

Casco Bay Steel Structures, Inc.

75 Spring Hill Road
Saco, Maine 04072

Phone: (207) 282-7360

Fax: (207) 282-1179

WELDING PROCEDURE SPECIFICATION

Material specification ASTM A709/A709M - Grade 36 (50) 50 (45) 50 W (346W)
Welding process Flux Cored Arc Welding
Manual or machine SEMI AUTO
Position of welding FLAT (1F) Horizontal (2F)
Filler metal specification AWS A5.20
Filler metal classification E71T-1
Flux NA 75% AR 25% CO2 Flow rate 40 CFH ± 3
Shielding gas 75% AR 25% CO2 - Electrode Extension 9/8" (58) ± 6.35
Single or multiple pass SINGLE AND MULTIPLE
Single or multiple arc SINGLE
Welding current DC
Polarity Reverse
Welding progression AWS specification
Root treatment ISOMET
Preheat and interpass temperature to 3/4" (19) 50 (10) 34 (8) to 1 1/2" (38) 70 (60) to 2 1/4" (60) 150 (65)
Postheat temperature NA over 2 1/2" (63) 225 (110)
Heat Input Min NA Max NA RICH Ford, VT
Br MC 41 - Proj No BHF-0302(3)S
C 855 36

(METRIC)					
Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
	1/16	205	28.8	11.6	1F TO 1/2" (12.7) TRANS RECEIVED CHKD BY <u>JUC</u> APR 09 2009 DESIGNED BY <u>WBC</u> DATE <u>4/17/08</u> TO 3/8" (9.5)
		247.5	26.8	10.4	
		TO	TO	TO	
		302.5	30.8	12.8	
	1/8	205	28.8	294.6	2F TO 1/2" (12.7) TRANS RECEIVED CHKD BY <u>JUC</u> APR 09 2009 DESIGNED BY <u>WBC</u> DATE <u>4/17/08</u> TO 3/8" (9.5)
		247.5	26.8	244.2	
		TO	TO	TO	
		302.5	30.8	325.12	

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

Contractor Casco Bay Steel

Revision no. 1

Authorized By Paul E. Goodale

Form III-2

Date 3/23/08