



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

WPS record number	653	Revision	Qualified to	AWS D1.5
Date	10/5/2015		Company name	Casco Bay Steel Structures
Supporting PQR(s)	613 FCM			
Reference docs.				

Scope	Groove
Joint	Joint details for this welding procedure specification in: JOINTS section of this WPS

BASE METALS				THICKNESS RANGE QUALIFIED (in)			
Type	Gr 50	P-no.	Grp-no.	As-welded	As-welded	With PWHT	With PWHT
Welded to	Gr 50	P-no.	Grp-no.	Min	Max	Min	Max
Backing	as reqd	P-no.	Grp-no.				
Retainers				Complete pen.	-	-	-
Notes				Impact tested	-	-	-
				Partial pen.	-	-	-
				Fillet welds	-	-	-
				DIAMETER RANGE QUALIFIED (in)			
				As-welded	As-welded	With PWHT	With PWHT
				Min	Max	Min	Max
				-	-	-	-

FILLER METALS						THICKNESS RANGE QUALIFIED (in)			
	SFA	Classification	F-no.	A-no.	Chemical analysis or Trade name	As-welded	As-welded	With PWHT	With PWHT
						Min	Max	Min	Max
GMAW	5.36	E70C-6MH4	6		ESAB Core Weld C6	-	-	-	-
Sup. filler	-	-	-	-	-	- None -			

WELDING PROCEDURE			
Welding process		GMAW	
Type		Automatic / Semi-Automatic	
Minimum preheat/interpass temperature (°F)		SEE BACKPAGE	
Maximum interpass temperature (°F)		390 F	
Filler metal size (in)		.052	
Layer number			
Position		F,H	
Weld progression		Not applicable	
Current/polarity		DCEP (reverse polarity)	
Amperes		296	
Volts		29.1	
Travel speed (in./min)		13.1	
Maximum heat input (kJ/in)		39.5	
Wire feed speed (in./min)			
Arc transfer mode		Spray	
Shielding: Gas type		Argon/CO2, 90/10	
Flow rate (cfh)		35	
Trailing: Gas type			
Flow rate (cfh)			
Backing: Gas type			
Flow rate (cfh)			
String or weave		Stringer or Weave	
Orifice/gas cup size (in)		5/8	
C.T.W.D		Single or Multiple passes	
Multi/Single electrode		Single electrode	
Maximum pass thickness (in)			
Weld deposit chemistry		E70C-6MH4	
Notes			

Approved for Waitefield
Joint
5/13/16
RSF