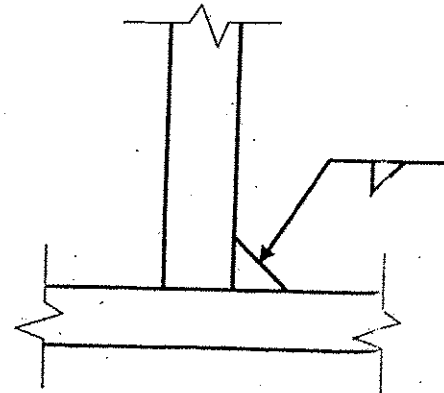


Electrode and manufacturer Lincoln Electric Lincoln Weld L-50 **G.P.I.**
 Flux and manufacturer N/A
 Shielding gas 85% Argon / 15% CO2 Flow rate 19-27 L / min
 Single or multiple pass Single
 Single or multiple arc Single
 Welding current DCEP
 Polarity Reverse - electrode positive
 Welding progression Stringers
 Root treatment clean base metal
 Preheat and interpass temperature Base Metal up to 3/4" (50°F) ; over 3/4-1 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	300 A ± 30	29 V ± 2	28 ipm ± 2	TYPICAL ALL FILLET WELDS 
3/16"	1	0.045	300 A ± 30	29 V ± 2	14 ipm ± 2	

VT TRANS RECEIVED
 OK'D BY _____ OK'D BY JWC
 FEB 23 2008
 RESUBMIT _____ APPROVED
 BY _____ DATE 3/4/08

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

WFS no. W-1615B
 Revision no. 0
 Supporting PQR no. Pre-qualified
 Project Name Bennington, VT

Fabricator Highway Safety Corporation
 Authorized by Paul Radice
 Date 2/5/08
 Project Number AC NH 019-1(53)

