

04/08/2008 09:17 FAX 207-772-2533

CASCO BAY STEEL

Casco Bay Steel Structures, Inc.
 5 Industry Road
 South Portland, Maine 04106

Phone: (207) 772-2533 Fax: (207) 772-0580

WELDING PROCEDURE SPECIFICATION

Material specification A36-A572-A588 (ASTM 709 GR 36-50-50W)
 Welding process Flux Cored Arc welding (FCAW)
 Manual or machine Semi-AUTO
 Position of welding Flat
 Filler metal specification E70T-1
 Filler metal classification E70T-1
 Flux NA
 Shielding gas 75% AR 25% CO₂ Flow rate 40 F5
 Electrode STICK OUT 3/4" EVO
 Single or multiple pass Single
 Single or multiple arc Single
 Welding current Direct Current
 Polarity Reverse Electrode Positive
 Welding progression see Detail
 Root treatment None
 Preheat and interpass temperature 2 to 3/4-50 (19-100) + 3/4 to 1 1/2-200 (119 to 38-200)
 Postheat temperature NA
 Heat input Min NA Max NA

RICA Ford, VT
 B-41C-41- Proj No. BHF-0302(3)S
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WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5	Filler
		Amperes	Volts			
1/16	280	28	17.7	17 IPM ± 1.7	Square groove joint detail	BUTT
1.6	280	28	17.7	143.2 ± 43.2		

TRANS RECEIVED
 JWC
 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. 105 Contractor Casco Bay Steel
 Authorized By [Signature]
 Revision no. AWC

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