

Casco Bay Steel Structures, Inc.

75 Spring Hill Road
Saco, Maine 04072

Phone: (207) 282-7360

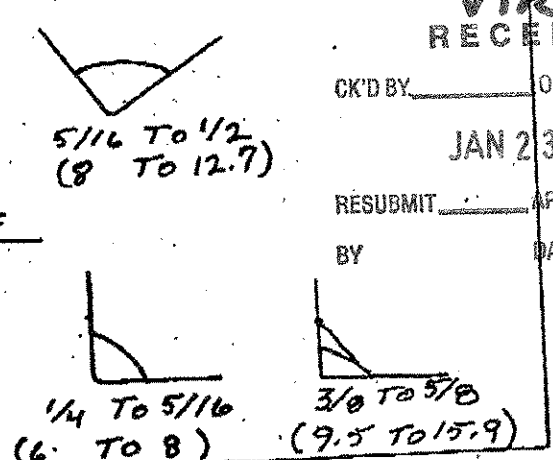
Fax: (207) 282-1179

WELDING PROCEDURE SPECIFICATION

Welding procedure specification ASTM A5.1 G28-50-50W (250-345-345W)
 welding process Submerged Arc Welding - Auto (SAW)
 manual or machine Machine
 position of welding Flat (H) Horizontal (H)
 filler metal specification AWs A5.17, AWS A5.23
 filler metal classification E80A-E81H-M11 Lincoln
 flux 960 Flux-Lincoln Weld - LA-75 Electrode
 inshielding gas Ar Flow rate N/A
 single or multiple pass Single
 single or multiple arc Single
 welding current Direct
 polarity Reverse Electrode Positive
 welding progression Meet AWS Specification
 root treatment Meet AWS Specification
 preheat and interpass temperature 30(19) to 40(5) 2/2(9) 1/2(8) 7/8(6) 1 1/8(5) 1 1/2(4) 1 3/4(3) 1 7/8(2) 2(1)
 postheat temperature A
 heat input Min 41.65 Max 65.45 PQR # 1-59.5
 Vermont A.C.T. Leicester, B#6
 Proj # BRF0160325
 CBSS 285

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amps	Volts		
5/32	605 544.5 TO 665.5	29.5	18.5	18.5 15.3 TO 20.9	AWS D1.5 IF
		27.4 TO 31.56	15.3 TO 20.9		
3-9	METRIC 605 544.5 TO 665.5	29.5	459.2	459.2 389.6 TO 529.8	2F
		27.4 TO 31.56	389.6 TO 529.8		



VTRANS RECEIVED
 CK'D BY: [Signature]
 JAN 23 2006
 RESUBMIT APPROVED [Signature]
 BY: [Signature]
 DATE 02-06-06

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. 201 Contractor Casco Bay Steel
 Revision no. 1 Authorized By P. E. Doolittle
 Date 3/2/00