

LB FOSTER CO Precise Structural Products
Welding Procedure Specification

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001 - FILLET WELD

Material Spec: <u>ASTM A709 G36, G60 & G50W</u> <u>AASHTO M270 G36, G60 & G50W</u>						
Welding Process(es) <u>SAW</u>						
Position of Welding <u>1F & 2F</u>						
Manual <input type="checkbox"/> Machine <input type="checkbox"/> Semi-Automatic <input type="checkbox"/> Automatic <input type="checkbox"/>						
Filler Metal Specification <u>AWS A5.23</u>						
Filler Metal Classification <u>F7A2-EN1K-Ni1-H8</u>						
Flux <u>LINCOLN 860</u>						
Shielding Gas <u>N/A</u> Gas Flow Rate <u>N/A</u>						
Single or Multiple Pass <u>BOTH</u>						
Single or Multiple Arc <u>SINGLE</u>						
Welding Current <u>REVERSE</u>						
Polarity: AC <input type="checkbox"/> DCEP <input checked="" type="checkbox"/> DCEN <input type="checkbox"/> Pulsed <input type="checkbox"/>						
Welding Progression Up <input type="checkbox"/> Down <input type="checkbox"/>						
Root Treatment <u>CLEAN AS TO REMOVE CONTAMINANTS</u>						
Preheat Temperature <u>*** SEE PAGE 2</u> Interpass Temperature <u>*** SEE PAGE 2</u>						
Postheat Treatment <u>N/A</u>						
Heat Input Min <u>48.55 KILOJOULES/IN</u> Max <u>76.29 KILOJOULES/IN</u>						
WELDING PROCEDURE						
Pass No.	Electrode Size	Amperes	Volts	Travel Speed	Other	Joint Detail
All	5/64	330-350	33-35	10-11		
<p>RECEIVED</p> <p>OK'D BY <u>VJK</u> OK'D BY <u>JWC</u></p> <p>DEC 1 2008</p> <p>BY <u>[Signature]</u> DATE <u>01/09/09</u></p>						
<p>This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.</p>						
<p>Procedure No. <u>001 - FILLET WELD</u> Contractor _____</p>						
<p>Revision No. <u>01</u> Authorized By <u>WALTER J. BORKOWSKI</u> Date <u>3/14/2008</u></p>						