

**Highway Safety Corporation**  
Glastonbury, CT

**Welding Procedure Specification**

Material specification A572 gr 50, A709 Gr 50 V.A.O.T.  
RECEIVED

Welding process Gas Metal Arc Welding (GMAW)

Manual, semi-automatic, or automatic Semi-Automatic OK'D BY JWC

Position of welding Flat (1F) or Horizontal (2F) DATE 1 JAN 04 2005

Filler metal specification AWS A5.18 RESUBMIT ✓ APPROVED ✓

Filler metal classification ER70S-3

Electrode and manufacturer Lincoln Electric Lincoln Weld L-50 BY                      DATE 01-19-05

Flux and manufacturer N/A

Shielding gas 85% Argon / 15% CO2 Flow rate 19-27 L / min

Single or multiple pass Single or Multiple

Single or multiple arc Single or Multiple

Welding current DCEP

Polarity Reverse - electrode positive

Welding progression Stringers

Root treatment None

Preheat and interpass temperature 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)

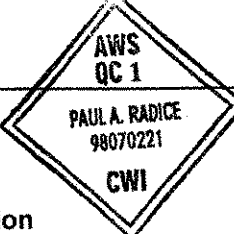
Postheat treatment None

Electrode extension 3/4" ± 1/4"

**WELDING PROCEDURE**

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
8mm	1	2 mm	275 A ± 25	25 V ± 2	200-250 mm / min	
5/16"	1	0.062"	↓	↓	8-10 ipm	
11 mm	1 & 2	2 mm	↓	↓	200-250 mm / min	
7/16"	1 & 2	0.062"	↓	↓	8-10 ipm	

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. W-1479-A Fabricator Highway Safety Corporation

Revision no. 0 Authorized by Paul Radice

Supporting PQR no. Pre-Qualified Date 12/30/04

Project Name Bolton, VT Project Number IM-089-2(29)

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