

L.B. Foster Co.
Welding Procedure Specification

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2F AL (AWS 56)

Trans Received
 OK'D BY JWC

OCT 27 2011

Resubmit BY _____ APPROVED DATE 11/01/11

Material Spec. 6061-T6 or 6061-T6

Welding Process(es) GMAW

Position of Welding Horizontal

Manual Machine Semi-Automatic Automatic

Filler Metal Specification AWS A5.10

Filler Metal Classification ERS356 F22

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		


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 QC1 EXP. 6/1/2013

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

Procedure No. 2F AL (AWS 56) Contractor L. B. Foster Co.

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