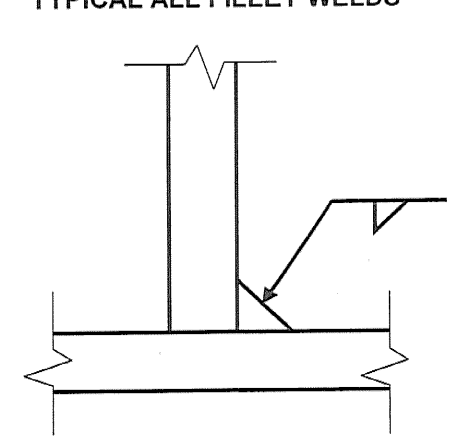


Highway Safety Corporation
Glastonbury, CT

Welding Procedure Specification

Material specification ASTM A36, A709 Gr 36, A500 gr B, A53 gr B
 Welding process Gas Metal Arc Welding (GMAW)
 Manual, semi-automatic, or automatic Semi-Automatic
 Position of welding Flat (1F) or Horizontal (2F)
 Filler metal specification AWS A5.18
 Filler metal classification ER70S-3
 Electrode and manufacturer Lincoln Electric Lincoln Weld L-60
 Flux and manufacturer N/A
 Shielding gas 85% Argon / 15% CO2 Flow rate 19-27 L / min
 Single or multiple pass Single
 Single or multiple arc Single
 Welding current DCEP
 Polarity Reverse - electrode positive
 Welding progression Stringers
 Root treatment clean base metal
 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
1/8"	1	0.045"	300 A ± 30	29 V ± 2	28 ipm ± 2	 <p>TYPICAL ALL FILLET WELDS</p>
3/16"	1	0.045"	300 A ± 30	29 V ± 2	14 ipm ± 2	

C'D BY: RAWS
 R E C E I V E D
 FEB 03 2008
 APPROVED: JW
 DATE: 01/13/09

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 D1.1 / D1.5

WPS no. W-1684-B Fabricator Highway Safety Corporation
 Revision no. 0 Authorized by Paul Radice
 Supporting PQR no. Pre-Qualified Date 2/3/09
 Project Name Canaan, VT rt 102 Project Number ER ST 0271(10)