

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

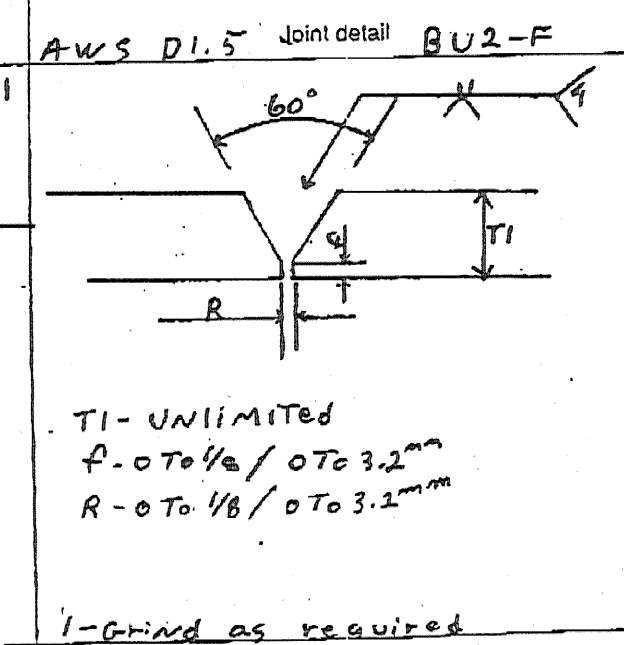
Material specification A36-A572-A588 (ASTM A36 Gr 36-50-50w)
 Welding process Flux Cored Arc welding (FCAW)
 Manual or machine SEMI-AUTO
 Position of welding FLAT-1G
 Filler metal specification AWS A5-20
 Filler metal classification E71T-1
 Flux NA
 Shielding gas 75% AR 25% CO₂ Flow rate 40-55
 Single or multiple pass Both Electrode stick out 3/4-1 1/4
 Single or multiple arc Single
 Welding current Direct current
 Polarity Reverse Electrode positive
 Welding progression see detail
 Root treatment see detail
 Preheat and interpass temperature To 50-50 (18-100) 3/4 to 1 1/2 (19 to 38-205)
 Postheat temperature NA
 Heat input Min NA Max NA

RICH FUND VT
 BRNO. 41 - Proj. NO BHF-0302(3)S
 C655361

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed
		Amperes	Volts	
	1/16	25 ± 2	25 ± 1.7	11 ± 1.1
	1/8	25 ± 2	25 ± 1.7	280 ± 28

TRANS RECEIVED
 JUC
 DATE 4/17/08



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. 104 Contractor Casco Bay Steel
 Revision no. AWS-QC1 Authorized By Paul E. Goodale
 Form III-2 Paul E. Goodale Date 2/2/99
 BSI00201
 C.W.I.