

Casco Bay Steel Structures, Inc.

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South Portland, Maine 04106

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A99 Gr 36-50-50W (250-345-345W)
 Welding process Shielded Metal Arc Welding (SMAW)
 Manual or machine Manual
 Position of welding Flat (PF), Horizontal (HF)
 Filler metal specification AWS/A51-A5.5
 Filler metal classification E7018-R018 C/C2 - 7028
 Flux NA
 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 MEET AWS SPECIFICATION
 Root treatment MEET AWS SPECIFICATION
 Preheat and interpass temperature To 3/4 (9) 50° (10°) 3/4 (9) To 1 1/2 (8) 70° (20°) 1 1/2 (8) To 2 1/2 (6.5) 150° (65°)
 Postheat temperature NA
 Heat Input Min NA Max NA

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Box 7 - P.O. Box 138
Warren VT 05554 324

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
AS	7018 1/8 (3.2)	70-170	22-26	AWS D1.5 Joint detail FILLET	IF
	5/32 (3.9)	120-225	22-26		
REQ	3/16 (4.8)	170-300	24-27	REQ	
	7018 1/8 (3.2)	90-160	22-26		
REQ	5/32 (3.9)	120-225	22-26	REQ	
	3/16 (4.8)	180-290	24-27		
REQ	7028 5/32 (3.9)	170-270	22-26	REQ	
	3/16 (4.8)	210-330	24-27		

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
 Authorized By Paul E. Hudale
 Date 3/2/00

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