



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

WPS record number Date	610 2/1/2017	Revision <b>1</b>	Qualified to Company name	AWS D1.5 Casco Bay Steel Structures
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JOINTS: Typical joint(s). See actual production drawings and engineering specifications for details.

	<b>Amps</b>	<b>Volts</b>	<b>TS</b>	TH1 FAS RT 0211 Huntington River Rural Major Collector BR 8 Proj BF-0211(32) CBSS 695
	<b>Avg</b> 307	<b>29.2</b>	<b>15.5</b>	
	<b>Min</b> 307	29.2	14.7	
	<b>Max</b> 327	31.2	15.5	
5/16 SINGLE PASS FILLET WELD				

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**

Peening	Not used
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 As Noted  
 BY Rob Young DATE 03/06/2017

Signature 1		Signature 2	
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