

# Casco Bay Steel Structures, Inc. 70-STRUCTURAL STEEL

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Saco, Maine 04072

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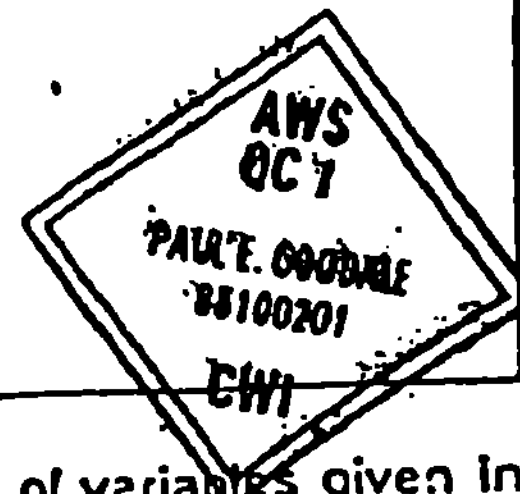
Fax: (207) 282-1179

## WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A36-50-50W / A709M Gr 250-345-345W  
 Welding process Flux Cored Arc welding (FCM)  
 Manual or machine Semi AUTO  
 Position of welding Flat - Horizontal  
 Filler metal specification AWS A5-29  
 Filler metal classification E81T1-Ni-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 5/8" ± 1/4  
 Single or multiple arc Single  
 Welding current DC  
 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 To 20<sup>mm</sup> (74) 10(50), 20<sup>+</sup>(54<sup>+</sup>) TO 40(1 1/2) 20(70), 40(1 1/2) TO 60(2 1/2) 65 C(150)  
 Postheat temperature NA  
 Heat Input Min 27.7 kJ/in Max 43.6 kJ/in PQR FCM #8 39.6 kJ/in  
VT-AOT - Read Board  
Br. NO. 31  
Proj NO - BR0-1441(25)  
CBSS 445

## WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS 5-13 AWS D1-5 Joint detail Fillet
		Amperes	Volts		
		287	29	13	
	1/16	258	26.8	11.4	
		TO	TO	TO	
		315	31	14	
<p>TRANS RECEIVED</p> <p>CK'D BY _____ OK'D BY <u>JWC</u></p> <p>APR 22 2010</p> <p>RESUBMIT _____ APPROVED <input checked="" type="checkbox"/></p> <p>BY _____ DATE <u>05/04/10</u></p>					



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. Woodale

Date 12-6-06