

L. B. Foster Co
Welding Procedure Specification

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1F (AWS)

Material Spec	ASTM A709G-36, 50 & 50W, A588, A572	A992 Gr 36, A36				
Welding Process(es)	GMAW					
Position of Welding	Flat					
Manual <input type="checkbox"/>	Machine <input type="checkbox"/>	Semi-Automatic <input checked="" type="checkbox"/> Automatic <input type="checkbox"/>				
Filler Metal Specification	AWS A5.18					
Filler Metal Classification	E70T8-3	(Lincoln L-50 Superarc)				
Flux	N/A					
Shielding Gas	80% Argon 20% CarbonDioxide	Gas Flow Rate 30 CFH				
Single or Multiple Pass	Single					
Single or Multiple Arc	Single					
Welding Current	Direct Current	OK'D BY: [Signature] DATE: FEB 04 2009				
Polarity	AC <input type="checkbox"/> DCBP <input checked="" type="checkbox"/> DCEN <input type="checkbox"/> Pulsed <input type="checkbox"/>	APPROVED: [Signature] DATE: 02/11/09				
Welding Progression	Up <input type="checkbox"/> Down <input type="checkbox"/>	R				
Root Treatment	Wire Brush	BY: [Signature]				
Preheat Temperature	See Notes	Interpass Temperature				
Postheat Treatment	N/A					
Heat Input	Min	Max				
WELDING PROCEDURES						
Pass No	Electrode Size	Amperes	Volts	Travel Speed	Other	Joint Detail
3rd	0.045"	270	26	9 IPM		
1st	0.045"	270	26	9 IPM		
2nd	0.045"	270	26	9 IPM		
Min	0.045"	243	24	8 IPM		
Max	0.045"	297	28	10 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	1F (AWS)		Contractor L. B. Foster Co			
Revision No	1	Authorized By	Julien M. Pedrazzani	Date	12/30/2004	

TRANS
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