

L.B. Foster Co.
Welding Procedure Specification

Page 1 of 2
2F (AWS)

Material Spec ABTM A709 Gr. 36, 50 & 50W, A588, A572, A892 Gr. 36, A36

Welding Process(es) GMAW

Position of Welding Horizontal

Manual Machine Semi-Automatic Automatic

Filler Metal Specification AWS A5.18

Filler Metal Classification ER70S-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 JWC

Polarity AC DCEP DCEN Pulsed

Welding Progression Up Down R L APPROVED FEB 04 2009

Root Treatment Wire Brush BY JWC DATE 02/11/09

Preheat Temperature See Notes Interpass Temperature _____

Postheat Treatment N/A

Heat Input Min _____ Max _____

WELDING PROCEDURE

Pass No	Electrode Size	Amps	Volts	Travel Speed	Other	Joint Detail
3/16"	0.045"	270	26	9 IPM		
1/4"	0.045"	270	26	9 IPM		
Min	263	24	8 IPM			
Max	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 6

Procedure No 2F (AWS) Contractor L.B. Foster Co

Revised No 1 Authorized By Juliano M. Pedrazzani Date 12/20/2004

Per AWS D1.5