

Casco Bay Steel Structures, Inc.

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WELDING PROCEDURE SPECIFICATION

Material specification ASTM A36-50-50W (250-345-345W)
Welding process Shielded Metal Arc Welding (SMAW)
Manual or machine Manual
Position of welding vertical up (3F)
Filler metal specification A5.1 - A5.5
Filler metal classification E7018 - R018 C/K3
Flux NA
Shielding gas NA Flow rate NA
Single or multiple pass single - multiple
Single or multiple arc single
Welding current DC
Polarity positive
Welding progression see detail
Root treatment Area To be Free of loose Scale, slag, Rust or Moisture
Preheat and interpass temperature To 34 (19) 50 (10), 34 (19) 70 (12) 70 (20) 125 (90)
Postheat temperature NA
Heat Input Min NA Max NA

VT-AOT, BRNO-5
Proj. NO. B4F6400(3D)
Twyler ST. Pr. CBS432

(Metric)					WELDING PROCEDURE	
Pass no.	Electrode size	Welding current		Travel speed	AWS D1-5	Joint detail
		Amperes	Volts			
7018 (3.2) 5/32 (3.9)	1/8	70-170	22-26			Filet
		120-190	22-26			
8018 (3.2) 5/32 (3.9)	1/8	90-160	22-26			
		130-200	22-26			

Note:
For Tacking and
repair welding
to Code -3-27-06

AWS QC 1
MADE GOOD
02/06/01
CWT

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. 403 Contractor Casco Bay Steel
Revision no. 1 Authorized By Paul H. [Signature]
Form III-2 Date 4-24-03