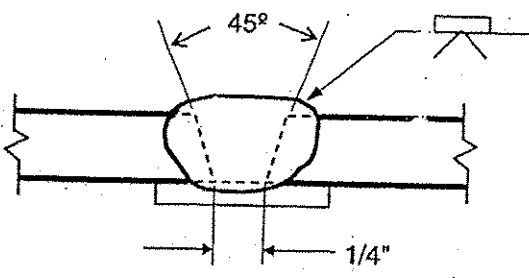


Electrode and manufacturer Lincoln Electric Jet LH 78 MR
 Flux and manufacturer N/A
 Shielding gas N/A Flow rate N/A
 Single or multiple pass Multiple
 Single or multiple arc Single
 Welding current AC
 Polarity N/A APR 09 2008
 Welding progression Stringers G.P.I.
 Root treatment None
 Preheat and interpass temperature 50°F (min)
 Postheat treatment None
 Electrode extension N/A

RECEIVED

WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
	ALL	5/32"	150 A to 220 A		VARIES	B-U2a 
	OK'D BY	OK'D BY				
	RESUBMIT	APPROVED				
	DATE	DATE				

VT TRANS RECEIVED
 OK'D BY JWC
 FEB 26 2008
 APPROVED
 DATE 3/21/08

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the limitation of variables given section 5 of latest edition AWS D1.1

WPS no. W-1615D
 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)

PAUL RADICE
 CWI 98070221
 OCT 98070221
 EXP. 7/01/10