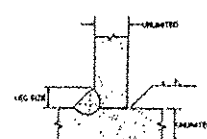


**LB FOSTER CO Precise Structural Products**  
**Welding Procedure Specification**

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 3590-01

Material Spec. <u>ASTM A709 G35, G50 &amp; G50W</u>		
Welding Process(es) <u>SMAW</u>		
Position of Welding <u>1F, 2F, 3F, 4F</u>		
Manual <input checked="" type="checkbox"/> Machine <input type="checkbox"/> Semi-Automatic <input type="checkbox"/> Automatic <input type="checkbox"/>		
Filler Metal Specification <u>AWS A5.1</u>		
Filler Metal Classification <u>E7018</u>		
Flux <u>N/A</u>		
Shielding Gas <u>N/A</u> Gas Flow Rate <u>N/A</u>		
Single or Multiple Pass <u>Single</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>N/A</u> Interpass Temperature <u>N/A</u>		
Postheat Treatment <u>N/A</u>		
Heat Input Min <u>N/A</u> Max <u>N/A</u>		
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	3/16 190-250	
CK'D BY _____ OK'D BY <u>JWC</u> OCT 13 2011 RESUBMIT _____ APPROVED <input checked="" type="checkbox"/> BY _____ DATE <u>10/14/11</u>		
This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.		
Procedure No. <u>1 TACK WELD</u> Contractor _____ Revision No. _____ Authorized By <u>WALTER J. BORKOWSKI</u> Date <u>10/13/1911</u>		