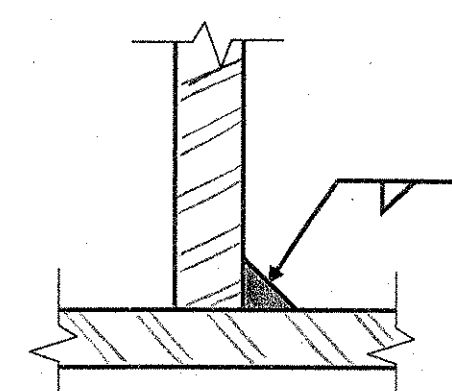


Highway Safety Corporation
Glastonbury, CT

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	TYPICAL ALL FILLET WELDS 
1/4"	1	0.045"	300 A ± 30	29 V ± 2	14 ipm ± 2	

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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