

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

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 3560-02

Material Spec: ASTM A709 G36, G50 & G60W AASHTO M270 G36, G50 & G60W

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

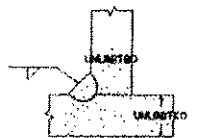
Welding Progression Up  Down

Root Treatment CLEAN AS TO REMOVE CONTAMINANTS

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

Postheat Treatment N/A

Heat Input Min 48.65 KILOJouLES/IN Max 76.29 KILOJouLES/IN

WELDING PROCEDURE						Joint Detail
Pass No.	Electrode Size	Amperes	Volts	Travel Speed	Other	
All	5/84	330-350	33-35	10-11		
<p>TRANS RECEIVED</p> <p>OK'D BY <u>JWC</u></p> <p>OCT 13 2011</p> <p>RESUBMIT APPROVED <input checked="" type="checkbox"/></p> <p>BY <u>[Signature]</u> DATE <u>10/13/11</u></p>						

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. \_\_\_\_\_ Authorized By WALTER J. BORKOWSKI Date 10/13/2011