

Casco Bay Steel Structures, Inc.

75 Spring Hill Road
Saco, Maine 04072

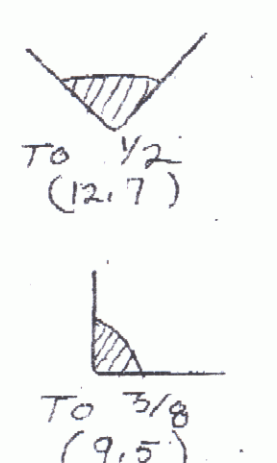
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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709/A709M Gr 36 (250) -50(45) -50W (345W)
 Welding process Flux Cored Arc Welding
 Manual or machine semi-AUTO
 Position of welding Flat (1F) - Horizontal (2F)
 Filler metal specification AWS-A5-29
 Filler metal classification E81T1-A11
 Flux NA
 Shielding gas 75%AR / 25%CO₂ flow rate 35 CFH ±8.6
 Single or multiple pass single and multiple
 Single or multiple arc single
 Welding current Direct
 Polarity Reverse Electrode Positive
 Welding progression NA
 Post treatment Heat AWS D1.5 specification
 Preheat and interpass temperature 30(19) 50° (10) - 30(19) to 120° (49) to 150° (65)
 Postheat temperature NA
 Heat input Min 28.6 (1.15kcal) Max 45.2 (1.80kcal) P.Q.R. # 409 (115)

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail
		Amps	Volts		
AS	1/16	27.5	28.8	11.6	1F
		24.7 TO 302.5	26.8 TO 30.8	10.4 TO 12.8	
		27.5	28.8	11.6	
Req	1/16	27.5	28.8	11.6	2F
		24.7 TO 302.5	26.8 TO 30.8	10.4 TO 12.8	
		27.5	28.8	11.6	



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. 101-A Contract Casco Bay Steel
 Revision no. 1 Authorized by [Signature]
 Date 9/20/07

Form 13-2
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