

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

Material Spec. ASTM A709Gr.36, 50 & 50W, A588, A572, A992 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

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 \_\_\_\_\_

RECEIVED

VIKANS

OK'D BY JWC

FEB 18 2011

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

BY KMH DATE 2/24/11

WELDING PROCEDURE				Joint Detail
Pass No.	Electrode Size	Amperes	Volts	
3/16"	0.045"	270	28	
1/4"	0.045"	270	28	
5/16"	0.045"	270	28	
3/8"	0.045"	270	28	
	Min.	243	24	
	Max.	297	28	

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 (AWS) Contractor L. B. Foster Co.

Revision No. \_\_\_\_\_ Authorized By Julian M. Pedrazzani Date 4/15/2009