

Casco Bay Steel Structures, Inc.

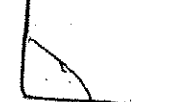
WELDING PROCEDURE SPECIFICATION

Material specification ASTM-A709-Gr 50
Welding process Flux Cored Arc welding
Manual or machine Semi AUTO
Position of welding Flat - Horizontal
Filler metal specification AWS A5-29
Filler metal classification E-81T1-Ni1MnJ-H4 - Dual Shield II 80-Ni1-H4
Flux NA
Shielding gas 75% AR - 25% CO₂ Flow rate 35 CFH +8, -4
Single or multiple pass Single & Multiple
Single or multiple arc Single
Welding current DC
Polarity DC EP
Welding progression see Detail
Root treatment Area to be free of RUST - slag - loose scale & Moisture
Preheat and interpass temperature see Table
Postheat temperature NA
Heat Input Min 34 kJ/in Max 43 kJ/in PAR-03 - 33.6 kJ/in

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

Welding Process (Base Metals)	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 (A220M [M270])	10 [150]	20 [70]	65 [150]	110 [225]

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Sec 5-13 and NY-SCM	
		Amps	Volts		AWS D1-5	Joint detail
A5 REQ	1/16	320	28	16		
		288	27	14		
		To	To	To		
		340	30	18		
		NOV 14 2011				

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. 101 ST OF VT Contractor Casco Bay Steel
Revision no. 1 - 8-3-10 PAUL E. GOODALE authorized By Paul E. Goodale
CWI 65100201
CCI EXP. 10/31/10 5-13-09