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

WELDING PROCEDURE SPECIFICATION (WPS- AL-102)

Cleaning
Initial cleaning notes: STAINLESS STEEL WIRE BRUSH
Initial cleaning method and dirt: SAME
Interpass cleaning:

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

Process(es)
Process: GMAW Type: SEMI-AUTOMATIC
Process: Type:
Electrode (STAND):

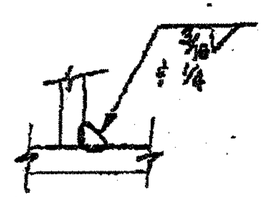
Technique
Stringer or weave bead: STRINGER
Orifice or gas cup size: 5/8" DIAMETER
Oscillation: NO
Contact tube to work distance: 1/2"
Single pass or multipass: SINGLE per side
Tungsten extension: N/A
Method of backgouging: N/A
Other:

Weld size	Pass no.	Welding process	Amps	Volts	Travel speed
3/16	1	GMAW	160	23	25 IPM
1/4	1	GMAW	180	24	19 IPM

AWS QC 1 ROBERT E. STACHEL INSPECTOR EWI

DATE: NOV 19 1997
APPROVED FOR:
PENNSYLVANIA DOT
BY: ROBERT W. HUNT CO

AL-102



FILLET WELD

Sketch of welding sequence

Form 8(a)

099 BR