

Casco Bay Steel Structures, Inc.

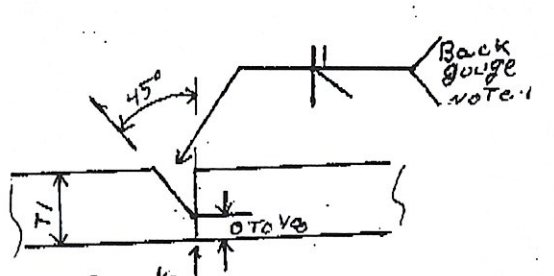
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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A572-50 (250-345-345M)
Welding process Shielded Metal Arc Welding (SMAW)
Manual or machine Manual
Position of welding Flat (1G) Horizontal (2G)
Filler metal specification A572-50
Filler metal classification E7018
Flux NA Flow rate NA
Shielding gas NA
Single or multiple pass Single and multiple
Single or multiple arc Single
Welding current AC
Polarity Reverse
Welding progression As specified
Root treatment To AWS specification
Preheat and interpass temperature To AWS specification
Postheat temperature NA
Heat input Min NA Max NA

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amps	Volts		
A5	7018 1/8 (3.2)	70-120	22-26	A5 REQ	
	5/32 (3.9)	120-225	22-26		
REQ	7018 1/8 (3.2)	90-160	22-26		
	5/32 (3.9)	120-225	22-26		
	7018 5/32 (3.9)	170-220	22-26		
	7018 5/32 (3.9)	170-220	22-26		

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. 402 Contractor Casco Bay Steel
Revision no. 10-16-01 Authorized By Paul E. Boudreau
Form III-2