

L.B. Foster Co.

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2F AL (AWS 56)

WELDING PROCEDURE SPECIFICATION

Material Spec: 6061-T6 or 6061-T8
 Welding Process(es): MMAW
 Position of Welding: Horizontal
 Manual Machine Semi-Automatic Automatic
 Filler Metal Specification: AWS A5.10
 Filler Metal Classification: E5055 E52
 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 DCRP DCEN Pulse
 Welding Progression: Up Down
 Root Treatment: Wire Brush
 Preheat Temperature: 80 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.		123	20	18 IPM		
Max.		192	28	22 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. 2F AL (AWS 56) Contractor L. B. Foster Co.
 Revision No. 0 Authorized By Julian M. Pedrazzani Date 2/21/2005