



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

WPS record number	610	Revision	1	Qualified to	AWS D1.5
Date	2/1/2017	Company name	Casco Bay Steel Structures		
Supporting PQR(s)	418				
Reference docs.					

Scope	Fillet
Joint	Joint details for this welding procedure specification in: JOINTS section of this WPS, Production drawings

BASE METALS				THICKNESS RANGE QUALIFIED (in.)			
Type	Gr50/Gr50W	P-no.	Grp-no.	As-welded		With PWHT	
				Min.	Max.	Min.	Max.
Welded to	Gr50/Gr50W	P-no.	Grp-no.	-	-	-	-
Backing:		P-no.	Grp-no.	-	-	-	-
Retainers	All A709 steels with 50ksi or less are also qualified						
Notes							

Complete pen.	-	-	-	-
Impact tested	-	-	-	-
Partial pen.	-	-	-	-
Fillet welds	1/8	no max	-	-

FILLER METALS						THICKNESS RANGE QUALIFIED (in.)			
SFA	Classification	F-no.	A-no.	Chemical analysis or Trade name	As-welded		With PWHT		
					Min.	Max.	Min.	Max.	
GMAW	E80C-Ni1	6	10	ESAB Coreweld 88-HS Ni1	1/8	no max	-	-	
Sup. filler	-	-	-	-	- None -				

WELDING PROCEDURE		GMAW
Welding process		Semi-automatic
Type		See Backpage
Minimum preheat/interpass temperature (°F)		440
Maximum interpass temperature (°F)		052
Filler metal size (in.)		.H
Layer number		Not applicable
Position		DCEP
Weld progression		307
Current/polarity		29.2
Amperes		15.5
Volts		34.8
Travel speed (in./min)		Spray
Maximum heat input (kJ/in)		Argon/CO2, 90/10
Wire feed speed (in./min)		35
Arc transfer mode		
Shielding: Gas type		Stringer or Weave
Flow rate (cft)		5/8
Trailing: Gas type		Single or Multiple passes
Flow rate (cft)		Single electrode
Backing: Gas type		
Flow rate (cft)		E80C-Ni1-H8
String or weave		
Orifice/gas cup size (in.)		
C.T.W.D (in.)		
Multi/Single pass per side		
Multi/single electrode (in.)		
Maximum pass thickness (in.)		
Weld deposit chemistry		
Notes		

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

TH1 FAS RT 0211 Huntington River  
 Rural Major Collector  
 BR 8 Proj BF-0211(32) CBSS 695