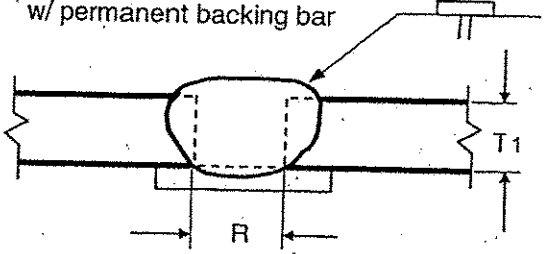


Electrode and manufacturer Lincoln Electric Jet LH 78 MR APR 09 2008
 Flux and manufacturer N/A
 Shielding gas N/A Flow rate N/A **G.P.I.**
 Single or multiple pass Multiple
 Single or multiple arc Single
 Welding current AC
 Polarity N/A
 Welding progression Stringers
 Root treatment clean base metal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


WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
	ALL	5/32"	150 A to 220 A		VARIES	<p>B-L1a full penetration weld joint w/ permanent backing bar</p>  <p>T 1 = 1/4" (max) R = T 1</p>
<p>VT TRANS RECEIVED</p> <p>GR'D BY _____ OK'D BY <u>JWC</u></p> <p>FEB 26 2008</p> <p>RESUBMIT _____ APPROVED <u>✓</u></p> <p>BY _____ DATE <u>3/4/08</u></p>						

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-1615C
 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
 02/05/08
 10:11 AM