

Casco Bay Steel Structures, Inc.

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South Portland, Maine 04106

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A109 Gr 86-50-50W (250-345-345W)
Welding process Shielded Metal Arc Welding (SMAW)
Manual or machine Manual
Position of welding Flat (1F), Horizontal (2F)
Filler metal specification AWS/AWS A5.1 - E70B
Filler metal classification E70B - 8018 C63 - 702B
Flux NA
Shielding gas NA
Single or multiple pass Single and multiple
Single or multiple arc Single
Welding current AC/DC
Polarity STraight / Reverse
Welding progression NA
Root treatment MEET AWS SPECIFICATION
Preheat and interpass temperature To 340 (170) 50 (105) 3/4 (113) To 14 (38) 70 (160) 125 (150) 150 (150) 225 (110)
Postheat temperature NA
Heat Input Min NA Max NA

(Metric)		WELDING PROCEDURE			Travel speed	
Pass no.	Electrode size	Amperes	Volts	Travel speed	Joint detail	Filler
AS REQ	7018 1/8 (3.2)	70-170	22-26	AS REQ	1F	AWS D1.5
	5/32 (3.9)	120-225	22-26			
	3/16 (4.8)	170-300	24-27			
	8018 1/8 (3.2)	90-160	22-26			
AS REQ	5/32 (3.9)	120-225	22-26	AS REQ	2F	AWS D1.5
	3/16 (4.8)	180-270	24-27			
	702B 5/32 (3.9)	170-270	22-26			
	3/16 (4.8)	210-330	24-27			

This procedure may vary due to friction sequence, fit-up, pass size, etc., within the limitation of variables given in applicable codes or contract specifications

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