

**Casco Bay Steel Structures, Inc.**

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**WELDING PROCEDURE SPECIFICATION**

Material specification ASTM A 36 - C x 36-50-52W / A 709M 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 A5-29  
 Filler metal classification E81T1-N11-H4 ESAB  
 Flux NA  
 Shielding gas 75% AR - 25% CO<sub>2</sub> Flow rate 35 CFH #8-4  
 Single or multiple pass single / multiple Elec. Ex. 1/4" = 1/4"  
 Single or multiple arc single  
 Welding current DC EP  
 Polarity DC EP  
 Welding progression see detail  
 Root treatment wire brush - area to be free of loose scale, slag, rust & moisture  
 Preheat and interpass temperature 20 (34) 10 (50) 20 (34) to 40 (100) 20 (34) 40 (100) to 60 (140) 45 (105)  
 Postheat temperature NA Overheat 60 (140) (225)  
 Heat input Min 20.7 kJ/in Max 43.6 kJ/in PQR FCM # 8 39.6 kJ/in

**WELDING PROCEDURE**

ST. Johnsbury  
Passumpsic River  
Br # 29 - Vermont

Pass no.	Electrode size	Welding current		Travel speed
		Ampere	Volts	
1/16	TO	28.7	29	13
		TO	TO	11.4
		31.5	31	14

Joint detail: AWSD1-5

OK'D BY: \_\_\_\_\_  
 RESUBMITTED BY: \_\_\_\_\_  
 JUN 06 2007  
 DATE: 6-19-07

AWSD1-5  
 STATE OF VERMONT  
 REGISTERED WELDER

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 C. Goodale  
 Date 12-6-06  
 Form No. \_\_\_\_\_ Date \_\_\_\_\_  
 07455W