



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

WPS record number	250	Revision	1	Qualified to	AWS D1.5
Date	6/10/2014	Company name	Casco Bay Steel Structures		

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

	5/16 single pass Horizontal	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>363.3</td> <td>31.6</td> <td>12.8</td> </tr> <tr> <td>MIN</td> <td>324.9</td> <td>29.9</td> <td>11.7</td> </tr> <tr> <td>MAX</td> <td>379.2</td> <td>33.2</td> <td>13.5</td> </tr> </tbody> </table>		Amps	Volts	Travel Speed	AVG	363.3	31.6	12.8	MIN	324.9	29.9	11.7	MAX	379.2	33.2	13.5
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AVG	363.3	31.6	12.8														
MIN	324.9	29.9	11.7														
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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)
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TECHNIQUE

Supplementary MF control	Not used
Peening	Grind/Blast/chemical/wirebrush clean to be free of moisture, slag, millscale, oils, dust
Surface preparation	Brushing and Grinding
Initial/interpass cleaning	None
Back gouging method	

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	Signature 2	Signature
Name	Matthew J Cote	Name	
Date	6/10/14	Date	
Signature 3	Signature	Signature 4	Signature
Name		Name	
Date		Date	