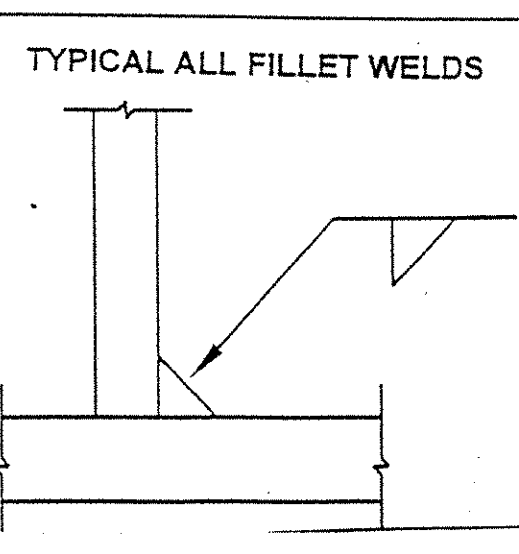


Highway Safety Corporation

Welding Procedure Specification

Material specification ASTM A709 Gr 36, ASTM A709 Gr 50
 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 ER 70S-3
 Electrode and manufacturer LINCOLN ELECTRIC LINCOLNWELD L-50
 Flux and manufacturer N/A
 Shielding gas 85% ARGON 15% CO₂ Flow rate 19-27 4/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		
1/8"	1	0.045"	300A ±30	29V ±2	28 ipm ±2	 <p>TYPICAL ALL FILLET WELDS</p>
3/16"	1	0.045"	300A ±30	29V ±2	25 ipm ±2	

OK'D BY: [Signature] DATE: FEB 13 2001

RESUBMIT: [Signature] APPROVED: [Signature]

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. N-1246 B Fabricator Highway Safety Corporation
 Revision no. 0 Authorized by PAUL RADICE
 Supporting PQR no. MJC # 60918002 Date 2/1/01
 Project Name HARTFORD SHARON Project Number IM IR 089-1 (8)

