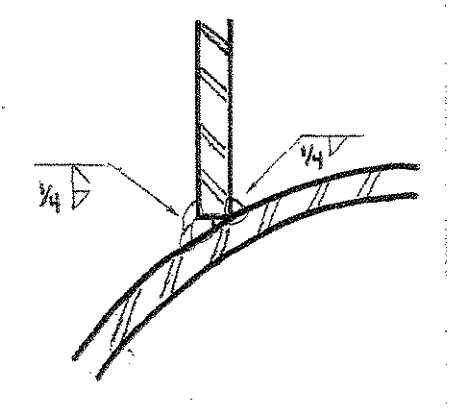


Highway Safety Corporation
Glastonbury, CT
Welding Procedure Specification

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
			Amps	Volts		
1/4"	1	0.045"	300 A ± 30	29 V ± 2	14 ipm ± 2	TYPICAL AT SUPPORT PLATE TO COLUMN POLE CONNECTION 
<p>RECEIVED</p> <p>CHK'D BY: _____ DATE: _____</p> <p>RESUBMIT APPROVED _____ DATE: _____</p>						

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the limitation of variables in section 5 of latest edition AWS D1.1.

WPS no. W-1587-3 Fabricator Highway Safety Corporation
Revision no. 0 Authorized by Paul Radice
Supporting POR no. Pre-qualified Date 8/29/07
Project Name St. Johnsbury, Lyndon, Waterford VT Project Number HES 091-3(42) & HES 093-1(10)

