

Casco Bay Steel Structures, Inc.

71 STRUCTURAL STEEL

75 Spring Hill Road
Saco, Maine 04072

Phone: (207) 282-7360

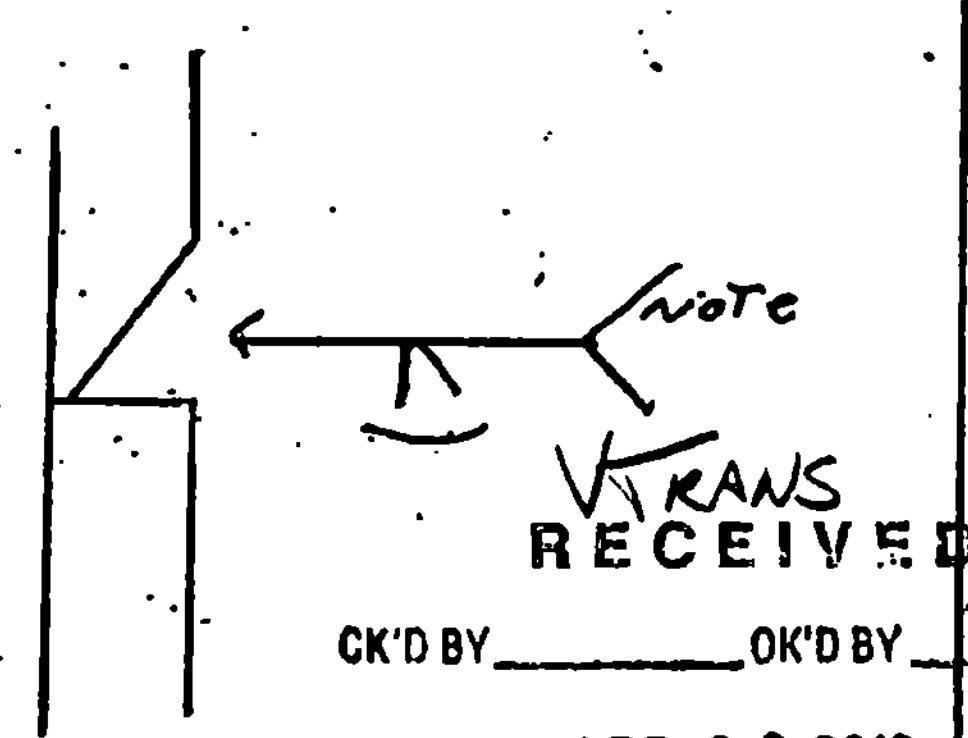
Fax: (207) 282-1179

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709/A709M - Grade 36 (250) 50 (345) 50W (345W)
 Welding process Flux Cored Arc welding (FCAW)
 Manual or machine Semi AUTO
 Position of welding Flat (1G) Horizontal (2G)
 Filler metal specification AWS A5-20
 Filler metal classification E71T-1
 Flux NA
 Shielding gas 75% AR 25% CO2 Flow rate 40 CFH ± 5
 Single or multiple pass Single and Multiple - Electrode Extension 5/8" ± 1/4" (15.87 ± 6.35)
 Single or multiple arc Single
 Welding current DC
 Polarity Reverse
 Welding progression See Joint Detail
 Root treatment To meet AWS specification
 Preheat and interpass temperature To 3/4" (19) = 50° (10°) - 3/4" (19) To 1/2" (38) = 70° (20) - 1/2" (38) To 2 1/2" (63) = 150° (65) over 2 1/2" (63) = 225° (110°)
 Postheat temperature NA
 Heat Input Min _____ Max _____

WELDING PROCEDURE

VT-AOT - Read Board
Br. NO. 31
Proj NO - BRD-1441(25)
CBSS 445

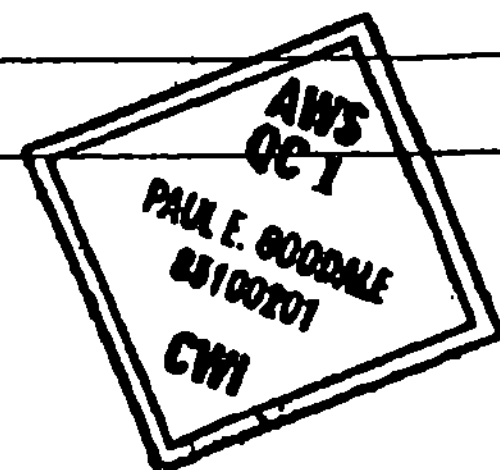
Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail
		Amperes	Volts		
	<u>1/16</u>	<u>275</u>	<u>28.8</u>	<u>11.6</u>	 <p>note</p> <p>TRANS RECEIVED</p> <p>CK'D BY _____ OK'D BY <u>JW</u></p> <p>APR 22 2010</p> <p>RESUBMIT _____ APPROVED <input checked="" type="checkbox"/></p> <p>BY _____ DATE <u>05/04/10</u></p> <p>note! Grind Flush as Req</p>
		<u>247.5</u>	<u>26.8</u>	<u>10.4</u>	
		<u>To</u>	<u>To</u>	<u>To</u>	
		<u>302.5</u>	<u>30.8</u>	<u>12.8</u>	
	<u>1.6</u>	<u>(METRIC)</u>		<u>294.6</u>	
		<u>275</u>	<u>28.8</u>	<u>264.2</u>	
		<u>247.5</u>	<u>26.8</u>	<u>To</u>	
		<u>To</u>	<u>30.8</u>	<u>325.12</u>	

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. 103

Revision no. _____

Form III-2



Contractor Casco Bay Steel

Authorized By Paul E. Goodale

Date 3/23/00