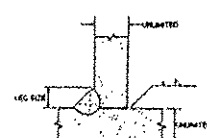


LB FOSTER CO Precise Structural Products
Welding Procedure Specification

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3590-01

Material Spec. <u>ASTM A709 G36, G50 & G50W</u>																															
Welding Process(es) <u>SMAW</u>																															
Position of Welding <u>1F, 2F, 3F, 4F</u>																															
Manual ☒ Machine ☐ Semi-Automatic ☐ Automatic ☐																															
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 ☐ DCEP ☒ DCEN ☐ Pulsed ☐																															
Welding Progression Up ☐ Down ☐																															
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																															
<table><tr><th>Pass No.</th><th>Electrode Size</th><th>Amperes</th><th>Volts</th><th>Travel Speed</th><th>Other</th></tr><tr><td>ALL</td><td>3/32</td><td>120-150</td><td></td><td></td><td></td></tr><tr><td>ALL</td><td>1/8</td><td>140-180</td><td></td><td></td><td></td></tr><tr><td>ALL</td><td>5/32</td><td>160-210</td><td></td><td></td><td></td></tr><tr><td>ALL</td><td>3/16</td><td>190-250</td><td></td><td></td><td></td></tr></table> OK'D BY _____ OK'D BY <u>JWC</u> OCT 13 2011 RESUBMIT _____ APPROVED ☒ BY _____ DATE <u>10/14/11</u>	Pass No.	Electrode Size	Amperes	Volts	Travel Speed	Other	ALL	3/32	120-150				ALL	1/8	140-180				ALL	5/32	160-210				ALL	3/16	190-250				
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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>10/13/11</u>																															