

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709/A709M, Gr 36 (250) - 50 (345) - 50 (345)
Welding process Flux Cored Arc welding
Manual or machine Semi-Auto
Position of welding Flat (F) - Horizontal (2F)
Filler metal specification AWS-A5-29
Filler metal classification E81T1-A1
Flux NA
Shielding gas 75%Ar / 25%CO₂ Flow rate 35 CFH ± 8.6
Single or multiple pass Single and Multiple
Single or multiple arc Single
Welding current Direct
Polarity Reverse Electrode Positive
Welding progression
Root treatment 1/16" AWS D1.5 Specification
Preheat and interpass temperature 34(9) 50(40) 30(40) to 110(40) 20(40) 20(40) 150(65)
Postheat temperature NA
Heat input Min 28.6 Max 45.0 PQR # 2 = 40.9 (115)

WELDING PROCEDURE					Travel speed	Joint detail
Pass no.	Electrode size	Welding current	Amperes	Volts		
AS	1/16	275	28.8	11.6	11.6	IF
		247	26.8	10.4		
		302.5	30.8	12.8		
REQ	1/16	275	28.8	29.4	29.4	2E
		247	26.8	26.4		
		302.5	30.8	25.12		

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-A
Revision no. 1
Form III-2
Contract Casco Bay Steel
Date 9/20/07