

LB FOSTER CO Precise Structural Products  
Welding Procedure Specification

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001 - FILLET WELD

Material Spec: ASTM A709 G36, G60 & G50W AASHTO M270 G36, G60 & 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-ENiK-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 76.29 KILOJOULES/IN

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

V. Trues  
 RECEIVED  
 SK'D BY \_\_\_\_\_ DT'D BY JWC  
 DEC 1 2008  
 BY \_\_\_\_\_ DATE 01/09/09

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

Procedure No. 001 - FILLET WELD Contractor \_\_\_\_\_

Revision No. 01 Authorized By WALTER J. BORKOWSKI Date 3/14/2008