

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A99/A99M - Grade 36(50) 50(45) 50W(346W)
 Welding process Flux Cored Arc Welding (FCAW)
 Manual or machine SEMI AUTO
 Position of welding Flat (1F) Horizontal (6F)
 Filler metal specification AWS A5.20
 Filler metal classification E71T-1
 Flux NA
 Shielding gas 75% AR 25% CO2 Flow rate 40 CFH ES
 Single or multiple pass Single and multiple - Electrode Extension 1/8" (3.2mm)
 Single or multiple arc Single
 Welding current DC
 Polarity Reverse
 Welding progression To meet AWS specification
 Preheat and interpass temperature To 30 (10) 30 (10) To 150 (60) 150 (60)
 Postheat temperature NA
 Heat Input Min NA Max NA

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5	Joint detail
		Amps	Volts			
1/16	2.05	28.8	11.6	11.6 10.4 12.8	1F	
	2.475	26.8	10.4			
	3.025	30.8	12.8			
1/8	2.75	28.8	29.6	29.6 26.2 32.5/12	2F	
	2.475	26.8	26.2			
	3.025	30.8	32.5/12			

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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
 Revision no. 01
 Form 31-2

Contractor Casco Bay Steel
 Authorized By Paul E. Goodale
 Date 5/23/00

