

Note: Not Reviewed by MJ

Highway Safety Corporation

Glastonbury, CT

Welding Procedure Specification

Material specification A572 gr 50, A709 Gr 50
 Welding process Gas Metal Arc Welding (GMAW) Spray Transfer
 Manual, semi-automatic, or automatic Semi-Automatic
 Position of welding Flat (1F) or Horizontal (2F)
 Filler metal specification AWS A5.18
 Filler metal classification ER70S-6
 Electrode and manufacturer Lincoln Electric Lincoln Weld L-56
 Flux and manufacturer N/A
 Shielding gas 86% Argon / 14% CO2 Flow rate 35-45 CFM
 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"

WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
5/16"	1	0.062"	300 A ± 30	29 V ± 2	15 ipm ± 2	
7/16"	1 & 2	0.062"	↓	↓	15 ipm ± 2	
<p>Vermont Agency of Transportation RECEIVED CK'D BY -- OK'D BY D. Bonneau January 4, 2013 RESUBMIT No Approved BY Douglas Bonneau DATE 01/08/13</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 D1.5

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Project Name Morristown, VT

Fabricator Highway Safety Corporation Paul A Radice

Prepared By: Paul Radice

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