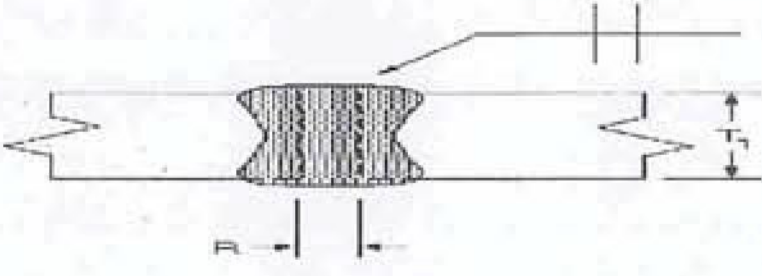




Casco Bay Steel Structures
One Wallace Avenue, South Portland ME 04106
AWS - Welding Procedure Specification (WPS)
WeldOffice WPS

WPS record number	202	Revision	3	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 569 /</td><td>27.4 /</td><td>15.5 IPM</td></tr><tr><td>MAX 625.1 /</td><td>31.0 /</td><td>18.7 IPM</td></tr></table>	Amps	Volts	Travel Speed	AVG 604 /	29.5 /	17.1 IPM	MIN 569 /	27.4 /	15.5 IPM	MAX 625.1 /	31.0 /	18.7 IPM	
Amps	Volts	Travel Speed												
AVG 604 /	29.5 /	17.1 IPM												
MIN 569 /	27.4 /	15.5 IPM												
MAX 625.1 /	31.0 /	18.7 IPM												
B-L1a-S * Second side shall be ground out and/or backgouged to sound metal prior to welding														

Type of groove	Square-groove	Minimum groove angle	(deg.) 0
		Minimum root opening	(in.) 0 to 1/16
		Maximum root face	(in.) 5/8

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 (pg85)

TECHNIQUE

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

NOTES

Vermont Agency of Transportation

RECEIVED

CK'D BY _____ OK'D BY RSF

May 7, 2017

RESUBMIT No
BY C. Carlson
Approved
DATE 05/09/2017

Signature 1	Signature 2
Name	Name
Matthew Cote	
Date	Date
6/2/14	
Signature 3	Signature 4
Name	Name
Date	Date

