

Electrode and manufacturer Lincoln Electric Lincoln Weld L-50
 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
 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"

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G.P.I.

WELDING PROCEDURE

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

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 CK'D BY _____ CK'D BY JWC
 FEB 26 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 D1.5

WPS no. W-1615A
 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)

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 EXP. 7/01/10