

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 1/2 (38) = 70° (20) - 1 1/2 (38) To 2 1/2 (63) = 150° (65)
Postheat temperature NA over 2 1/2 (63) = 225° (110°)
Heat Input Min NA Max NA

ST & F 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		
	<u>1/16</u>	<u>275</u>	<u>28.8</u>	<u>11.6</u>	<u>1F</u>
		<u>247.5</u> TO <u>302.5</u>	<u>26.8</u> TO <u>30.8</u>	<u>10.4</u> TO <u>12.8</u>	
	<u>1.6</u>	<u>275</u>	<u>28.8</u>	<u>294.6</u>	<u>2F</u>
		<u>247.5</u> TO <u>302.5</u>	<u>26.8</u> TO <u>30.8</u>	<u>264.2</u> TO <u>325.12</u>	



To 1/2 (12.7) TRANS
RECEIVED

CK'D BY _____ OK'D BY JWC

APR 01 2010

RESUBMIT _____ APPROVED _____

BY _____ DATE 4/20/10

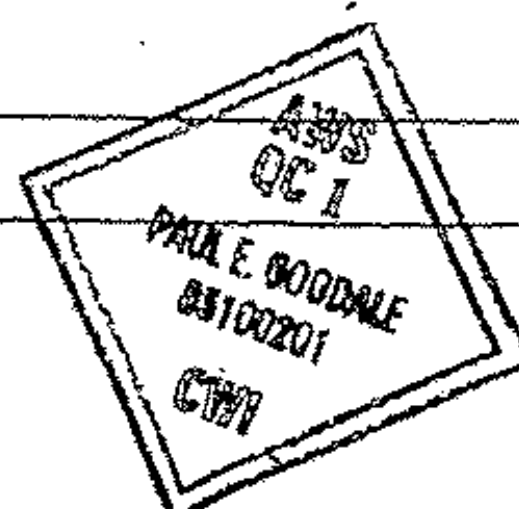
To 3/8 (9.5)

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