

LB FOSTER CO Precise Structural Products
Welding Procedure Specification

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001 - FILLET WELD

Material Spec. ASTM A709 G36, G50 & G50W AASHTO M270 G36, G50 & G50W

Welding Process(es) SAW

Position of Welding 1F & 2F

Manual Machine Semi-Automatic Automatic

Filler Metal Specification AWS A5.23

Filler Metal Classification F7A2-EN1K-Ni1-H8

Flux LINCOLN 860

Shielding Gas N/A Gas Flow Rate N/A

Single or Multiple Pass BOTH

Single or Multiple Arc SINGLE

Welding Current REVERSE

Polarity: AC DCEP DCEN Pulsed

Welding Progression Up Down

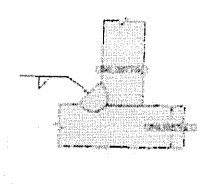
Root Treatment CLEAN AS TO REMOVE CONTAMINANTS

Preheat Temperature *** SEE PAGE 2 Interpass Temperature *** SEE PAGE 2

Postheat Treatment N/A

Heat Input Min 48.55 KILOJOULES/IN Max 76.28 KILOJOULES/IN

WELDING PROCEDURE

Pass No.	Electrode Size	Amperes	Volts	Travel Speed	Other	Joint Detail
All	5/64	330-350	33-35	10-11		

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