L.B. FOSTER CO.
R.D.#2 BOX C
BEDFORD INDUSTRIAL PARK
BEDFORD, PA. 15522

130/ APPENDIX E

WELDING PROCEDURE SPECIFICATION (WPS) AL-103

Cleaning
Initial cleaning oxide: STAINLESS STEEL WIRE BRUSH
Initial cleaning oil and dirt: SAME
Interpass cleaning:

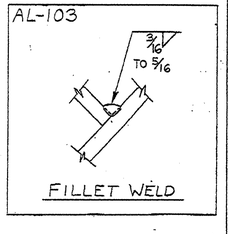
Post Weld Heat Treatment
Original temper: N/A
Final temper: N/A
Temperature: N/A
Time: N/A
Quench: N/A

Process(es)
Process: GMAW Type: SPRAY TRANSFER
Process: Type:
Electrode (GTAW):

Technique
Stringer or weave bead: STRINGER
Orifice or gas cup size: 5/8" DIAMETER
Oscillation: NO
Contact tube to work distance: 1/2"
Single pass or multipass: SINGLE OR MULTIPLE per side
Tungsten extension: N/A
Method of backgouging: N/A
Other:

WELD SIZE	Pass no.	Welding process	Amps	Volts	Travel speed
3/16	1	GMAW	160	23	25IPM
1/4	1	GMAW	180	24	19IPM
5/16	2	GMAW	175	24	21IPM

V.A.O.T.
RECEIVED
OK'D BY ____ OK'D BY JWC
NOV 01 2004
RESUBMIT ____ APPROVED ✓
BY ____ DATE 12-9-04



Sketch of welding sequence

Form E(a)

VERMONT AGENCY OF TRAN.
L.B. FOSTER JOB AR0170
PROJECT - Town of Royalton
PROJECT NO. AAC 0100(6) S Br. 21