

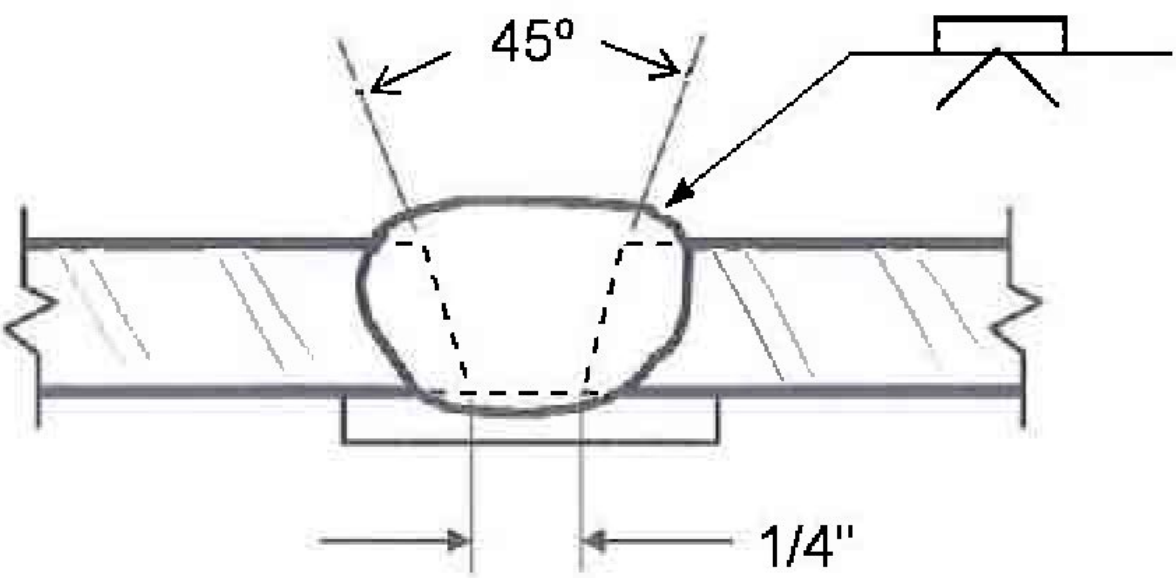
Highway Safety Corporation

Glastonbury, CT

Welding Procedure Specification

Material specification ASTM A500 gr B
 Welding process Gas Metal Arc Welding (GMAW)
 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
 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)
 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	0.063"	300 A ± 30	29 V ± 2	15 ipm ± 2	B-U2a-GF 

Vermont Agency of Transportation
RECEIVED
 CK'D BY _____ OK'D BY JWC
 December 6, 2013
 RESUBMIT NO Approved
 BY JTS DATE 12-20-2013

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-VGWBCK Fabricator Highway Safety Corporation
 Revision no. 0 Prepared By: Paul Radice
 Supporting PQR no. Pre-Qualified Date 12/5/13
 Project Name Barnard, Vermont Project Number ER BRF 0241 (39)

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