

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Welding specification: ASTM A109-87 1/8" x 3/8" x 5/8" (250-245-345W)
 Welding process: Shielded Metal Arc Welding (SMAW)
 Material or machine: Manual
 Position of welding: Flat (FE) Horizontal (HE)
 Filler metal specification: AWS E7018 AWS A5.1 - A5.5
 Filler metal classification: E7018 - R018 5/62 - 7018
 Flux: NA
 Shielding gas: NA Flow rate: NA
 Single or multiple pass: Single and multiple
 Single or multiple arc: Single
 Welding current: A.C. D.C.
 Polarity: Reverse
 Welding progression: STRAIGHT / REVERSE
 Root treatment: MAINT AWS SPECIFICATION
 Preheat and interpass temperature: 350 (175) 500 (260) 550 (265) 600 (315) 650 (345) 700 (370)
 Postheat temperature: NA
 Heat input: NA Max: NA

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 C.B.S.S. No 329

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail
		Amperes	Volts		
AS	7018 1/8 (4-2)	70-100	22-26	AS	1F
	5/32 (3-7)	120-225	22-26		
	3/16 (4-8)	170-300	24-27		
REQ	7018 1/8 (3-2)	90-160	22-26	REQ	2F
	5/32 (3-7)	120-225	22-26		
	3/16 (4-8)	180-290	24-27		
REQ	7018 5/32 (3-7)	170-270	22-26	REQ	3/16 to 3/8 (5 to 8)
	3/16 (4-8)	180-290	24-27		
	7018 5/32 (3-7)	210-330	24-27		

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in applicable codes or contract specifications.

Procedure no. 401
 Revision no. 0
 Contractor: Casco Bay Steel
 Authorized By: Paul E. Hoodale
 Date: 3/2/00

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