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 APR 09 2007
 RESUBMIT _____ APPROVED
 DATE 4-13-07

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 A99/A99M - Grade 36 (A50 50 (45) 50w (345w)
 Welding process Flux Cored Arc welding (FCAW)
 Manual or machine Semi Auto
 Position of welding Flat (1F) Horizontal (2F)
 Filler metal specification AWS A5.20
 Filler metal classification E71T-1
 Flux NA
 Shielding gas 75% Ar 25% CO2 Flow rate 40 CFH ± 5
 Single or multiple pass Single and Multiple - Electrode Extension 3/8" (507-636)
 Single or multiple arc Single
 Welding current DC
 Polarity Reverse
 Welding progression _____
 Root treatment To meet AWS specification
 Preheat and interpass temperature To 1/2 (101) 3/4 (104) To 1/2 (101) 3/4 (104) To 1/2 (101) 3/4 (104)
 Postheat temperature NA
 Heat input Min NA Max NA
Bradford VT
Proj = STB14788
C853 = 314

(METRIC)

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
1/16	1/16	205	28.8	11.6	1F To 1/2 (12.7)
		247.5	26.8	10.4	
		302.5	30.8	12.8	
1/8	1/8	205	28.8	294.6	2F To 3/8 (9.5)
		247.5	26.8	264.2	
		302.5	30.8	325.12	

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. 101 Contractor Casco Bay Steel
 Revision no. _____ Authorized By Phil C. Scodale
 Form II-2 Date 3/23/07

