CBSS Job # 597
Rutland City, VT
BRF 3000 (16)

Casco Bay Steel Structures

One Wallace Avenue, South Portland ME 04106

AWS - Welding Procedure Specification (WPS)

WeldOffice WPS

WPS record number Date	201 4/24/2014	Revision 1	Qualified to Company name	AWS D1.5 Casco Bay Steel Structures
Supporting PQR(s) Reference docs.	SAW DC + FCM 2-21-14 - Rev 1			

Scope	Fillet, no PWHT (As-welded)
Joint	Joint details for this welding procedure specification in: JOINTS section of this WPS

BASE METALS

Type	Gr50/Gr50W	P-no.	Grp-no. -
Welded to	Gr50/Gr50W	P-no.	Grp-no. -
Backing:	None	P-no.	Grp-no. -
Retainers Notes	All A709 steels with 50 ksi or less are also qualified		

THICKNESS RANGE QUALIFIED (in.)

	As-welded Min.	As-welded Max.	With PWHT Min.	With PWHT Max.
Complete pen.	-	-	-	-
Impact tested	-	-	-	-
Partial pen.	-	-	-	-
Fillet welds	1/8	All	-	-

DIAMETER RANGE QUALIFIED (in.)

	As-welded Min.	As-welded Max.	With PWHT Min.	With PWHT Max.
			-	-

FILLER METALS

	SFA	Classification	F-no.	A-no.	Chemical analysis or Trade name	THICKNESS RANGE QUALIFIED (in.) As-welded Min.	As-welded Max.	With PWHT Min.	With PWHT Max.
SAW	5.23	ENi1K	6		Lincolnweld LA-75	1/8	All	-	-
Flux	-	-	-	-	-	- None -			
Sup. filler	-	-	-	-	-	- None -			

WELDING PROCEDURE

Welding process		SAW
Type		Machine
Minimum preheat/interpass temperature	(°F)	See Backpage
Maximum interpass temperature	(°F)	490
Filler metal size	(in.)	5/32
Layer number		
Position		F,H
Current/polarity		DCEP
Amperes		604
Volts		29.5
Travel speed	(in./min)	17.1
Maximum heat input	(kJ/in.)	62.5193
Wire feed type		Hot wire
Wire feed speed	(in./min)	N/A
String or weave		Stringer
C.T.W.D	(in.)	
Multi/Single pass per side		Single or Multiple passes
Multiple or single layer		Single or Multiple layer
Oscillation		None
Multi/single electrode		Single electrode
Electrode angle	(deg.)	As needed
Maximum pass thickness	(in.)	See Backpage
Weld deposit chemistry		F8A2-ENi1K-Ni1-H8
Notes		

APPROVED
By Jeff Clark at 9:39 am, Apr 23, 2015

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Casco Bay Steel Structures

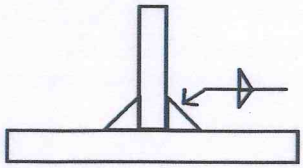
One Wallace Avenue, South Portland ME 04106

AWS - Welding Procedure Specification (WPS)

WeldOffice WPS

WPS record number	201	Revision 1	Qualified to	AWS D1.5
Date	4/24/2014		Company name	Casco Bay Steel Structures

JOINTS: Typical joint(s). See actual production drawings and engineering specifications for details.



3/8 single pass flat
5/16 single pass Horizontal

	Amps	Volts	Travel Speed
AVG	604 /	29.5 /	17.1 IPM
MIN	544 /	27.4 /	14.5 IPM
MAX	644 /	31.6 /	19.7 IPM

*** Multiple passes may be used if drawing details call for a larger size fillet weld than noted above in the position welding is being performed**

Type of groove	Fillet weld	Minimum groove angle	(deg.)	N/A
		Minimum root opening	(in.)	N/A
		Maximum root face	(in.)	N/A

PREHEAT TABLE

Applicable standard	
AWS D1.5 Bridge Welding Code	For thickness 1/8 to 3/4(in.): 50(°F). Preheat to 70(°F) if the base metal temperature is below 32(°F). Over 3/4 thru 1-1/2(in.): 70(°F). Over 1-1/2 thru 2-1/2(in.): 150(°F). Over 2-1/2(in.): 225(°F). Refer to AWS D1.5 2010 Table 4.3 (pg 85)
AWS D1.5 2010 FCM	For thickness 1/8 to 3/4(in.): 100°F). Over 3/4 thru 1-1/2(in.): 200(°F). Over 1-1/2 thru 2-1/2(in.): 300(°F). Over 2-1/2(in.): 350(°F). No welding to be done if ambient temperature in immediate area is below 0(°F)
New York SCM	Up to 3/4 ----------100 (F) Over 3/4 to 1-1/2 ----------200 (F) Over 1-1/2 to 2-1/2 --------300 (F) Over 2-1/2 ----------350 (F)

TECHNIQUE

Supplementary MF control	
Peening	
Surface preparation	Grind/Blast/chemical/wirebrush clean to be free of moisture, slag, millscale, oils, dust
Initial/interpass cleaning	Brushing and Grinding
Back gouging method	None

NOTES

AWS FCM preheats are taken from AWS D1.5 2010 Clause 12 Table 12.4 and are based upon calculated heat input calculated in accordance with section 5.12 with an as welded H8 designation for the electrode combination we are using. This higher preheat will be used on non weathering steels also.

Signature 1

Name	Signature
Matthew Cote	Matthew J Cote CWI 08051341 QC1 EXP. 5/1/2017
Date	
6/2/2014	

Signature 2

Name	Signature
Date	

Signature 3

Name	Signature
Date	

Signature 4

Name	Signature
Date	

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Casco Bay Steel Structures

One Wallace Avenue, South Portland ME 04106

AWS - Welding Procedure Specification (WPS)

WeldOffice WPS

WPS record number Date	203 Revision 1 4/24/2014	Qualified to Company name	AWS D1.5 Casco Bay Steel Structures
Supporting PQR(s) Reference docs.	SAW DC + FCM 2-21-14 - Rev 1		

Scope	Groove, no PWHT (As-welded)
Joint	Joint details for this welding procedure specification in: JOINTS section of this WPS

BASE METALS

Type	Gr50/Gr50W	P-no.	Grp-no. -
Welded to	Gr50/Gr50W	P-no.	Grp-no. -
Backing:	None	P-no.	Grp-no. -
Retainers Notes	All A709 steels with 50 ksi or less are also qualified		

THICKNESS RANGE QUALIFIED (in.)

	As-welded Min.	As-welded Max.	With PWHT Min.	With PWHT Max.
Complete pen.	over 1/2	2	-	-
Impact tested	-	-	-	-
Partial pen.	NO	-	-	-
Fillet welds	-	-	-	-

DIAMETER RANGE QUALIFIED (in.)

	As-welded Min.	As-welded Max.	With PWHT Min.	With PWHT Max.
			-	-

FILLER METALS

	SFA	Classification	F-no.	A-no.	Chemical analysis or Trade name	As-welded Min.	As-welded Max.	With PWHT Min.	With PWHT Max.
SAW	5.23	ENi1K	6		Lincolnweld LA-75	over 1/2	2	-	-
Flux Sup. filler	5.23 -	F8A2 -	6 -	-	Lincolnweld 960 -	- Required - - None -			
Flux type Flux from recrush. slag	No								

WELDING PROCEDURE

Welding process		SAW
Type		Machine
Minimum preheat/interpass temperature	(°F)	See Backpage
Maximum interpass temperature	(°F)	490
Filler metal size	(in.)	5/32
Layer number		
Position		F
Current/polarity		DCEP
Amperes		604
Volts		29.5
Travel speed	(in./min)	17.1
Maximum heat input	(kJ/in.)	62.5193
Wire feed type		Hot wire
Wire feed speed	(in./min)	N/A
String or weave		Stringer
C.T.W.D	(in.)	
Multi/Single pass per side		Single or Multiple passes
Multiple or single layer		Single or Multiple layer
Oscillation		None
Multi/single electrode		Single electrode
Electrode angle	(deg.)	As needed
Maximum pass thickness	(in.)	
Weld deposit chemistry		F8A2-ENi1K-Ni1-H8
Notes		

APPROVED

By Jeff Clark at 9:40 am, Apr 23, 2015

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Casco Bay Steel Structures

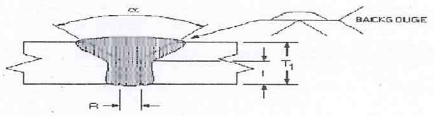
One Wallace Avenue, South Portland ME 04106

AWS - Welding Procedure Specification (WPS)

WeldOffice WPS

WPS record number	203	Revision 1	Qualified to	AWS D1.5
Date	4/24/2014		Company name	Casco Bay Steel Structures

JOINTS: Typical joint(s). See actual production drawings and engineering specifications for details.



	Amps	Volts	Travel Speed
AVG	604 /	29.5 /	17.1 IPM
MIN	544 /	27.4 /	14.5 IPM
MAX	644 /	31.6 /	19.7 IPM

BL2c-S

Over 1/2" to 1" (1/4 root face min)
Over 1" to 1-1/2" (3/8 root face min)
Over 1-1/2" to 2" (1/2 root face min)

*backside shall be backgouged prior to welding

Type of groove	Single-V-groove	Minimum groove angle	(deg.)	55 to 70
		Minimum root opening	(in.)	0 to 1/16
		Maximum root face	(in.)	varies

PREHEAT TABLE

Applicable standard	
AWS D1.5 Bridge Welding Code	For thickness 1/8 to 3/4(in.): 50°F). Preheat to 70(°F) if the base metal temperature is below 32(°F). Over 3/4 thru 1-1/2(in.): 70(°F). Over 1-1/2 thru 2-1/2(in.): 150(°F). Over 2-1/2(in.): 225(°F). Refer to AWS D1.5 2010 Table 4.3 (pg 85)
AWS D1.5 2010 FCM	For thickness 1/8 to 3/4(in.): 100°F). Over 3/4 thru 1-1/2(in.): 200(°F). Over 1-1/2 thru 2-1/2(in.): 300(°F). Over 2-1/2(in.): 350(°F). No welding to be done if ambient temperature in immediate area is below 0(°F)
New York SCM	Up to 3/4 ----------100 (F) Over 3/4 to 1-1/2 ----------200 (F) Over 1-1/2 to 2-1/2 --------300 (F) Over 2-1/2 ----------350 (F)

TECHNIQUE

Supplementary MF control	
Peening	
Surface preparation	Grind/Blast/chemical/wirebrush clean to be free of moisture, slag, millscale, oils, dust
Initial/interpass cleaning	Brushing and Grinding
Back gouging method	Grinding or Air Carbon Arc Gouging

NOTES

AWS FCM preheats are taken from AWS D1.5 2010 Clause 12 Table 12.4 and are based upon calculated heat input calculated in accordance with section 5.12 with an as welded H8 designation for the electrode combinationwe are using. This higher preheat will be used on non weathering steels also.

Signature 1

Name	Signature
Matthew Cote	
Date	
6/2/14	

Matthew J Cote
CWI 08051341
QC1 EXP. 5/1/2017

Signature 2

Name	Signature
Date	

Signature 3

Name	Signature
Date	

Signature 4

Name	Signature
Date	

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Casco Bay Steel Structures

One Wallace Avenue, South Portland ME 04106

AWS - Welding Procedure Specification (WPS)

WeldOffice WPS

WPS record number Date	250 6/10/2014	Revision	Qualified to Company name	AWS D1.5 Casco Bay Steel Structures
Supporting PQR(s) Reference docs.	SAW FCM 3/32 DC- 5/7/14			

Scope	Fillet, no PWHT (As-welded), impact testing
Joint	Joint details for this welding procedure specification in: JOINTS section of this WPS

BASE METALS

Type	Gr50/Gr50W	P-no.	Grp-no. -
Welded to	Gr50/Gr50W	P-no.	Grp-no. -
Backing:	Yes	P-no.	Grp-no.
Retainers Notes	All A709 with 50 ksi or less are also qualified		

THICKNESS RANGE QUALIFIED (in.)

	As-welded Min.	As-welded Max.	With PWHT Min.	With PWHT Max.
Complete pen.	-	-	-	-
Impact tested	0.625	no max.	-	-
Partial pen.	-	-	-	-
Fillet welds	no min.	no max.	-	-

DIAMETER RANGE QUALIFIED (in.)

	As-welded Min.	As-welded Max.	With PWHT Min.	With PWHT Max.
	N/A	N/A	-	-

FILLER METALS

THICKNESS RANGE QUALIFIED (in.)

	SFA	Classification	F-no.	A-no.	Chemical analysis or Trade name	As-welded Min.	As-welded Max.	With PWHT Min.	With PWHT Max.
SAW	5.23	ENi1K	6		LincolnElectric LA-75	0.125	no max.	-	-
Flux Sup. filler	5.23	F8A2			LIncolnElectric Lincolnweld960	- Required - - Required -			

Flux type	
Flux from recrush. slag	No
Suppl. filler metal vol. (ft³)	N/A

WELDING PROCEDURE

Welding process	SAW
Type	Machine
Minimum preheat/interpass temperature (°F)	See Back Page
Maximum interpass temperature (°F)	400
Filler metal size (in.)	3/32
Layer number	
Position	F,H
Current/polarity	DCEN (straight polarity)
Amperes	363.3
Volts	31.6
Travel speed (in./min)	12.8
Maximum heat input (kJ/in.)	53.8138
Wire feed type	Cold wire
Wire feed speed (in./min)	N/A
String or weave	Stringer
C.T.W.D (in.)	
Multi/Single pass per side	Single or Multiple passes
Multiple or single layer	Single or Multiple layer
Oscillation	None
Multi/single electrode	Single electrode
Electrode angle (deg.)	Varies
Maximum pass thickness (in.)	See Back Page
Weld deposit chemistry	F8A2-ENi1K-Ni1-H8
Notes	

APPROVED

By Jeff Clark at 9:40 am, Apr 23, 2015

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Casco Bay Steel Structures

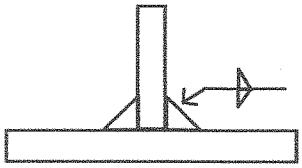
One Wallace Avenue, South Portland ME 04106

AWS - Welding Procedure Specification (WPS)

WeldOffice WPS

WPS record number	250	Revision	Qualified to	AWS D1.5
Date	6/10/2014		Company name	Casco Bay Steel Structures

JOINTS: Typical joint(s). See actual production drawings and engineering specifications for details.



3/8 single pass flat
5/16 single pass Horizontal

	Amps	Volts	Travel Speed
AVG	363.3	31.6	12.8
MIN	326.9	29.4	10.8
MAX	399.6	33.8	14.7

*** Multiple passes may be used if drawing details call for a larger size fillet weld than noted above in the position welding is being performed**

Type of groove	Fillet weld	Minimum groove angle	(deg.)	N/A
		Minimum root opening	(in.)	N/A
		Maximum root face	(in.)	N/A

PREHEAT TABLE

Applicable standard	
AWS D1.5 Bridge Welding Code	For thickness 1/8 to 3/4(in.): 50(°F). Preheat to 70(°F) if the base metal temperature is below 32(°F). Over 3/4 thru 1-1/2(in.): 70(°F). Over 1-1/2 thru 2-1/2(in.): 150(°F). Over 2-1/2(in.): 225(°F). Refer to AWS D1.5 2010 Table 4.3 (pg 85)
AWS D1.5 2010 FCM	For thickness 1/8 to 3/4(in.): 100°F). Over 3/4 thru 1-1/2(in.): 200(°F). Over 1-1/2 thru 2-1/2(in.): 300(°F). Over 2-1/2(in.): 350(°F). No welding to be done if ambient temperature in immediate area is below 0(°F)
New York SCM	Up to 3/4 ----------100 (F) Over 3/4 to 1-1/2 ----------200 (F) Over 1-1/2 to 2-1/2 --------300 (F) Over 2-1/2 ----------350 (F)

TECHNIQUE

Supplementary MF control	
Peening	Not used
Surface preparation	Grind/Blast/chemical/wirebrush clean to be free of moisture, slag, millscale, oils, dust
Initial/interpass cleaning	Brushing and Grinding
Back gouging method	None

NOTES

AWS FCM preheats are taken from AWS D1.5 2010 Clause 12 Table 12.4 and are based upon calculated heat input calculated in accordance with section 5.12 with an as welded H8 designation for the electrode combination we are using. This higher preheat will be used on non weathering steels also.

Signature 1		Signature 2	
Name	Signature	Name	Signature
Matthew Cote	Matthew J Cote CWI 08051341 QC1 EXP. 5/1/2017		
Date		Date	
6/10/14			

Signature 3		Signature 4	
Name	Signature	Name	Signature
Date		Date	

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Casco Bay Steel Structures

One Wallace Ave, South Portland ME 04106

AWS - Prequalified Welding Procedure Specification (pWPS)

WeldOffice WPS

Identification #	470 Rev.
Originated by	Matthew Cote
Date	7/21/2014
Authorized by	Matthew J Cote
Date	7/21/2014

Company name	Casco Bay Steel Structures
Welding process	SMAW
Process type	Manual

Joint design used

Joint type	T - T joint
Joint design	Fillet Weld
Backing	No
Backing material	Not Applicable
Root opening (R)* (in.)	
Root face (f)* (in.)	
Groove angle (a)* (deg.)	
Radius (J - U)* (deg.)	
Back gouging	No
Back gouging method	None

* Datum, As Detailed (As Fit-Up)

Base metals

Spec., type or grade	Gr 50
Thickness: Groove (in.)	
Fillet (in.)	1/8" and above
Diameter (Pipe) (in.)	Unlimited

Filler metals

AWS Specification	A5.1
AWS Classification	E-7018 H4R

Shielding

Flux	-
Electrode-flux (class)	-
Gas composition	-
Gas flow rate (cfh)	-
Gas cup size (in.)	-

Position

Welding position: Groove	
Fillet	All
Vertical progression	Up

Electrical characteristics

Transfer mode (GMAW)	N/A
Current type	Other
Other	DC+ and AC

Technique

Stringer or weave bead	Stringer or Weave
Multi/single pass (per side)	Single or Multiple
Number of electrodes	Varies
Spacing: Longitudinal (in.)	-
Lateral (in.)	-
Angle (deg.)	-
Contact tube to work (in.)	-
Peening	Not permitted
Interpass cleaning	Brushing or grinding

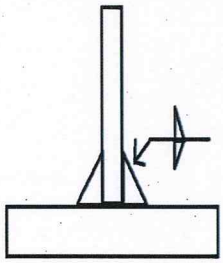
Preheat

Preheat temp.: Min. (°F)	See notes
Interpass temp.: Min. (°F)	See notes
Max. (°F)	450

Post weld heat treatment

Temperature (°F)	None
Time (hrs)	-

Welding procedure

Layer	Pass	Process	Filler metal class	Filler metal diameter (in.)	Current type / polarity	Amps	Wire feed speed (in./min)	Volts	Travel speed (in./min)	Joint details
1	All	SMAW	E-7018 H4R	1/8	DCEP	90-160	-	n/a	varies	
1	All	SMAW	E-7018 H4R	1/8	AC	100-160	-	n/a	varies	
1	All	SMAW	E-7018 H4R	5/32	DCEP	130-210	-	n/a	varies	
1	All	SMAW	E-7018 H4R	5/32	AC	140-210	-	n/a	varies	
1	All	SMAW	E-7018 H4R	3/16	DCEP	180-300	-	n/a	varies	
1	All	SMAW	E-7018 H4R	3/16	AC	200-300	-	n/a	varies	
								Designation		

Notes

LINCOLN ELECTRIC EXCALIBUR 7018 MR

TACKING ONLY ON GR50W MATERIAL

APPROVED

By Jeff Clark at 9:41 am, Apr 23, 2015

Signature 1

Name	Signature
Mathew J Cote	
Date	
7/21/14	

AWS Matthew J Cote CWI 08051341 QC1 EXP. 5/1/2017

Signature 2

Name	Signature
Date	

Signature 3

Name	Signature
Date	

Signature 4

Name	Signature
Date	

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Identification #	470	Rev.

AWS D1.5 2010

Single Pass Fillet weld in 1F position, No bigger than 3/8 in a single pass
Single Pass Fillet weld in 2F, 4F position, No bigger than 5/16 in a single pass
Single Pass Fillet weld in 3F position, No biger than 1/2 in a single pass

For thickness 1/8 to 3/4(in.): 50°F). Preheat to 70(°F) if the base metal temperature is below 32(°F).
Over 3/4 thru 1-1/2(in.): 70(°F).
Over 1-1/2 thru 2-1/2(in.): 150(°F).
Over 2-1/2(in.): 225(°F). Refer to AWS D1.5 2010 Table 4.3 (pg85)

FOR FRACTURE CRITICAL WELDS

For thickness 1/8 to 3/4(in.): 125°F).
Over 3/4 thru 1-1/2(in.): 200(°F).
Over 1-1/2 thru 2-1/2(in.): 300(°F).
Over 2-1/2(in.): 350(°F). No welding to be done if ambient temperature in immediate area is below 0(°F)

ALL VERTICAL WELDING SHALL BE DONE UPWARD

IF A GAP FROM 1/16 TO 3/16 IS EVIDENT, INCREASE WELD SIZE 1/16 FOR EACH 1/16 GAP

EX 1/16 GAP IS +1/16 FROM DETAILED SIZE
1/8 GAP IS +1/8 FROM DETAILED SIZE
3/16 GAP IS +3/16 FROM DETAILED SIZE

TACKING ONLY ON GR50W MATERIAL

Preheats to the NYSSCM

	Gr 50	Gr 50W
to 3/4	50F	100F
over 3/4 to 1-1/2	70F	200F
over 1-1/2 to 2-1/2	150F	300F
over 2-1/2	225	350F

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Casco Bay Steel Structures

One Wallace Ave, South Portland ME 04106

AWS - Prequalified Welding Procedure Specification (pWPS)

WeldOffice WPS

Identification #	480 Rev.
Originated by	Matthew Cote
Date	7/22/2014
Authorized by	Matthew J Cote
Date	7/22/2014

Company name	Casco Bay Steel Structures
Welding process	SMAW
Process type	Manual

Joint design used

Joint type	T - T joint
Joint design	Fillet Weld
Backing	No
Backing material	Not Applicable
Root opening (R)* (in.)	
Root face (f)* (in.)	
Groove angle (a)* (deg.)	
Radius (J - U)* (deg.)	
Back gouging	No
Back gouging method	None

* Datum, As Detailed (As Fit-Up)

Base metals

Spec., type or grade	Gr 50/ Gr50W
Thickness: Groove (in.)	
Fillet (in.)	1/8" and above
Diameter (Pipe) (in.)	

Filler metals

AWS Specification	A5.5
AWS Classification	E-8018 H4R

Shielding

Flux	-
Electrode-flux (class)	-
Gas composition	-
Gas flow rate (cfh)	-
Gas cup size (in.)	-

Position

Welding position: Groove	
Fillet	All
Vertical progression	Up

Electrical characteristics

Transfer mode (GMAW)	N/A
Current type	Other
Other	DC+ and AC

Technique

Stringer or weave bead	Stringer or Weave
Multi/single pass (per side)	Single or Multiple
Number of electrodes	Varies
Spacing: Longitudinal (in.)	-
Lateral (in.)	-
Angle (deg.)	-
Contact tube to work (in.)	-
Peening	Not permitted
Interpass cleaning	Brushing or grinding

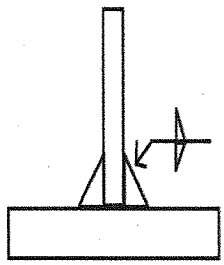
Preheat

Preheat temp.: Min. (°F)	See notes
Interpass temp.: Min. (°F)	See notes
Max. (°F)	450

Post weld heat treatment

Temperature (°F)	None
Time (hrs)	-

Welding procedure

Layer	Pass	Process	Filler metal class	Filler metal diameter (in.)	Current type / polarity	Amps	Wire feed speed (in./min)	Volts	Travel speed (in./min)	Joint details
1	All	SMAW	E-8018 H4R	1/8	DCEP	90-160	-	n/a	varies	
1	All	SMAW	E-8018 H4R	1/8	AC	100-160	-	n/a	varies	
1	All	SMAW	E-8018 H4R	5/32	DCEP	130-210	-	n/a	varies	
1	All	SMAW	E-8018 H4R	5/32	AC	140-210	-	n/a	varies	
1	All	SMAW	E-8018 H4R	3/16	DCEP	180-300	-	n/a	varies	
1	All	SMAW	E-8018 H4R	3/16	AC	200-300	-	n/a	varies	
								Designation		FILLET

Notes

LINCOLN ELECTRIC EXCALIBUR 8018-C3 MR

SEE BACKSIDE FOR MORE DETAILS

APPROVED

By Jeff Clark at 9:41 am, Apr 23, 2015

Signature 1

Name	Signature
Matthew J Cote	
Date	
7/22/2014	

Matthew J Cote
CWI 08051341
QC1 EXP 5/1/2017

Signature 2

Name	Signature
Date	

Signature 3

Name	Signature
Date	

Signature 4

Name	Signature
Date	

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Identification #	480	Rev.

AWS D1.5 2010

Single Pass Fillet weld in 1F position, No bigger than 3/8 in a single pass
Single Pass Fillet weld in 2F, 4F position, No bigger than 5/16 in a single pass
Single Pass Fillet weld in 3F position, No biger than 1/2 in a single pass

For thickness 1/8 to 3/4(in.): 50°F). Preheat to 70(°F) if the base metal temperature is below 32(°F).
Over 3/4 thru 1-1/2(in.): 70(°F).
Over 1-1/2 thru 2-1/2(in.): 150(°F).
Over 2-1/2(in.): 225(°F). Refer to AWS D1.5 2010 Table 4.3 (pg85)

FOR FRACTURE CRITICAL WELDS

For thickness 1/8 to 3/4(in.): 125°F).
Over 3/4 thru 1-1/2(in.): 200(°F).
Over 1-1/2 thru 2-1/2(in.): 300(°F).
Over 2-1/2(in.): 350(°F). No welding to be done if ambient temperature in immediate area is below 0(°F)

ALL VERTICAL WELDING SHALL BE DONE UPWARD

IF A GAP FROM 1/16 TO 3/16 IS EVIDENT, INCREASE WELD SIZE 1/16 FOR EACH 1/16 GAP

EX 1/16 GAP IS +1/16 FROM DETAILED SIZE
1/8 GAP IS +1/8 FROM DETAILED SIZE
3/16 GAP IS +3/16 FROM DETAILED SIZE

Preheats to the NYSSCM

	Gr 50	Gr 50W
to 3/4	50F	100F
over 3/4 to 1-1/2	70F	200F
over 1-1/2 to 2-1/2	150F	300F
over 2-1/2	225	350F

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Casco Bay Steel Structures, Inc.

WELDING PROCEDURE SPECIFICATION

Material specification: ASTM Gr. 50 + G-50W
Welding process: Gas Metal ARC Welding (GMAW)
Manual or machine: Semi Auto
Position of welding: Flat + Horizontal
Filler metal specification: AWS-A5.28 ESAB
Filler metal classification: E80C-Ni1
Flux: N/A
Shielding gas: 90% AR / 10% CO^2 Flow rate: 35 CFH +8/-4, Elec. Stickout 5/8
Single or multiple pass: Single + multiple
Single or multiple arc: Single
Welding current: DC
Polarity: DCEP
Welding progression: See Detail
Root treatment: Blast Clean-Wire Brush-Area To be Free of Slag-Rust-Moisture
Preheat and interpass temperature: See Table and as Required
Postheat temperature: As Required
Heat Input Min 24.4 KJ/in Max 38.3 KJ/in P.Q.R. 418-FCM=34.8 KJ/IN
* 35.0 KJ/in Min for single pass

Minimum Preheat and Interpass Temperature, °C [°F]

Welding Process (Base Metal)	To 20 mm [3/4 in] Incl.	Over 20 mm [3/4 in] to 40 mm [1-1/2 in] Incl.	Over 40 mm [1-1/2 in] to 65 mm [2-1/2 in] Incl	Over 65 mm [2-1/2 in]
		Thickness of Thickest Part at Point of Welding, mm [in]		
SAW; GMAW; FCAW; SMAW (M270M [M270] [A 709M (A 709)] 345 [50].	10 [50]	20 [70]	65 [150]	110 [225]
FCM Gr50	150°F	200°F	225°F	325°F
FCM Gr50W	150°F	250°F	325°F	350°F

Preheats to the NYSSCM

	Gr 50	Gr 50W
to 3/4	50F	100F
over 3/4 to 1-1/2	70F	200F
over 1-1/2 to 2-1/2	150F	300F
over 2-1/2	225	350F

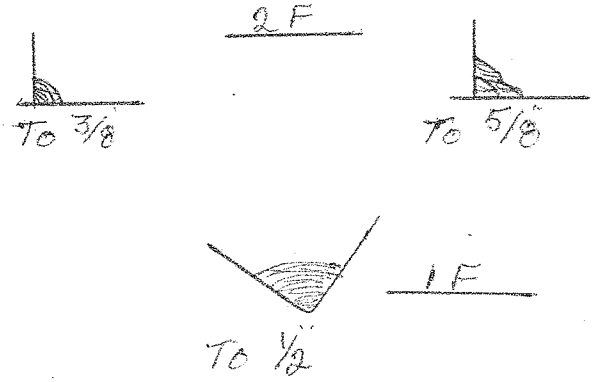
WELDING PROCEDURE

Max Interpass 440°F

Sec. 5.12.4.2

AWS D1.5 Joint detail Fillet

Pass no.	Electrode size	Welding current Amperes	Volts	Travel speed
AS REQ	.052	307	29.2	15.5
		338.7 To 276.3	31 To 27	17.5 To 13.5
* 1 Pass	.052	338.7 to 281.3	31 to 28.0	17.5 to 13.5



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. FCM 610
Revision no.

Contractor Casco Bay Steel
Authorized By Paul E. Goodale
Date 8-1-2013

APPROVED
By Jeff Clark at 9:41 am, Apr 23, 2015