

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709/A709M - Gr 36-50-50w (250-345-345w)
 Welding process STUD WELDER (S.W.)
 Manual or machine Machine VTRANS
 Position of welding Flat RECEIVED
 Filler metal specification NA BY JWC
 Filler metal classification NA
 Flux NA Flow rate NA
 Shielding gas NA
 Single or multiple pass Single
 Single or multiple arc Single
 Welding current DC EN 4/19/08
 Polarity DC EN
 Welding progression NA
 Post treatment Clean surface to be welded
 Preheat and interpass temperature To 3/4" 50° to 1 1/2" 70° to 1 1/2" 150° over 2 1/2" 225°
 Postheat temperature NA
 Heat input Min NA Max NA Rich Ford, VT
Br. No. 41 - Proj No. BHF-0302(C)S
C.B.S.S. 361

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1-1 Joint detail	AWS D1-5
		Amperes	Volts			
	STUD size		Weld Time			
1/2	350	650	35"			
5/8	350	650	35"	NA		
3/4	550	750	40"			
7/8	650	850	1.0"			

NOTE:
This procedure is only a guide to setup.

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. # I S.W.
 Revision no. _____
 Form III-2

Contractor Casco Bay Steel
 Authorized By [Signature]
 Date May 3-2008

