

Manual or machine Manual
 Position of welding Flat (1F), Horizontal (2F)
 Filler metal specification AWS/AWS A5.1 - A5.5
 Filler metal classification E7018 - 8018 c/c3 - 7028
 Flux NA
 Shielding gas NA Flow rate NA
 Single or multiple pass Single and multiple
 Single or multiple arc single
 Welding current AC/DC
 Polarity STraight / Reverse
 Welding progression _____
 Root treatment MEET AWS SPECIFICATION
 Preheat and interpass temperature To 3/4(19) 50°(10°) 3/4(19) To 1/2(38) 70°(20°) 1/2(38) To 2 1/2(63.5) 150°(65°)
 Postheat temperature NA over 2 1/2(63.5) 225°(110°)
 Heat Input Min NA Max NA

TRAWS RECEIVED
 OK'D BY _____ OK'D BY JOC
 SEP 28 2009
 RESUBMIT _____ APPROVED ✓
 BY _____ DATE 10/13/09

Vermont A.C.T.
 B: #15 - Proj # 1443(34)
 CIARE-DON - CB55424

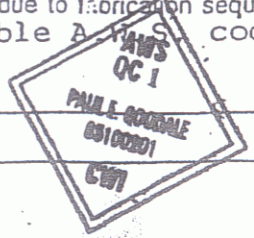
WELDING PROCEDURE

(Metric)

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail Fillet		
		Amperes	Volts				
AS REQ.	<u>7018</u>				<u>1F</u>		
	<u>1/8 (3.2)</u>	<u>70-170</u>	<u>22-26</u>	<u>AS REQ.</u>			
	<u>5/32 (3.9)</u>	<u>120-225</u>	<u>22-26</u>		<u>3/16 To 3/8 (5 To 10)</u>	<u>3/8 To 1/2 (10 To 13)</u>	<u>1/2 To 5/8 (13 To 16)</u>
	<u>3/16 (4.8)</u>	<u>170-300</u>	<u>24-27</u>				
	<u>8018</u>						
	<u>1/8 (3.2)</u>	<u>90-160</u>	<u>22-26</u>				
	<u>5/32 (3.9)</u>	<u>120-225</u>	<u>22-26</u>				
	<u>3/16 (4.8)</u>	<u>180-290</u>	<u>24-27</u>				
<u>7028</u>				<u>2F</u>			
	<u>5/32 (3.9)</u>	<u>170-270</u>	<u>22-26</u>		<u>3/16 To 5/16 (5 To 8)</u>	<u>3/8 (10)</u>	<u>7/16 To 5/8 (11 To 16)</u>
	<u>3/16 (4.8)</u>	<u>210-330</u>	<u>24-27</u>				

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in applicable AWS codes or contract specifications

Procedure no. 401
 Revision no. _____



Contractor Casco Bay Steel
 Authorized By Paul E. Hoodale
 Date 3/2/00