

**Casco Bay Steel Structures, Inc.**

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Saco, Maine 04072

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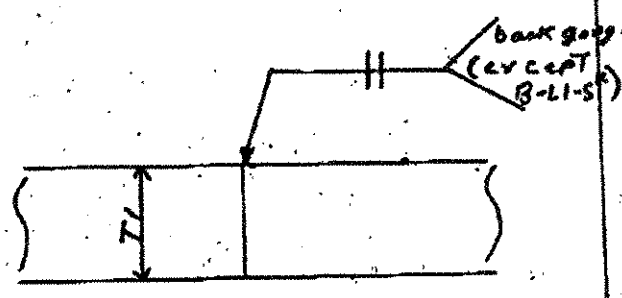
Fax: (207) 282-1179

**WELDING PROCEDURE SPECIFICATION**

Material specification ASTM A572 Gr 50 (50-50-50) (250-245-345w)  
 Welding process Submerged Arc Welding - AUTO (SAW)  
 Manual or machine Machine  
 Position of welding Flat (1/2 G)  
 Filler metal specification AWA A5-17 AWS A5-23 Lincoln  
 Filler metal classification E70T-5 AWS E70T-5 Electrode  
 Flux 66 Flux Lincoln Weld - LA-75 Electrode  
 Shielding gas None  
 Single or multiple pass both  
 Single or multiple arc single  
 Welding current Direct  
 Polarity Reverse Electrode Positive  
 Welding progression Left to Right  
 Root treatment None  
 Preheat and interpass temperature None  
 Postheat temperature None  
 Heat input Min 41.65 Max 65.45 PAR 1-59.5

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**WELDING PROCEDURE**

Pass no.	Electrode size	Welding current		Travel speed
		Amps	Volts	
5/32	605	29.5	18	AWS D1.5 Joint detail B-11.5, B-11a-5 
	544.5	27.4	15.3	
	665.5	31.56	20.7	
3/8	605	29.5	457.2	T1 = 3/8 (9.5) B-11.5 T1 = 5/8 (15.875) B-11a-5 *Evidence of C.U.P. is req.
	544.5	27.4	388.6	
	665.5	31.56	525.8	

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in applicable A.W.I. codes or contract specifications.

Procedure no. 203  
 Revision no. 1  
 Form W-2  
 Contractor Casco Bay Steel  
 Authorized By Paul E. Wendle  
 Date 3/2/00