



U.S. Department  
of Transportation  
**Federal Highway  
Administration**

# Memorandum

Subject: **INFORMATION:** Buy America - Non-domestic flux  
for welding of bridges and other structures

Date: JAN 31 2003

From: Dwight A. Horne *Dwight A. Horne*  
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Reply to  
Attn. of: HIPA-30

To: Peter J. Nicklas  
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Welding Consumable  
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Thank you for your January 3 letter to the Federal Highway Administration that inquired about the applicability of the Buy America requirements to non-domestic flux used in welding. We have reviewed the various welding process commonly used in Federal-aid highway construction projects; Gas Welding, Arc Welding, Shielded Metal Arc Welding, Gas-Tungsten Arc Welding, Gas-Metal Arc, Submerged Arc, and Resistance and hermite Welding.

In all the instances, the metallic or non-metallic flux is applied to the surface to be joined, acting on application of heat to prevent oxide formation and to facilitate the flow of solder. Some metallic fluxes are made of alloy materials and are basically used for the same purpose. Therefore, the use of metallic/non-metallic flux in welding process is not covered by the Buy America requirements of 23 CFR 635.410.

Please note that the welding rod, which is typically an iron/steel product is covered, and the welding process is a manufacturing process that must take place domestically.

