

# Highway Safety Corporation

Glastonbury, CT

## Welding Procedure Specification

Material specification A36, A709 GR 36

Welding process Gas Metal Arc Welding (GMAW) RECEIVED STR-7

Manual, semi-automatic, or automatic Semi-Automatic CK'D BY \_\_\_\_\_ OK'D BY \_\_\_\_\_

Position of welding Flat (1F) or Horizontal (2F) JUL 20 2006

Filler metal specification AWS A5.18

Filler metal classification ER70S-3 RESUBMIT \_\_\_\_\_ APPROVED \_\_\_\_\_

Electrode and manufacturer Lincoln Electric Lincoln Weld L-50 BY \_\_\_\_\_ DATE \_\_\_\_\_

Flux and manufacturer N/A

Shielding gas 85% Argon / 15% CO2 Flow rate 19-27 L / min

Single or multiple pass Single

Single or multiple arc Single

Welding current DCEP

Polarity Reverse - electrode positive

Welding progression Stringers

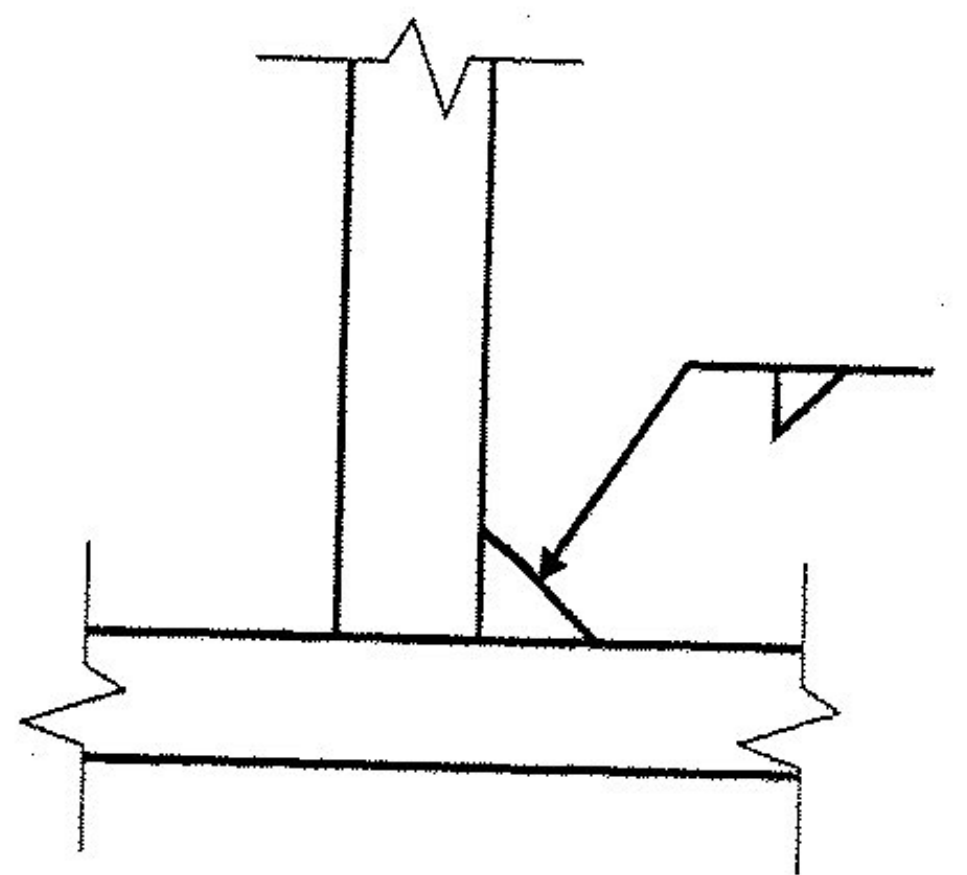
Root treatment None

Preheat and interpass temperature base metal up to 3/4" (50°F)

Postheat treatment None

Electrode extension 3/4" ± 1/4"

### WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
1/4"	1	.062"	350 A ± 30	28 V ± 2	12 ipm ± 2	<p>TYPICAL ALL FILLET WELDS</p> 

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the limitation of variables given in section 5 of latest edition AWS D1.5

WPS no. W-1561A

Revision no. 0

Supporting PQR no. pre-qualified

Project Name SOUTH BURLINGTON, VT

Fabricator Highway Safety Corporation

Authorized by Paul Radice

Date 7/13/06

Project Number IM 089-3 (37)

