

Casco Bay Steel Structures, Inc.

75 Spring Hill Road
Saco, Maine 04072


Phone: (207) 282-7360

Fax: (207) 282-1170

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A 36 - Gr 36 - 50 - SDW (200-345-345W)
 Welding process Shielded Metal Arc welding (SMAW)
 Manual or machine Manual
 Position of welding Overhead (4F)
 Filler metal specification AWS/A5.1 - A5.5
 Filler metal classification E7018 - 8018 C63
 Flux NA
 Shielding gas NA Flow rate NA
 Single or multiple pass Single - multiple
 Single or multiple arc Single
 Welding current D.C.
 Polarity Positive
 Welding progression See Detail
 Root treatment Area 12A - Free of loose scale - slag - rust or moisture
 Preheat and interpass temperature 36(9) to 65(15) to 149(32) to 177(38) to 204(40) to 232(45)
 Postheat temperature NA 75 to 150 (65°)
 Heat Input Min NA Max NA
 Vermont A.G.T.
 Leicester, VT #6
 Proj # BRF016025
 C.B.S.S 285

(Metric) WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
7018				AWS D1.5 Joint detail <u>Fillet</u>  VTRANS RECEIVED OK'D BY _____ OK'D BY <u>JWC</u> JAN 23 2006 RESUBMIT _____ APPROVED <input checked="" type="checkbox"/> BY _____ DATE <u>02-06-06</u>
1/8 (3.2)	95-160	22-26		
5/32 (3.9)	120-190	22-26		
8018				
1/8 (3.2)	110-150	22-26		
5/32 (3.9)	130-190	22-26		

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

Procedure no. 2104 Contractor Casco Bay Steel Structures, Inc.
 Revision no. _____ Authorized By [Signature]
 Form 11-2 Date 6-3-04