

**Casco Bay Steel Structures, Inc.**

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**WELDING PROCEDURE SPECIFICATION**

Material specification A56-A572-A588 (ASTM 709 C+36-50-50W)  
 Welding process Flux Cored Arc Welding (FCAW)  
 Manual or machine semi-AUTO  
 Position of welding Flat  
 Filler metal specification AWS 5.20  
 Filler metal classification E71T-1  
 Flux NA  
 Shielding gas 75% AR 25% CO<sub>2</sub> Flow rate 40 F<sup>3</sup>  
 Single or multiple pass single Electrode stick out 3/4" ETV  
 Single or multiple arc single  
 Welding current Direct Current  
 Polarity Reverse Electrode Positive  
 Welding progression as detail  
 Post treatment as detail  
 Preheat and interpass temperature as detail  
 Postheat temperature NA  
 Heat Input Min NA Max NA

**WELDING PROCEDURE**

Pass no.	Electrode size	Welding current		Travel speed	Notes
		Amps	Volts		
1/16	2.80 ± .28	25 ± 1.7	19.1 V	19 IPM ± 1.7	Filler Square groove joint detail BUTT
1.6	2.80 ± .28	25 ± 1.7	19.1 V	19 IPM ± 1.7	RECEIVED APR 09 2007 APPROVED

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

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 Revision no. AWS-CR1 Authorized By Paul E. Goodale  
 Form W-2 Paul E. Goodale Date 2/2/99  
 C.W.I.