

**L.B. Foster Co.**  
**Welding Procedure Specification**

Page 1 of 2

1F AL (AWS 56)

Material Spec. 6061-T6 or 6061-T6

Welding Process(es) GMAW CK'D VTrans Received OK'd BY JWC

Position of Welding Flat

Manual  Machine  Semi-Automatic  Automatic  **OCT 27 2011**

Filler Metal Specification AWS A5.10 Resubmit APPROVED

Filler Metal Classification ER5356 F22 BY DATE 11/2/11

Flux N/A

Shielding Gas 100% Argon Gas Flow Rate 35 CFH

Single or Multiple Pass Single

Single or Multiple Arc Single

Welding Current Direct Current

Polarity: AC  DCEP  DCEN  Pulsed

Welding Progression Up  Down

Root Treatment Wire Brush

Preheat Temperature 60 Deg. F min. Interpass Temperature N/A

Postheat Treatment None

Heat Input Min N/A Max N/A

**WELDING PROCEDURE**

Pass No.	Electrode Size	Amperes	Volts	Travel Speed	Other	Joint Detail
3/16"	0.035"	160	23	20 IPM		
1/4"	0.035"	160	23	20 IPM		
5/16"	0.035"	160	23	20 IPM		
3/8"	0.035"	160	23	20 IPM		
	Min.	128	20	18 IPM		
	Max.	192	26	22 IPM		

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure No. 1F AL (AWS 56) Contractor L. B. Foster Co.

Revision No. 0 Authorized By Timothy A. Miller Date 7/12/2011