

L.B. Foster Co.  
Welding Procedure Specification

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2F AL (AWS 56)

Material Spec: 6061-T6 or 6061-T8

Welding Process(es): GMAW

Position of Welding: Horizontal

Manual  Machine  Semi-Automatic  Automatic

Filler Metal Specification: AWS A5.10

Filler Metal Classification: ER5356 F22

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  DCEPR  DCEN  Pulsed

Welding Progression: Up  Down

Root Treatment: Wire Brush

Preheat Temperature: 60 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
1/16"	0.035"	160	23	20 IPM
1/8"	0.035"	160	23	20 IPM
5/16"	0.035"	160	23	20 IPM
3/8"	0.035"	160	23	20 IPM
Min.		120	20	18 IPM
Max.		192	26	22 IPM

Joint Detail

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CHK'D BY: [Signature] DATE: MAR 04 2010

APPROVED: [Signature]

This procedure may vary due to fabrication requirements, fit-up, parts size, etc., within the limitation of variables given in Section 5.

Procedure No: 2F AL (AWS 56) Contractor: L. B. Foster Co.  
Revision No: 1 Authorized By: Timothy A. Miller Date: 1/22/2010