

Casco Bay Steel Structures, Inc.
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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A102 Gr 36-50 (250-345-345W)
 Welding process Shielded Metal Arc Welding (SMAW)
 Manual or machine Manual
 Position of welding Flat (PF) Horizontal (HF)
 Filler metal specification AWS/A51-A5.5
 Filler metal classification E7018-R018 C/C2-7028
 Flux NA
 Shielding gas NA
 Single or multiple pass Single and multiple
 Single or multiple arc Single
 Welding current AC/DC
 Polarity Straight/Reverse
 Root treatment Meet AWS specification
 Preheat and interpass temperature 50°(10°) 50°(10°) 300°(150°) 140°(60°) 200°(90°) 180°(80°) to 216°(100°) 150°(65°)
 Postheat temperature NA
 Heat input Min NA Max NA

Rich Ford, VT
By MC-41 - Proj No BHF-0302(3)S
C.B.S.S 361

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5	Joint detail	Filler
		Amperes	Volts				
AS	7018 1/8 (3-2)	70-170	22-26	AS	1F		Filler
	5/32 (3-9)	120-225	22-26				
	3/16 (4-8)	170-300	24-27				
RF	7018 1/8 (3-2)	90-160	22-26	RF	2F		Filler
	5/32 (3-9)	120-225	22-26				
	3/16 (4-8)	180-290	24-27				
RF	7018 1/8 (3-2)	170-270	22-26	RF	3/16 to 3/8 (5 to 8)		Filler
	5/32 (3-9)	170-270	22-26				
	3/16 (4-8)	210-330	24-27				

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

Procedure no. 401
 Revision no. 1
 Contractor Casco Bay Steel
 Authorized By Paul E. Hordale
 Date 3/2/00