

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

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1G AL 3/16 (BC-P2)

Material Spec. 6061-T6, 6063-T6

Welding Process(es) GMAW

Position of Welding 1G

Manual  Machine  Semi-Automatic  Automatic

Filler Metal Specification AWS A5.10

Filler Metal Classification ER5356 F22

Flux N/A

Shielding Gas 100% Argon Gas Flow Rate 35 CFH

Single or Multiple Pass Multiple

Single or Multiple Arc Single

Welding Current Direct Current Reverse Polarity

Polarity: AC  DCEP  DCEN  Pulsed

Welding Progression Up  Down

Root Treatment Clean With SS Wire Brush

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

Postheat Treatment None

Heat Input Min N/A Max N/A

VTrans  
 Received  
 OK'd BY JWC

CKD

OCT 27 2011

Resubmit BY \_\_\_\_\_ APPROVED DATE 11/01/11

**WELDING PROCEDURE**

Pass No.	Electrode Size	Amperes	Volts	Travel Speed	Other	Joint Detail
All	.035"	160	23	20 IPM		
	Min.	128	19.5	18.6 IPM		
	Max.	192	26.5	21.4 IPM		
						 Timothy A Miller CWM 01001121 OCT 15 EXP. 01/2013

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

Procedure No. 1G AL 3/16 (BC-P2) Contractor L.B. Foster Co.

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