

**CASCO BAY STEEL STRUCTURES, INC.**

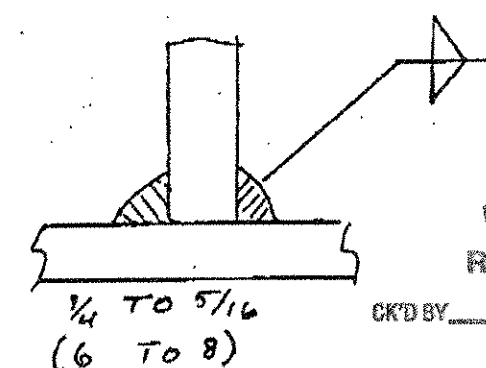
75 Spring Hill Road  
Saco, Maine 04072

Phone: (207) 282-7360

Fax: (207) 282-1179

**WELDING PROCEDURE SPECIFICATION**

Material specification ASTM-A709/A709M - Gr 36 (250), 50 (345), 50W (345W)  
 Welding process Shielded Arc Welding  
 Manual or machine Manual  
 Position of welding Horizontal (2F)  
 Filler metal specification AWS A5-23  
 Filler metal classification E6010-E6011 Lincoln  
 Flux Lincoln 96 Flux with LA-75 Electrode  
 Shielding gas Argon Flow rate 4A  
 Single or multiple pass Single - Electrode Ex. 1.284 (25.4 ± 1.1)  
 Single or multiple arc Single  
 Welding current DC  
 Polarity DCEN  
 Welding progression See Joint Detail  
 Root treatment 50% wire brush - grind - Blast Clean area  
 Preheat and interpass temperature 30 (19) to 50 (10) to 100 (38) to 200 (150) to 225 (150)  
 Postheat temperature NA  
 Heat input Min 3.0 kJ/in (1.2 kJ/mm) Max 47.1 kJ/in (1.9 kJ/mm) PQR # 4-428 KJ/in (1.7 kJ/mm) Vermont Agt. Leicester-0576  
 Proj # BRF0160325  
 C.B.S.S. 285

Pass no.	Electrode size	Welding current		Travel speed	Fillet
		Amps	Volts		
1	3/32	299	31	12 IPM	AWS D1-5 Joint detail
		269	29	11	
		329	33	15	
2-4	Metric	299	31	320 mm	
		269	29	299	
		329	33	381	

VTRANS RECEIVED  
 CRD BY: JWC  
 JAN 23 2006  
 APPROVED: [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. 250 Contractor Casco Bay Steel  
 Revision no. 01 Authorized By Paul E Gadele  
 Form W-2 Date 6-13-00

