

Casco Bay Steel Structures, Inc.

5 Industry Road
South Portland, Maine 04106

Phone: (207) 772-2533

Fax: (207) 772-0580

WELDING PROCEDURE SPECIFICATION

Welding specification: ASTM A109 Gr 36-50-60W (250-345-345W)
 Welding process: Shielded Metal Arc Welding (SMAW)
 Manual or machine: Manual
 Position of welding: Flat (1F) Horizontal (2F)
 Filler metal specification: ANSI/AWS A5.1 - E7018
 Filler metal classification: E7018 - R018 5/16 - 7/8
 Shielding gas: NA Flow rate: NA
 Single or multiple pass: Single and multiple
 Single or multiple arc: single
 Welding current: AC/DC
 Polarity: STRAIGHT / Reverse
 Welding progression: SEE AWS SPECIFICATION
 Root treatment: SEE AWS SPECIFICATION
 Preheat and interpass temperature: 34(92.50) to 30(90) to 1/4(38) to 1/2(40) to 3/4(75) to 1(150)
 Postheat temperature: NA
 Heat input: Min NA Max NA

APPROVED BY: JWC
 DATE: 02-06-06

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail		
		Amps	Volts		AWS D1.5	Fillet	
A5 REQ	7018 1/8 (3.2)	70-170	22-26	AS REQ	1F		
	5/32 (3.9)	120-225	22-26		3/8 to 1/2	3/8 to 1/2	1/2 to 5/8
	3/16 (4.8)	170-300	24-27		5 to 10	10 to 13	13 to 16
R018	1/8 (3.2)	90-160	22-26	2F			
	5/32 (3.9)	120-225	22-26				
	3/16 (4.8)	180-290	24-27				
7028	5/32 (3.9)	170-270	22-26	3/16 to 1/8 (5 to 8)			
	3/16 (4.8)	210-330	24-27		3/8	7/16 to 5/8	11 to 16

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

Procedure no. 401 Contractor Casco Bay Steel
 Revision no. 0 Authorized By Paul E. Hoodale
 Form W-2 Date 3/2/00