

Casco Bay Steel Structures, Inc.

5 Industry Road
South Portland, Maine 04106

Phone: (207) 772-2533

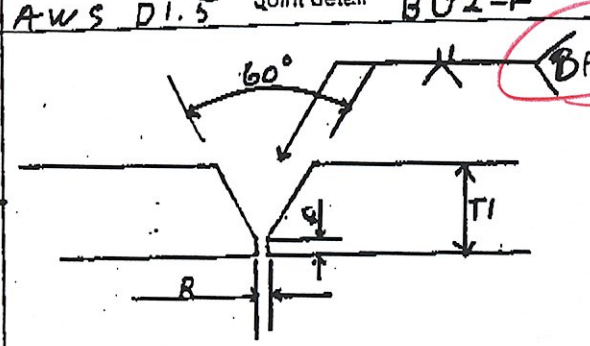
Fax: (207) 772-0580

WELDING PROCEDURE SPECIFICATION

Material specification A36-A572-A588 (ASTM 709 Gr 36-50-50w)
Welding process Flux Cored Arc welding (FCAW)
Manual or machine Semi-AUTO
Position of welding Flat-IG
Filler metal specification AWS A5-20
Filler metal classification E71T-1
Flux As
Shielding gas 75% Ar 25% CO₂ Flow rate 40 ± 5
Single or multiple pass Both Electrode stick out 3/4 ± 1/4
Single or multiple arc Single
Welding current Direct Current
Polarity Reverse Electrode positive
Welding progression See Detail
Root treatment weld side + 1 backspace side + 2 - grind - then weld
Preheat and interpass temperature To 3/4 500° F (14-10°) + 3/4 to 1 1/2 70° (+17 to 38-20°)
Postheat temperature NA
Heat Input Min NA Max NA

VT-AOT, BRNO-5
BIO 40. BHF 6400 (3d)
Fayler St. Ar, CB 55430

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	AWS D1.5 Joint detail
		Amperes	Volts		
	1/16	280 ±28	25 ±1.7	11 ±1.1	
	1/6	280 ±28	25 ±1.7	280 ±28	
TRANS CR-10 MAN 27 2000 RESUBMIT APPROVED DATE 02/14/10					
AS NOTED 1-grind as required					

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. 104 Contractor Casco Bay Steel
Revision no. AWS-OC1 Authorized By Paul E. Goodale
Form III-2 Paul E. Goodale Date 2/2/99
83100201
C.W.I.