

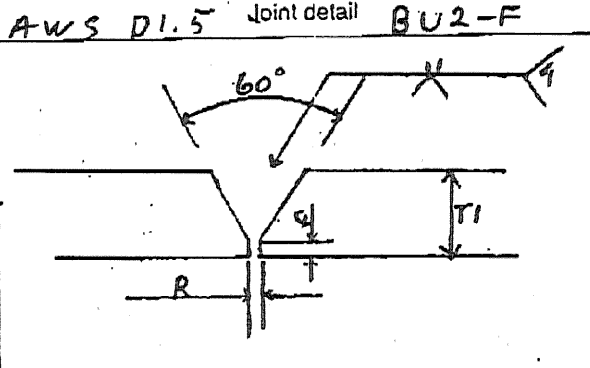
04/08/2000 09:10 FAX 2072533119 CASCO BAY STEEL WJ000
Casco Bay Steel Structures, Inc.
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 South Portland, Maine 04106
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WELDING PROCEDURE SPECIFICATION

Material specification A36-A572-A578 (ASTM A36 or 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 SS
 Single or multiple pass Both Electrode STICK OUT 3/4
 Single or multiple arc Single
 Welding current Direct current
 Polarity Reverse Electrode positive
 Welding progression see detail
 Root treatment side side 1 backspace side 2 grind then weld
 Preheat and interpass temperature To 50-50 (10-10) 3/4 to 1/2 (10-20)
 Postheat temperature NA
 Heat Input Min NA Max NA
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WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed
		Amps	Volts	
	1/16	280 ±28	25 ±1.7	11 ±1.1
	1/6	280 ±28	25 ±1.7	280 ±28

AWS D1.5 Joint detail BU2-F

 T- UNLIMITED
 T- 0 to 1/8 / 0 to 3.2 mm
 R- 0 to 1/8 / 0 to 3.2 mm
 1-grind as required

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-OC1 Authorized By Paul E. Goodale
 Form #2 Paul E. Goodale Date 2/2/99
 BSI00201
 C.W.I.