

Highway Safety Corporation
Welding Procedure Specification

Material specification ASTM A109 GR 50, A109 GR 36, A572 GR 50, A36
 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 LINCOLNWELD L-50
 Flux and manufacturer N/A
 Shielding gas 85% ARGON 15% CO₂ Flow rate 40 CFH TO 56 CFH
 Single or multiple pass MULTIPLE
 Single or multiple arc SINGLE
 Welding current DC
 Polarity REVERSE
 Welding progression STRINGERS
 Root treatment NONE
 Preheat and interpass temperature 50°F min (1/4" TO 3/4") 70°F min (3/4" TO 1 1/2")
 Postheat treatment NONE
 Electrode extension 3/4 INCH

WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
5/16"	1	1/16"	275A ± 25	25A ± 2	9-15 IPM	
7/16"	1 & 2	1/16"	275A ± 2	25A ± 2	9-15 IPM	

V.A.O.T. RECEIVED
 CK'D BY: _____ OK'D BY: JWC
 JAN 30 2001
 RESUBMIT APPROVED ✓
 BY: GSR DATE 02-01-01

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-NTG-151 Fabricator Highway Safety Corporation
 Revision no. NEW Authorized by PAUL RADICE
 Supporting POR no. MJC #60918002 Date 1/23/01
 Project Name THREND SHIELD, BOYNTON Project Number 1M 1R 089-1(8)

