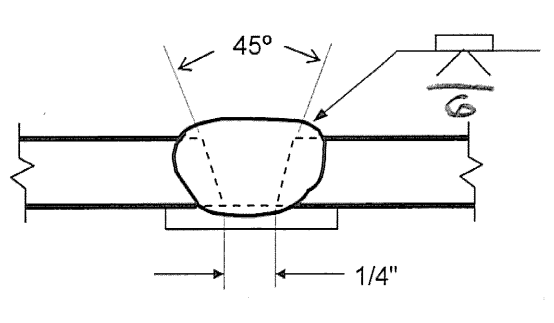


**Highway Safety Corporation**  
Glastonbury, CT

**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 ER7018  
 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 clean base metal  
 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"	150 A to 220 A	VARIES	B-U2a 

TRANS RECEIVED  
 CHECKED BY: Juc  
 FEB 03 2009  
 APPROVED: AS  
 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

WPS no. W-1684-C 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)