

# Highway Safety Corporation

Glastonbury, CT

## Welding Procedure Specification

Material specification	<u>A572 gr 50, A709 Gr 50</u>		
Welding process	<u>Gas Metal Arc Welding (GMAW) Spray Transfer</u>		
Manual, semi-automatic, or automatic	<u>Semi-Automatic</u>		
Position of welding	<u>Flat (1F) or Horizontal (2F)</u>		
Filler metal specification	<u>AWS A5.18</u>		
Filler metal classification	<u>ER70S-6</u>		
Electrode and manufacturer	<u>Lincoln Electric Lincoln Weld L-56</u>		
Flux and manufacturer	<u>N/A</u>		
Shielding gas	<u>86% Argon / 14% CO2</u>	Flow rate	<u>39 - 45 CFH</u>
Single or multiple pass	<u>Single or Multiple</u>		
Single or multiple arc	<u>Single</u>		
Welding current	<u>DCEP</u>		
Polarity	<u>Reverse - electrode positive</u>		
Welding progression	<u>Stringers</u>		
Root treatment	<u>clean base metal</u>		
Preheat and interpass temperature	<u>base metal up to 3/4" (50°F) ; over 3/4 thru 1-1/2" ( 150°F ) ; over 1-1/2" thru 2-1/2" (225°F)</u>		
Postweld heat treatment	<u>None</u>		
Electrode extension	<u>3/4" ± 1/4"</u>		

**SHOP DRAWING REVIEW**

REVIEWED AS REQUIRED BY THE CONSTRUCTION CONTRACT DOCUMENTS AND APPROVED FOR CONFORMANCE TO THE DESIGN CONCEPT OF THE WORK, AND SUBJECT TO FURTHER LIMITATIONS AND REQUIREMENTS CONTAINED IN THE CONSTRUCTION CONTRACT DOCUMENTS.  
 REJECTED     REUSE AND RESUBMIT     APPROVED AS NOTED

CORRECTIONS OR COMMENTS MADE ON THE SHOP DRAWINGS DURING THIS REVIEW DO NOT RELIEVE THE CONTRACTOR OF ANY OBLIGATIONS OR REQUIREMENTS OF THE DRAWINGS AND SPECIFICATIONS. THIS CHECK IS ONLY FOR REVIEW OF GENERAL CONFORMANCE WITH THE DESIGN CONCEPT OF THE PROJECT AND GENERAL COMPLIANCE WITH THE INFORMATION GIVEN IN THE CONTRACT DOCUMENTS. THE CONTRACTOR IS RESPONSIBLE FOR CONFIRMING AND CORRECTING ALL DIMENSIONS AND DIMENSIONS, FOLLOWING ALL DESIGN PROCESSES AND TECHNIQUES OF CONSTRUCTION; COORDINATING THEIR WORK WITH THAT OF ALL OTHER TRADES; AND PERFORMING THEIR WORK IN A SAFE AND SATISFACTORY MANNER.

C.D. Case, P.E., Engineer 540 Commercial Street Manchester, NH 03111 603-686-8222	Job Number: <u>1511223</u> Reviewed by: <u>SRB</u> Date: <u>04/29/2016</u>
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ON: April 28, 2016

and Checked for CONFORMANCE

BY: Jennifer Fitch    DATE: 05/02/16

### WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
5/16"	1	0.062"	300 A ± 30	29 V ± 2	15 ipm ± 2	
7/16"	1 & 2	0.062"	↓	↓	15 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 D1.5

WPS no. <u>W-VTPEDPOST1</u> Revision no. <u>0</u> Supporting PQR no. <u>W-AWSD1511 (06-22-11)</u> Project Name <u>Irasburg, VT</u>	Fabricator <u>Highway Safety Corporation</u> Prepared By: <u>Paul Radice</u> Date <u>04-28-16</u> Project Number <u>IM DECK (46)</u>
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