

L.B. Foster Co.
Welding Procedure Specification

Material Spec. ASTM A709Gr.36, 50 & 50W, A599, A572, A992 Gr. 36, A36, A616M Gr.420

Welding Process(es) GMAW

Position of Welding Flat

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

Polarity: AC DCEP DCEN Pulsed

Welding Progression Up Down

Root Treatment Wire Brush

Preheat Temperature See Notes Interpass Temperature _____

Postheat Treatment N/A

Heat Input Min _____ Max _____

RESUBMIT _____ APPROVED
 BY KMH DATE 2/24/11

OK'D BY Jux **FEB 16 2011**

WELDING PROCEDURE

Pass No.	Electrode Size	Amps	Volts	Travel Speed	Other
3/16"	0.045"	270	28	9 IPM	
1/4"	0.045"	270	28	9 IPM	
5/16"	0.045"	270	28	9 IPM	
3/8"	0.045"	270	28	9 IPM	
Min.		243	24	8 IPM	
Max.		297	28	10 IPM	

Joint Detail

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. Date 4/15/2009

Revision No. _____ Authorized By Julian M. Pedrazzani