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

**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

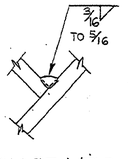
| WELD SIZE | Pass no. | Welding process | Amps | Volts | Travel speed |
|---|---|---|---|---|---|
| 3/16 | 1 | GMAW | 160 | 23 | 25 IPM |
| 1/4 | 1 | GMAW | 180 | 24 | 19 IPM |
| 5/16 | 2 | GMAW | 175 | 24 | 21 IPM |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |

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

V.A.O.T.
RECEIVED
OK'D BY _____ OK'D BY JWC
NOV 0 1 2004
RESUBMIT _____ APPROVED ✓
BY _____ DATE 12-9-04

**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: _____

AL-103




FILLET WELD

Sketch of welding sequence

Form E(a)

VERMONT AGENCY OF TRAN.
L.B. FOSTER JOB AR0170
PROJECT - Town of Royalton