

Casco Bay Steel Structures, Inc.

5 Industry Road
South Portland, Maine 04106

72 STRUCTURAL
STEEL

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A109-Gr B 50-50W (250-345-345W)
 Welding process Shielded Metal Arc Welding (SMAW)
 Manual or machine Manual
 Position of welding FLAT (1F), HORIZONTAL (2F) VT TRANS RECEIVED
 Filler metal specification ANSI/AWS A5.1 - A5.5
 Filler metal classification E7018 - 8018 3/32 - 7028 CK'D BY _____ OK'D BY JWC
 Flux NA
 Shielding gas NA Flow rate NA APR 22 2010
 Single or multiple pass Single and multiple RESUBMIT _____ APPROVED
 Single or multiple arc single BY _____ DATE 05/04/10
 Welding current AC/DC
 Polarity STRAIGHT / Reverse
 Welding progression _____
 Root treatment MEET AWS SPECIFICATION
 Preheat and interpass temperature To 3/4(19) 50°(10°) 3/4(19) TO 1 1/2(38) 70°(20°) 1 1/2(38) TO 2 1/2(63.5) 150°(65°)
 Postheat temperature NA over 2 1/2(63.5) 225°(110°)
 Heat Input Min NA Max NA VT-AOT - Read Board
Br. NO. 31
Proj NO - BR0-1441(25)
CBSS 445

WELDING PROCEDURE

(Metric)

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail Fillet			
		Amperes	Volts					
AS REQ.	<u>7018</u> 1/8 (3.2)	70-170	22-26	AS REQ.	<u>1F</u>			
	5/32 (3.9)				120-225	22-26		3/8 To 3/8 (5 To 10)
	3/16 (4.8)	170-300	24-27					
	<u>8018</u> 1/8 (3.2)				90-160	22-26	<u>2F</u>	
	5/32 (3.9)	120-225	22-26					3/8 To 1/2 (10 To 13)
	3/16 (4.8)				180-290	24-27		
<u>7028</u> 5/32 (3.9)	170-270	22-26		3/8 To 1/2 (10 To 13)			3/8 To 1/2 (10 To 13)	1/2 To 5/8 (13 To 16)
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 AWS codes or contract specifications

Procedure no. 401

Revision no. _____

Form III-2

Contractor Casco Bay Steel

Authorized By Paul E. Hoodale

Date 3/2/00

