

Casco Bay Steel Structures, Inc.

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Saco, Maine 04072

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 36 Gr 36-50-52W / A 209M Gr 250-345-345W
 Welding process Flux Cored Arc welding (FCAW)
 Manual or machine Semi AUTO
 Position of welding Flat - Horizontal
 Filler metal specification AWS A5-23
 Filler metal classification E81T-N11-R4 ESAB
 Flux None
 Shielding gas 75% Ar - 25% CO₂ Flow rate 35 CFH ± 4
 Single or multiple pass Single / Multiple Elec Ex 3/8" = W
 Single or multiple arc Single
 Welding current DCP
 Polarity DCP
 Welding progression See detail
 Root treatment Wire brush - area to be free of loose scale, slag, rust & moisture
 Preheat and interpass temperature 20 (34) 100 (200) 60 (140) 70 (160) 200 (400) 400 (800) 600 (1100) 650 (1200)
 Postheat temperature None
 Heat input Min 27.7 kJ/in Max 43.6 kJ/in PQR FCM # 8 59.6 kJ/in
 Proj No. BHO-BTA-2005 U
 New Haven Way Saco VT
 C.B.S.S. No 329

WELDING PROCEDURE

Pass no.	Electrode Size	Welding current		Travel speed
		Amps	Volts	
		28.7	29	13
1/16		25.8	26.8	11.4
		31.5	31	14

OK'D BY: [Signature] DATE: JUN 1 12 2007

RESUBMIT BY: [Signature] DATE: 6/12/07

APPROVED: [Signature]

Joint detail: Fillet

APPROVED BY: [Signature] DATE: 6/12/07

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

Procedure no. 101 Contractor Casco Bay Steel
 Revision no. _____ Authorized By Paul G. Stoddole
 Form W-2 Date 12-6-06

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