

**Casco Bay Steel Structures, Inc.**

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**WELDING PROCEDURE SPECIFICATION**

Material specification ASTM A572 Gr. 50 (250-345W)  
 Welding process Shielded Metal Arc welding (SMAW)  
 Manual or machine Manual  
 Position of welding Vertical up (3F)  
 Filler metal specification ANSI AWS E7018 - E5.5  
 Filler metal classification E7018 - R018 4/5  
 Flux NA  
 Shielding gas NA  
 Single or multiple pass Single - multiple  
 Single or multiple arc Single  
 Welding current AC  
 Polarity positive  
 Welding progression see detail  
 Root treatment Area to be free of loose scale, slag, rust or moisture  
 Preheat and interpass temperature 34 (19) 50 (60), 39 (9) 50 (60) 70 (20) 120 (80)  
 Postheat temperature NA  
 Heat input Min NA Max NA

TRANS RECEIVED

REVISED BY: JWE

JAN 23 2006

RESUBMIT APPROVED

DATE 02-06-06

VERMONT A.S.T.  
LEICESTER BR #6  
Proj # BRFO160005  
C.B.S.S 285

**WELDING PROCEDURE**

(Metric)

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail
		Amperes	Volts		
7018					
1/8 (3.2)	70-170	22-26			
5/32 (3.9)	120-190	22-26			
8018					
1/8 (3.2)	90-160	22-26			
5/32 (3.9)	130-200	22-26			

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. 403 Contractor Casco Bay Steel  
 Revision no. \_\_\_\_\_ Authorized By Paul F. Babilone  
 Form 11-2 Date 4-24-05