

**L. B. Foster Co.**  
Welding Procedure Specification

Material Spec. ASTM A709Gr.50 to A366 20 Ga.

Welding Process(es) GMAW

Position of Welding Horizontal

Manual  Machine  Semi-Automatic  Automatic

Filler Metal Specification ERT70-S3 Lincoln SuperArc L-50

Filler Metal Classification AWS 5.18

Flux N/A

Shielding Gas 80% Argon 20% CO2 (Dew Point<-65°F) Gas Flow Rate 30 CFH

Single or Multiple Pass Single

Single or Multiple Arc Single

Welding Current Direct Current

Polarity: AC  DCEP  DCEN  Pulsed

Welding Progression Up  Down

Root Treatment Wire Brush

Preheat Temperature 50 Deg. F Min. Interpass Temperature N/A

Postheat Treatment None

Heat Input Min \_\_\_\_\_ Max \_\_\_\_\_

**WELDING PROCEDURE**

Pass No.	Electrode Size	Amperes	Volts	Travel Speed	Other	Joint Detail
All	.045"	260	22	15 IPM		
	Max.	286	24	16 IPM		
	Min.	234	20	14 IPM		

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TRANS

OK'D BY JWC

FEB 18 2011

RESUBMIT \_\_\_\_\_ APPROVED

BY KMH DATE 2/24/11

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

Procedure No. 2F Pan Contractor L.B Foster Co. Date 2/23/2010  
 Revision No. 1 Authorized By Timothy A. Miller