

TRANS
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APR 09 2007

RESUBMIT _____ APPROVED _____

BY _____ DATE 4/13/07

Fax: (207) 772-0580

Casco Bay Steel Structures, Inc.
5 Industry Road
South Portland, Maine 04106

Phone: (207) 772-2533

WELDING PROCEDURE SPECIFICATION

Welding specification ASTM A109 Gr 50-55-50 (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-A55

Filler metal classification E 7018 R218 5/16 - 7/8

Flux NA

Shielding gas NA Flow rate NA

Single or multiple pass Single and multiple

Single or multiple arc Single

Welding current AC 100

Polarity Straight / Reverse

Welding progression _____

Root treatment Meet AWS SPECIFICATION

Preheat and interpass temperature 70 (160) 50 (100) 3/16 (1.6) 1/8 (2.0) 5/16 (2.4) 3/8 (2.4) 1/2 (3.2) 5/8 (3.2) 3/4 (3.2) 7/8 (3.2) 1 (3.2)

Postheat temperature NA

Heat input Min _____ Max NA

Bradford VT
Proj # STP194788
CBS5 # 314

Pass no.	Electrode size	Welding current		Travel speed	AWS Q165 Joint detail	Filllet
		Amperes	Volts			
AS	1/8 (3.2)	70-170	22-26	AS	3/8 to 3/8 (5" to 10")	1/4 to 3/8 (3 to 10)
	5/32 (4.0)	120-225	22-26			
REQ	3/16 (4.8)	170-300	24-27	REQ	3/8 to 3/8 (5" to 10")	1/4 to 3/8 (3 to 10)
	7/8 (21.3)	70-160	22-26			
REQ	5/32 (4.0)	120-225	22-26	REQ	3/8 to 3/8 (5" to 10")	1/4 to 3/8 (3 to 10)
	3/16 (4.8)	180-290	24-27			
REQ	5/32 (4.0)	190-270	22-26	REQ	3/8 to 3/8 (5" to 10")	1/4 to 3/8 (3 to 10)
	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

Revision no. _____ Authorized By Paul E. Hodale

Form III-2 Date 3/2/00