

Casco Bay Steel Structures, Inc.

75 Spring Hill Road
Saco, Maine 04072

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A209-G+36-50-50w/A209M GR 250-345-345W
 Welding process Flux Cored Arc welding (FCMw)
 Manual or machine Semi AUTO
 Position of welding Flat - Horizontal
 Filler metal specification AWS A5-29
 Filler metal classification E81T1-Ni1-H4 ESAB
 Flux NA
 Shielding gas 75% AR - 25% CO₂ Flow rate 35 CFH #8-4
 Single or multiple pass single / multiple Elec Ex 5/8 = 1/4
 Single or multiple arc single
 Welding current DC EP
 Polarity DC EP
 Welding progression See detail
 Root treatment wire brush - area to be Free of Loose Scale, Slag, rust & Moisture
 Preheat and interpass temperature To 200 (390) 10(50), 200 (390) to 400 (750) 20(100) to 650 (1200) 15 (300)
 Postheat temperature NA
 Heat Input Min 20.7 KJ/in Max 43.6 KJ/in PQR FCM #8 39.6 KJ/in

WELDING PROCEDURE

Br. Rd / Freeman Brook
Br. No 7 - Proj No 3HFC100(1)
Warren VT. CBSSAC 324

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail
		Amperes	Volts		
		287	29	13"	
	1/16	258	26.6	11.4	
		315	31	14	

TRANS RECEIVED
 ORDERED BY JWC
 JUL 16 2007
 APPROVED BY [Signature]
 DATE 6-17-07

AWS OCT
 PAUSE CONTROL
 #4100201
 EWI

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. 101
 Revision no. _____
 Form III-2

Contractor Casco Bay Steel
 Authorized By Paul G. Goodale
 Date 12-6-06
 64655