

LB FOSTER CO Precise Structural Products
Welding Procedure Specification

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3476-01

Material Spec. ASTM A709 G36, G50 & G50W

Welding Process(es) SMAW

Position of Welding 1F, 2F, 3F, 4F

Manual Machine Semi-Automatic Automatic

Filler Metal Specification AWS A5.1

Filler Metal Classification E7018

Flux N/A

Shielding Gas N/A Gas Flow Rate N/A

Single or Multiple Pass Single

Single or Multiple Arc SINGLE

Welding Current REVERSE

Polarity: AC DCEP DCEN Pulsed

Welding Progression Up Down

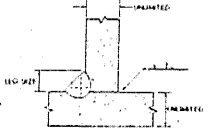
Root Treatment CLEAN AS TO REMOVE CONTAMINANTS

Preheat Temperature N/A Interpass Temperature N/A

Postheat Treatment N/A

Heat Input Min N/A Max N/A

WELDING PROCEDURE

Pass No.	Electrode Size	Amperes	Volts	Travel Speed	Other	Joint Detail
ALL	3/32	120-150				
ALL	1/8	140-180				
ALL	5/32	160-210				
ALL	3/16	180-250				

VITRANS
 REVISED
 OK'D BY: JWC
 DEC 1 2008
 APPROVED: ✓
 09/05/09

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure No. 1 TACK WELD Contractor _____

Revision No. _____ Authorized By WALTER J. BORKOWSKI Date 12/31/2008