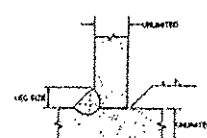


LB FOSTER CO Precise Structural Products
Welding Procedure Specification

Page 1 of 2
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	
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	
OK'D BY _____ OK'D BY <u>JWC</u>	
OCT 13 2011	
RESUBMIT _____ APPROVED <u>✓</u>	
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>	