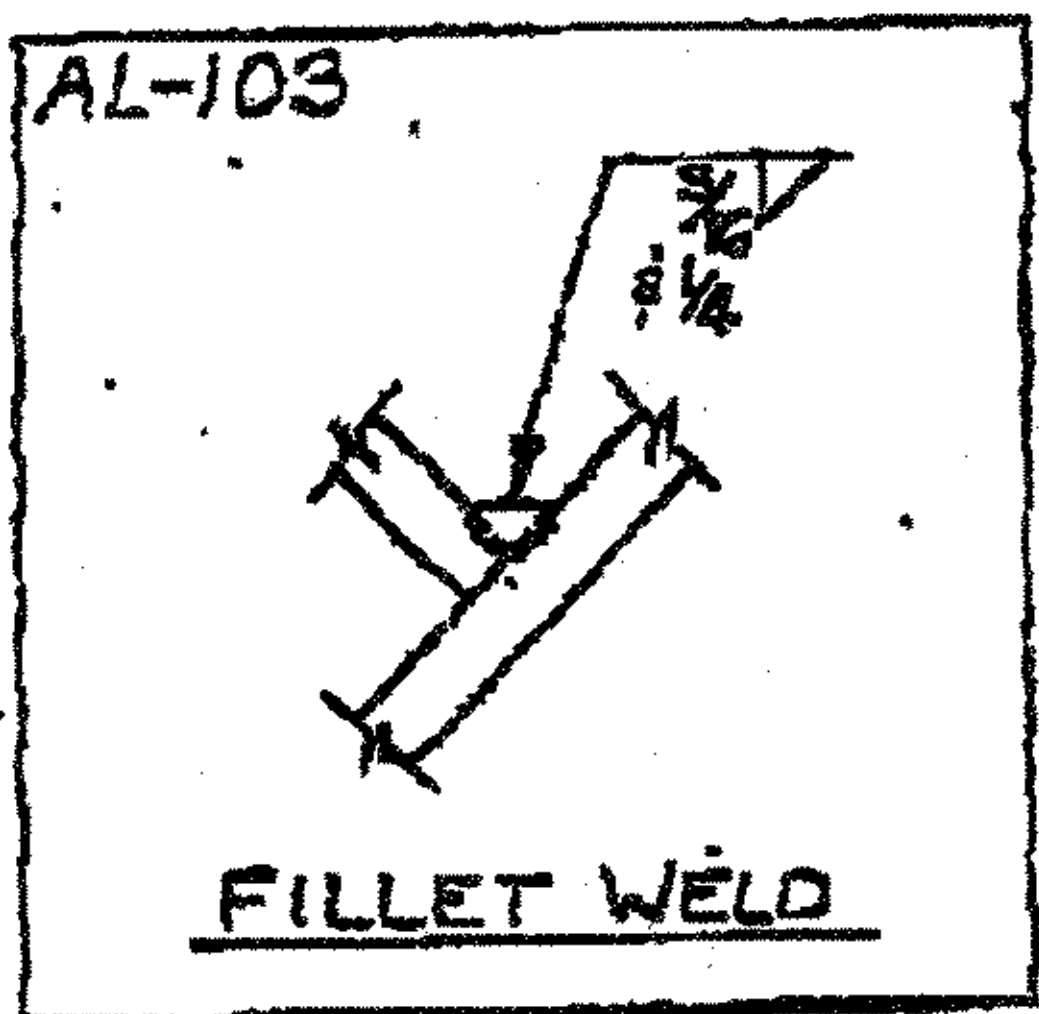


L.B. FOSTER CO.  
 R.D. #2 BOX C  
 BEDFORD INDUSTRIAL PARK  
 BEDFORD, PA. 15522

WELDING PROCEDURE SPECIFICATION (WPS AL-103)

| Flaming                       | STAINLESS STEEL | WELD SIZE | Pass | Welding process | Amperage | Voltage | Travel speed |
|-------------------------------|-----------------|-----------|------|-----------------|----------|---------|--------------|
| Initial cleaning notes        | WIRE BRUSH      | 3/16      | 1    | GMAW            | 160      | 29      | 25 IPM       |
| Initial cleaning oil and dirt | SAME            | 1/4       | 2    | GMAW            | 180      | 24      | 19 IPM       |
| Interpass cleaning            |                 |           |      |                 |          |         |              |
| Post-Yield Heat Treatment     |                 |           |      |                 |          |         |              |
| Original temper               | N/A             |           |      |                 |          |         |              |
| Final temper                  | N/A             |           |      |                 |          |         |              |
| Temperature                   | N/A             |           |      |                 |          |         |              |
| Time                          | N/A             |           |      |                 |          |         |              |
| Current                       | N/A             |           |      |                 |          |         |              |
| Process(es)                   |                 |           |      |                 |          |         |              |
| Process                       | GMAW            |           |      | SEMI-AUTOMATIC  |          |         |              |
| Process                       |                 |           |      |                 |          |         |              |
| Electrode (GTAW)              |                 |           |      |                 |          |         |              |
| Technology                    |                 |           |      |                 |          |         |              |
| Class of work used            | STRINGER        |           |      |                 |          |         |              |
| Class of gas cup size         | 3/8" DIAMETER   |           |      |                 |          |         |              |
| Condition                     | NO              |           |      |                 |          |         |              |
| Contact tube to work distance | 1/2"            |           |      |                 |          |         |              |
| Single pass or multipass      | SINGLE          |           |      |                 |          |         |              |
| Tongue or undercut            | N/A             |           |      |                 |          |         |              |
| Method of backgouging         | N/A             |           |      |                 |          |         |              |
| Other                         |                 |           |      |                 |          |         |              |

AWS  
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Sketch of welding sequence