

L. B. Foster Co.
Welding Procedure Specification

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IG AL (BC-P2)

Material Spec: <u>6061-T6, 6063-T6</u>						
Welding Process(es): <u>GMAW</u>						
Position of Welding: <u>1G</u>						
Manual <input type="checkbox"/>	Machine <input type="checkbox"/> Semi-Automatic <input checked="" type="checkbox"/> Automatic <input type="checkbox"/>					
Filler Metal Specification: <u>AWS A5.10</u>						
Filler Metal Classification: <u>ER5356</u>	<u>F22</u>					
Flux: <u>N/A</u>						
Shielding Gas: <u>100% Argon</u>	Gas Flow Rate: <u>35 CFH</u>					
Single or Multiple Pass: <u>Multiple</u>						
Single or Multiple Arc: <u>Single</u>						
Welding Current: <u>Direct Current Reverse Polarity</u>						
Polarity: AC <input type="checkbox"/> DCEP <input checked="" type="checkbox"/> DCEN <input type="checkbox"/> Pulsed <input type="checkbox"/>						
Welding Progression: <u>Up</u> <input type="checkbox"/> <u>Down</u> <input type="checkbox"/>						
Root Treatment: <u>Clean With SS Wire Brush</u>						
Preheat Temperature: <u>60 Deg. F min.</u>	Interpass Temperature: <u>N/A</u>					
Postheat Treatment: <u>None</u>						
Heat Input: Min <u>N/A</u>	Max <u>N/A</u>					
WELDING PROCEDURE						
Pass No.	Electrode Size	Amperes	Volts	Travel Speed	Other	Joint Detail
All	.035"	160	23	20 IPM		
Min.	128	19.5	18.6 IPM			
Max.	192	26.5	21.4 IPM			
<p>RECEIVED CR. BY <u>JWC</u> OK'D BY <u>JWC</u> MAR 04 2010 RESUBMIT APPROVED <u>[Signature]</u> BY DATE <u>3/11/10</u></p>						

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

Procedure No: IG AL (BC-P2) Contractor: L.B. Foster Co.
 Authorized By: Timothy A. Miller Date: 1/22/2010