

L.B. Foster Co.
Welding Procedure Specification

1F (AWS)

Material Spec. ASTM A709Gr.36, 50 & 50W, A588, A572, A992 Gr. 36, A36, A615M Gr.420

Welding Process(es) GMAW

Position of Welding Flat

Manual Machine Semi-Automatic Automatic

Filler Metal Specification AWS A5.18

Filler Metal Classification ER70S-3 (Lincoln L-50 Superarc)

Flux N/A

Shielding Gas 80% Argon 20% CarbonDioxide Gas Flow Rate 30 CFH

Single or Multiple Pass Single VTRANS

Single or Multiple Arc Single RECEIVED

Welding Current Direct Current OK'D BY JWC

Polarity: AC DCEP DCEN Pulsed JAN 26 2011

Welding Progression Up Down RESUBMIT _____ APPROVED

Root Treatment Wire Brush BY _____ DATE 01/31/11

Preheat Temperature See Notes Interpass Temperature _____

Postheat Treatment N/A

Heat Input Min _____ Max _____

WELDING PROCEDURE

Pass No.	Electrode Size	Amps	Volts	Travel Speed	Other	Joint Detail
3/16"	0.045"	270	28	9 IPM		
1/4"	0.045"	270	28	9 IPM		
5/16"	0.045"	270	28	9 IPM		
3/8"	0.045"	270	28	9 IPM		
Min.		243	24	8 IPM		
Max.		297	28	10 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 (AWS) Contractor L. B. Foster Co.

Revision No. _____ Authorized By Julian M. Pedrazzani Date 4/15/2009

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DECK PANELS