

Casco Bay Steel Structures, Inc.

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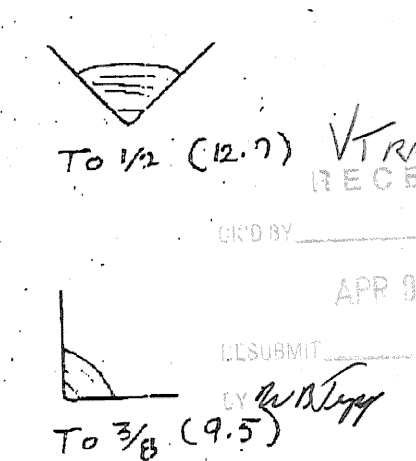
WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709/A709M - Grade 36 (50) 50 (45) 50 W (345 W)
 Welding process Flux Cored Arc Welding (FCAW)
 Manual or machine Semi Auto
 Position of welding Flat (1F) Horizontal (2F)
 Filler metal specification AWS A5.20
 Filler metal classification E71T-1
 Flux NA
 Shielding gas 75% AR 25% CO₂ Flow rate 40 CFH ± 5
 Single or multiple pass Single and Multiple - Electrode Extension 3/8" (50" ± 6.35)
 Single or multiple arc Single
 Welding current DC
 Polarity Reverse
 Welding progression
 Root treatment As per AWS specification
 Preheat and interpass temperature To 3/8" (19) 50 (110) 3/4" (19) To 1/2" (20) 50 (110) To 3/4" (19) 50 (110) To 1" (25) 150 (65)
 Postheat temperature NA
 Heat input Min NA Max NA
 Rich Ford, VT
 B.V.M.C. 41 - Proj No. BHF-0302(3)S
 C.B.S.S. 361

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
1/16	1/16	205	28.8	11.6	1F
		247.5	26.8	10.4	
		302.5	30.8	12.8	
1/8	1/8	205	28.8	294.6	2F
		247.5	26.8	264.2	
		302.5	30.8	325.12	

Joint detail: Flillet

Diagram: 

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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 Contractor Casco Bay Steel
 Revision no. 1 Authorized By A.C. Goodale
 Form III-2 Date 3/23/08