

LB FOSTER CO Precise Structural Products
Welding Procedure Specification

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3560-02

Material Spec: <u>ASTM A709 G36, G50 & G60W</u>		<u>AASHTO M270 G36, G50 & G60W</u>				
Welding Process(es) <u>SAW</u>						
Position of Welding <u>1F & 2F</u>						
Manual ☐ Machine ☐ Semi-Automatic ☒ Automatic ☐						
Filler Metal Specification <u>AWS A5.23</u>						
Filler Metal Classification <u>F7A2-ENi1K-Ni1-H8</u>						
Flux <u>LINCOLN 860</u>						
Shielding Gas <u>N/A</u>		Gas Flow Rate <u>N/A</u>				
Single or Multiple Pass <u>BOTH</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>*** SEE PAGE 2</u>		Interpass Temperature <u>*** SEE PAGE 2</u>				
Postheat Treatment <u>N/A</u>						
Heat Input Min <u>48.55 KILOJOULES/IN</u> Max <u>75.29 KILOJOULES/IN</u>						
WELDING PROCEDURE						
Pass No.	Electrode Size	Amperes	Volts	Travel Speed	Other	Joint Detail
All	5/64	330-350	33-35	10-11		
TRANS RECEIVED OK'D BY <u>JWC</u> OCT 13 2011 RESUBMIT <u>✓</u> APPROVED BY <u>DATE 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>001 - FILLET WELD</u> Contractor _____						
Revision No. _____ Authorized By <u>WALTER J. BORKOWSKI</u> Date <u>10/13/2011</u>						