

**Casco Bay Steel Structures, Inc.**

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**WELDING PROCEDURE SPECIFICATION**

Material specification ASTM A109 Gr 36 to 50w (250-345-345w)  
 Welding process Shielded Metal Arc welding (SMAW)  
 Manual or machine Manual  
 Position of welding Flat (F), Horizontal (H)  
 Filler metal specification AWS/AWS A5.1 - A5.5  
 Filler metal classification E7018 - R018 5/32 - 7/32  
 Flux NA  
 Shielding gas NA  
 Single or multiple pass Single and multiple  
 Single or multiple arc Single  
 Welding current AC/DCE  
 Polarity STRAIGHT / REVERSE  
 Welding progression Meet AWS specification  
 Root treatment Meet AWS specification  
 Preheat and interpass temperature To 3/4 (19) 50° (105) 3/4 (19) to 1 1/8 (28) 70° (160) 1 1/8 (28) to 2 1/8 (55) 150° (325)  
 Postheat temperature NA  
 Heat Input Min NA Max NA

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DATE 6-19-07

ST. JOHNS BURY  
PASSUMPSIC RIVER  
B.F. 29 VERMONT

**WELDING PROCEDURE**

Pass no.	Electrode size	Amperes	Volts	Travel speed	Notes
	<u>7018</u>				<u>1F</u>
AS	1/8 (3.2)	70-170	22-26		
REQ	5/32 (3.9)	120-225	22-26		
	3/16 (4.8)	170-300	24-27		
	<u>8018</u>				<u>2F</u>
	1/8 (3.2)	90-160	22-26		
	5/32 (3.9)	120-225	22-26		
	3/16 (4.8)	180-290	24-27		
	7/32 (5.7)	190-270	22-26		
	3/16 (4.8)	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. 1  
 Form III-2

Contractor Casco Bay Steel  
 Authorized By Paul E. Hoodale  
 Date 3/2/00