



Casco Bay Steel Structures
One Wallace Avenue, South Portland ME 04106
AWS - Welding Procedure Specification (WPS)
WeldOffice WPS

WPS record number	203	Revision	1	Qualified to	AWS D1.5
Date	4/24/2014	Company name	Casco Bay Steel Structures		

JOINTS: Typical joint(s). See actual production drawings and engineering specifications for details.

	<table><tr><th>Amps</th><th>Volts</th><th>Travel Speed</th></tr><tr><td>AVG 604 /</td><td>29.5 /</td><td>17.1 IPM</td></tr><tr><td>MIN 544 /</td><td>27.4 /</td><td>14.5 IPM</td></tr><tr><td>MAX 644 /</td><td>31.6 /</td><td>19.7 IPM</td></tr></table>	Amps	Volts	Travel Speed	AVG 604 /	29.5 /	17.1 IPM	MIN 544 /	27.4 /	14.5 IPM	MAX 644 /	31.6 /	19.7 IPM	
Amps	Volts	Travel Speed												
AVG 604 /	29.5 /	17.1 IPM												
MIN 544 /	27.4 /	14.5 IPM												
MAX 644 /	31.6 /	19.7 IPM												
BL2c-S Over 1/2" to 1" (1/4 root face min) Over 1" to 1-1/2" (3/8 root face min) Over 1-1/2" to 2" (1/2 root face min) *backside shall be backgouged prior to welding														

Type of groove	Single-V-groove	Minimum groove angle	(deg.)	55 to 70
		Minimum root opening	(in.)	0 to 1/16
		Maximum root face	(in.)	varies

PREHEAT TABLE

Applicable standard	
AWS D1.5 Bridge Welding Code	For thickness 1/8 to 3/4(in.): 50°F). Preheat to 70(°F) if the base metal temperature is below 32(°F). Over 3/4 thru 1-1/2(in.): 70(°F). Over 1-1/2 thru 2-1/2(in.): 150(°F). Over 2-1/2(in.): 225(°F). Refer to AWS D1.5 2010 Table 4.3 (pg 85)
AWS D1.5 2010 FCM	For thickness 1/8 to 3/4(in.): 100°F). Over 3/4 thru 1-1/2(in.): 200(°F). Over 1-1/2 thru 2-1/2(in.): 300(°F). Over 2-1/2(in.): 350(°F). No welding to be done if ambient temperature in immediate area is below 0(°F)
New York SCM	Up to 3/4 -----100 (F) Over 3/4 to 1-1/2 -----200 (F) Over 1-1/2 to 2-1/2 -----300 (F) Over 2-1/2 -----350 (F)

TECHNIQUE

Supplementary MF control Peening Surface preparation Initial/interpass cleaning Back gouging method	Grind/Blast/chemical/wirebrush clean to be free of moisture, slag, millscale, oils, dust Brushing and Grinding Grinding or Air Carbon Arc Gouging
---	---

NOTES

AWS FCM preheats are taken from AWS D1.5 2010 Clause 12 Table 12.4 and are based upon calculated heat input calculated in accordance with section 5.12 with an as welded H8 designation for the electrode combinationwe are using. This higher preheat will be used on non weathering steels also.

Vermont Agency of Transportation
RECEIVED
CK'D BY _____ OK'D BY Rob Young
April 4, 2016
RESUBMIT NO Approved
BY Rob Young DATE 04/08/2016

Signature 1

Name	Signature	Name	Signature
Matthew Cote			
Date		Date	
6/2/14			



Matthew J Cote
CWI 08051341
QC1 EXP. 5/1/2017

Signature 3

Name	Signature	Name	Signature
Date		Date	

Signature 2

Name	Signature
Date	

Signature 4

Name	Signature
Date	