



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

Company name: Casco Bay Steel Structures
 Welding process: SMAW
 Process type: Manual

Identification #: 480 Rev. **1**
 Originated by: Matthew Cote
 Date: 7/22/2014
 Authorized by: Matthew J Cote
 Date: 7/22/2014

Joint design used
 Joint type: T - T joint
 Joint design: Fillet Weld
 Backing: No
 Backing material: Not Applicable
 Root opening (R)* (in.):
 Root face (f)* (in.):
 Groove angle (a)* (deg.):
 Radius (J - U)* (deg.):
 Back gouging: No
 Back gouging method: None

Position
 Welding position: Groove Fillet All
 Vertical progression: Up

Electrical characteristics
 Transfer mode (GMAW): N/A
 Current type: Other
 Other: DC+ and AC

Base metals * Datum, As Detailed (As Fit-Up)
 Spec., type or grade: Gr 50/ Gr50W
 Thickness: Groove (in.):
 Fillet (in.): 1/8" and above
 Diameter (Pipe) (in.):

Technique
 Stringer or weave bead: Stringer or Weave
 Multi/single pass (per side): Single or Multiple
 Number of electrodes: Varies
 Spacing: Longitudinal (in.):
 Lateral (in.):
 Angle (deg.):
 Contact tube to work (in.):
 Peening: Not permitted
 Interpass cleaning: Brushing or grinding

Filler metals
 AWS Specification: A5.5
 AWS Classification: E-8018 H4R

Preheat
 Preheat temp.: Min. (°F) See notes
 Interpass temp.: Min. (°F) See notes
 Max. (°F) 450

Shielding
 Flux: -
 Electrode-flux (class): -
 Gas composition: -
 Gas flow rate (cfh): -
 Gas cup size (in.): -

Post weld heat treatment
 Temperature (°F): None
 Time (hrs): -

Welding procedure

Layer	Pass	Process	Filler metal class	Filler metal diameter (in.)	Current type / polarity	Amps	Wire feed speed (in./min)	Volts	Travel speed (in./min)	Joint details
1	All	SMAW	E-8018 H4R	1/8	DCEP	100-160	-	n/a	varies	
1	All	SMAW	E-8018 H4R	1/8	AC	90-160	-	n/a	varies	
1	All	SMAW	E-8018 H4R	5/32	DCEP	140-210	-	n/a	varies	
1	All	SMAW	E-8018 H4R	5/32	AC	130-210	-	n/a	varies	
1	All	SMAW	E-8018 H4R	3/16	DCEP	200-300	-	n/a	varies	
1	All	SMAW	E-8018 H4R	3/16	AC	180-300	-	n/a	varies	

Designation: **FILLET**

Not allowed for vertical or overhead welds

Notes
 LINCOLN ELECTRIC EXCALIBUR 8018-C3 MR
 SEE BACKSIDE FOR MORE DETAILS
 TH1 FAS RT 0211 Huntington River
 Rural Major Collector
 BR 8 Proj BF-0211(32) CBSS 695



February 16, 2017
 RESUBMIT BY Rob Young Approved As Noted DATE 03/06/2017

Signature 1 Name: Matthew J Cote Date: 7/22/2014	Signature Matthew J Cote CWI 08051341 QC11XP 5/1/2017	Signature 2 Name: _____ Date: _____
Signature 3 Name: _____ Date: _____	Signature _____	Signature 4 Name: _____ Date: _____