

Casco Bay Steel Structures, Inc.

5 Industry Road
South Portland, Maine 04106

Phone: (207) 772-2533

Fax: (207) 772-0580

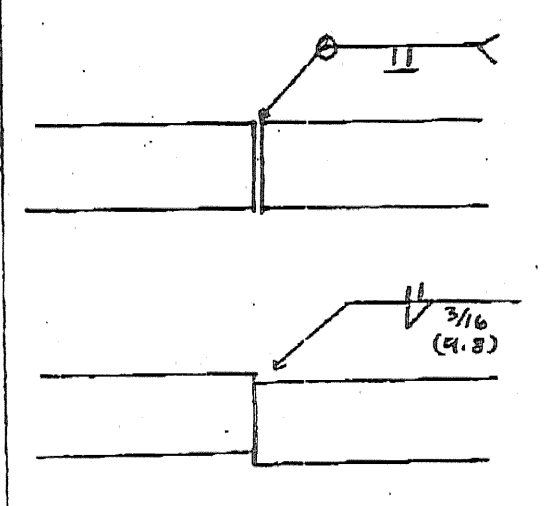
WELDING PROCEDURE SPECIFICATION

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 AWS 5.20
 Filler metal classification E71T-1
 Flux NA
 Shielding gas 75% AR 25% CO₂ Flow rate 40 F5
 Single or multiple pass Single Electrode stick out 3/4" ± 1/4"
 Single or multiple arc SINGLE
 Welding current Direct Current
 Polarity Reverse Electrode Positive
 Welding progression see Detail
 Root treatment None AWS Weld from one side only
 Preheat and interpass temperature 2 to 3/4-50° (19-100°) + 3/4 to 1 1/2-200° (19 to 38-200°)
 Postheat temperature NA
 Heat Input Min NA Max NA

Rich Ford, VT
 B.P. No. 41 - Proj No. BHF-0302(3)S
 CBS 361

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5	Filler
		Amperes	Volts			
	1/16	280 ± 28	25 ± 1.7	17 IPM ± 1.7	Square groove joint detail	BUTT
	1.6	280 ± 28	25 ± 1.7	432 ± 43.2		



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. 1.05 Contractor Casco Bay Steel
 Revision no. AWC Authorized By J.P. Swadlow

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