

Casco Bay Steel Structures, Inc.

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A572-50W
Welding process Shielded Metal Arc
Manual or machine Manual
Position of welding Flat, Horizontal
Filler metal specification AWS/A5.1-A5-5
Filler metal classification E7018-E8018 C/C3
Flux NA
Shielding gas NA Flow rate NA
Single or multiple pass single & multiple
Single or multiple arc single
Welding current AC/DC
Polarity STRAIGHT & Reverse
Welding progression See Detail
Root treatment Grind-wire brush-Area Free of Slag-Rust-Moisture
Preheat and interpass temperature NA
Postheat temperature NA
Heat Input Min NA Max NA

Minimum Preheat and Interpass Temperature, °C [°F]

Welding Process (Base Metal)	Thickness of Thickest Part at Point of Welding, mm (in)			
	To 20 mm (3/4 in) incl.	Over 20 mm (3/4 in) to 40 mm (1-1/2 in) incl.	Over 40 mm (1-1/2 in) to 65 mm (2-1/2 in) incl.	Over 65 mm (2-1/2 in)
SAW, GMAW, FCAW, SMAW (M270M [M270] [A 709M (A 709)] Or, 250 [36], 345 [50], 345W [50W], HPS 345W (HPS 50W)	10 [50]	20 [70]	65 [150]	110 [225]

VT. DOT HYDE PARK
PR NO. 42
PRJ NO. STP-CUW (26)
CASS NO. 865

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail
		Amperes	Volts		
AS Reg.	<u>7018</u>				<u>Fillet</u>
	<u>1/8</u>	70 To 170	22-26		<u>2F</u>
	<u>5/32</u>	120 To 225	22-26		
	<u>3/16</u>	170 To 300	24-27		
	<u>8018</u>				
	<u>1/8</u>	90 To 160	22-26		
	<u>5/32</u>	120 To 225	22-26		
	<u>3/16</u>	180 To 290	24-27		

Vermont Agency of Transportation
RECEIVED
CK'D BY JWC OK'D BY JWC
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BY DATE 03/24/2014

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. 401
Revision no. _____

Contractor Casco Bay Steel
Authorized By John E. [Signature]
Date April 13 2012