

Castco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specificationASTM A 36-50-50W / A 709M Gr 250-345-345W

Welding processFlux cored arc welding (FCAW)

Manual or machineSemi AUTO

Position of weldingFlat - Horizontal

Filler metal specificationAWS A5-29

Filler metal classificationE81T1-Ni-HWESAB

FluxNA

Shielding gas75% Ar - 25% CO<sub>2</sub>Flow rate35 CFH ± 4

Single or multiple passSingle / Multiple

Single or multiple arcSingle

Welding currentDCRP

PolarityDCRP

Welding progressionSee detail

Root treatmentWire brush - area to be Free of loose scale, slag, rust & moisture

Preheat and interpass temperatureTo 20 (34) (50) 40 (34) To 10 (14) 20 (34) 40 (34) To 60 (38) 65 (150)

Postheat temperatureNA

Heat Input Min 22.7 kJ/in Max 43.6 kJ/in PQR FCM # 8 39.6 kJ/in

VT-AOT, BFN0-5

Reg. NO. BHF 6400(21)

12/1/11 ST. BR. CBS 434

| Pass no. | Electrode size | Welding current |       | Travel speed |
|----------|----------------|-----------------|-------|--------------|
|          |                | Amps            | Volts |              |
| 1/16     | 2.87           | 29              | 13    |              |
|          | 2.58           | 26.8            | 11.4  |              |
|          | To             | To              | To    |              |
|          | 315            | 31              | 14    |              |

VT TRANS RECEIVED

CR. BY: DATE: 02/14/10

JAN 27 2010

RESUBMIT BY: DATE: 02/14/10

APPROVED

Joint detail

Fillet

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

Revision no.

Form II-2

Contractor Castco Bay Steel

Authorized By Phil C. Goodale

Date 12-6-06