

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A109-62 55-50-50W (250-345-345W)
Welding process Shielded Metal Arc Welding (SMAW)
Manual or machine Manual
Position of welding Flat (1F) Horizontal (2F)
Filler metal specification AWS A5.1 - A5.5
Filler metal classification E7018 - E7018 C₃ - 7028
Flux NA
Shielding gas NA Flow rate NA
Single or multiple pass Single and multiple
Single or multiple arc Single
Welding current AC / DC
Polarity Straight / Reverse
Welding progression Left to Right
Preheat and interpass temperature 250°F (121°C) to 350°F (177°C)
Postheat temperature NA
Heat Input Min NA Max NA

Pass no.	Electrode size	Welding current	Trevol speed	Joint detail
		Amperes	Volts	
	<u>7018</u>			<u>AWS D1.5</u> Joint detail <u>Filler</u>
	<u>1/8</u>	<u>70-170</u>	<u>22-26</u>	<u>1F</u>
	<u>(3-9)</u>			
	<u>5/32</u>	<u>120-225</u>	<u>22-26</u>	
	<u>(3-9)</u>			
	<u>3/16</u>	<u>170-300</u>	<u>24-27</u>	
	<u>(4-8)</u>			
	<u>7028</u>			
	<u>1/8</u>	<u>90-160</u>	<u>22-26</u>	
	<u>(3-9)</u>			
	<u>5/32</u>	<u>120-225</u>	<u>22-26</u>	
	<u>(3-9)</u>			
	<u>3/16</u>	<u>180-290</u>	<u>24-27</u>	
	<u>(4-8)</u>			
	<u>7028</u>			
	<u>5/32</u>	<u>170-270</u>	<u>22-26</u>	
	<u>(3-9)</u>			
	<u>3/16</u>	<u>210-330</u>	<u>24-27</u>	
	<u>(4-8)</u>			

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

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Revision no. 01 Authorized By Paul E. Hoodale
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