569 /	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										
<b>AVG 604 /</b>	<b>29.5 /</b>	<b>17.1 IPM</b>												
MIN 569 /	27.4 /	15.5 IPM												
MAX 625.1 /	31.0 /	18.7 IPM												
BL2c-S  Over 1/2" to 1" (1/4 root face min) Over 1" to 1-1/2" (3/8 root face min) Over 1-1/2" to 2" (1/2 root face min)  *backside shall be backgouged prior to welding														

Type of groove	Single-V-groove	Minimum groove angle	(deg.) 55 to 70
		Minimum root opening	(in.) 0 to 1/16
		Maximum root face	(in.) varies

**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	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			
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6/2/14			
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**Matthew J Cote**  
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