

**Casco Bay Steel Structures, Inc.**

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Saco, Maine 04072

Phone: (207) 282-7360

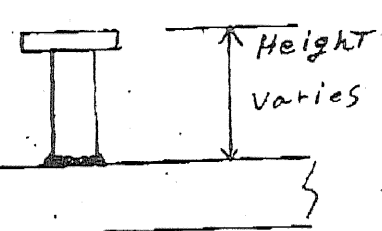
Fax: (207) 282-1179

**WELDING PROCEDURE SPECIFICATION**

Material specification ASTM-A709/A709M-Gr36-50-50w(250-345-345W)  
 Welding process STUD WELDER (S.W.)  
 Manual or machine Machine  
 Position of welding Flat  
 Filler metal specification NA  
 Filler metal classification NA  
 Flux NA  
 Shielding gas NA Flow rate NA  
 Single or multiple pass single  
 Single or multiple arc single  
 Welding current DC EN  
 Polarity DC EN  
 Welding progression NA  
 Root treatment Clean surface to be welded  
 Preheat and interpass temperature To 34-50° 3/4" to 1 1/2" 70° 1 1/2" to 2 1/2" 150° over 2 1/2" 225°  
 Postheat temperature NA  
 Heat input Min NA Max NA

Rick Ford, VT  
Br. No. 41- Proj. No. BHF-0302(3)S  
C 855 361

**WELDING PROCEDURE**

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
	STUD size		Weld TIME		
1/2	350	35	NA		
	650	35			
5/8	350	35			
	650	35			
3/4	550	40			
	750	40			
7/8	650	1.0			
	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. Contractor Casco Bay Steel  
 Revision no. 1 Authorized By [Signature]  
 Form III-2 Date May 3-1999

