

Highway Safety Corporation

Glastonbury, CT

Welding Procedure Specification

Material specification ASTM A36, A572 gr 50, A709 Gr 36, ASTM A709 Gr 50, A500 gr B

Welding process Gas Metal Arc Welding (GMAW)

Manual, semi-automatic, or automatic Semi-Automatic

Position of welding Horizontal (2F)

Filler metal specification AWS A5.18

Filler metal classification ER70S-3

Electrode and manufacturer Lincoln Electric Lincoln Weld L-50

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 DC

Polarity Reverse

Welding progression Stringers

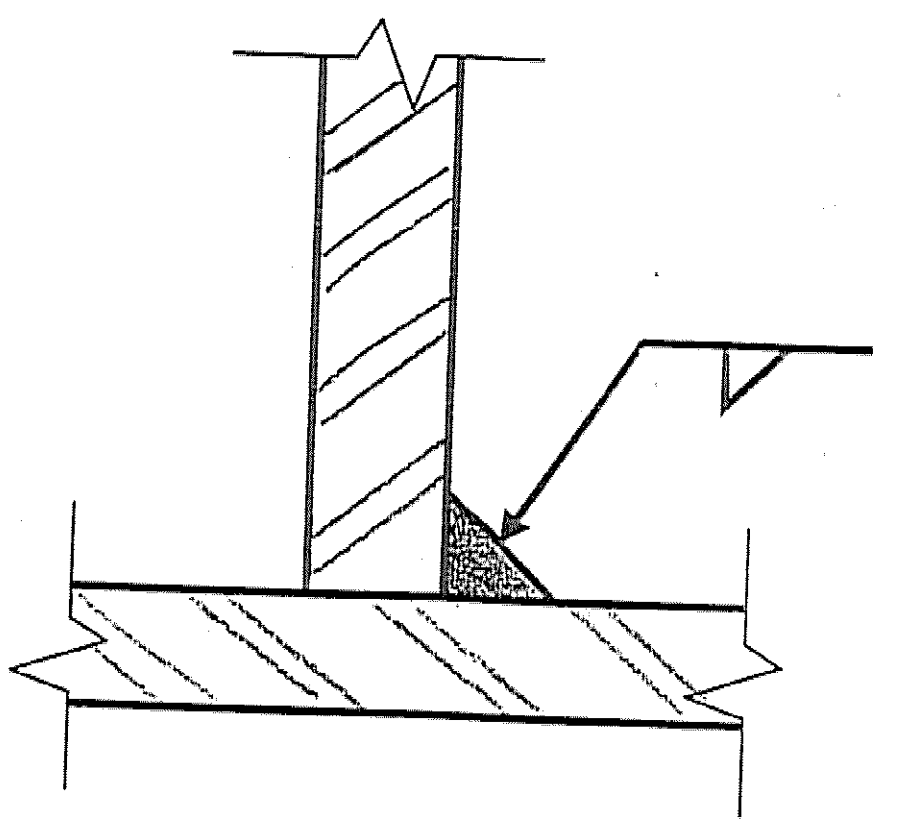
Root treatment None

Preheat and interpass temperature Base Metal up to 3/4" (50°F) ; over 3/4-1 1/2" (70°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		
3/16"	1	0.045"	300 A ± 30	29 V ± 2	28 ipm ± 2	<p>TYPICAL ALL FILLET WELDS</p> 
1/4"	1	0.045"	300 A ± 30	29 V ± 2	14 ipm ± 2	

VTR AWS

WFS

6/19/07

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 D1.1

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Project Name Ryegate, Vermont

Fabricator Highway Safety Corporation

Authorized by Paul Radice

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