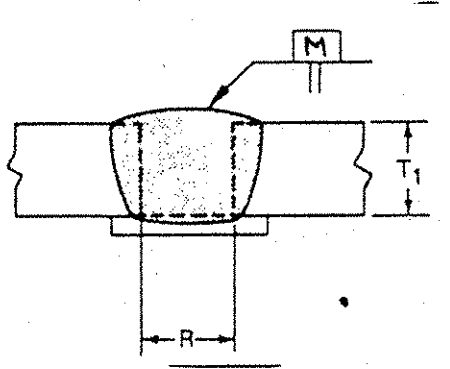


Highway Safety Corporation

Welding Procedure Specification

Material specification ASTM A500 Gr B
 Welding process SHIELDED METAL ARC WELDING (SMAW)
 Manual, semi-automatic, or automatic MANUAL
 Position of welding FLAT (1G)
 Filler metal specification AWS A5.1
 Filler metal classification E7018
 Electrode and manufacturer LINCOLN ELECTRIC JET LH 78 MR
 Flux and manufacturer N/A
 Shielding gas N/A Flow rate N/A
 Single or multiple pass MULTIPLE
 Single or multiple arc SINGLE
 Welding current AC
 Polarity N/A
 Welding progression STRINGERS
 Root treatment NONE
 Preheat and interpass temperature 50°F min.
 Postheat treatment NONE
 Electrode extension N/A

WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters Amperes Volts	Travel speed	Joint detail
	ALL	5/32"	150A to 220A	VARIES	B-Lia 
CR'D BY		V.A.P.T. RECEIVED			
BY GPK		DATE 02-16-01			
REQUISIT		APPROVED			
BY GPK		DATE 02-16-01			

R = T₁
T₁ = 1/4" max.

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the limitation of variables given in section 5 of AWS D1.5-95.

WPS no. W-1246A Fabricator Highway Safety Corporation
 Revision no. 0 Authorized by PAUL RADICE
 Supporting PQR no. PRE-QUALIFIED Date 2/1/01
 Project Name HARTFORD, SHARON Project Number IM IR 089-1(8)

