

# Casco Bay Steel Structures, Inc.

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## 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 (1F) Horizontal (2F)  
 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 \_\_\_\_\_  
 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 2/4" (63) = 150°(65)  
 Postheat temperature NA over 2 1/2" (63) = 225°(110)  
 Heat Input Min NA Max NA

ST. OF VERMONT  
DUMMERSTON  
Proj: BHO 1442(28)  
CBSS NO

## WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1-5 Joint detail
		Amperes	Volts		
	1/16	275	28.8	11.6	1F
		247.5 TO 302.5	26.8 TO 30.8	10.4 TO 12.8	
	1.6	(METRIC)		294.6	2F
		275	28.8	264.2 TO 325.12	

To 1/2" (12.7) TRANS RECEIVED

CK'D BY \_\_\_\_\_ OK'D BY JWC

APR 01 2010

RESUBMIT \_\_\_\_\_ APPROVED \_\_\_\_\_

BY \_\_\_\_\_ DATE 4/20/10

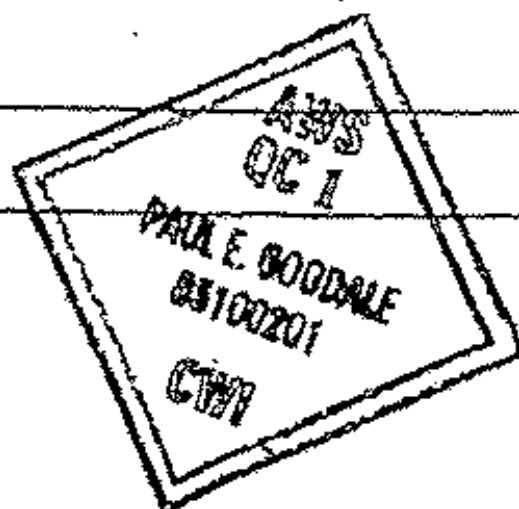
To 3/8" (9.5)

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

Revision no. \_\_\_\_\_

Form III-2



Contractor Casco Bay Steel

Authorized By Paul E. Goodale

Date 3/23/00