

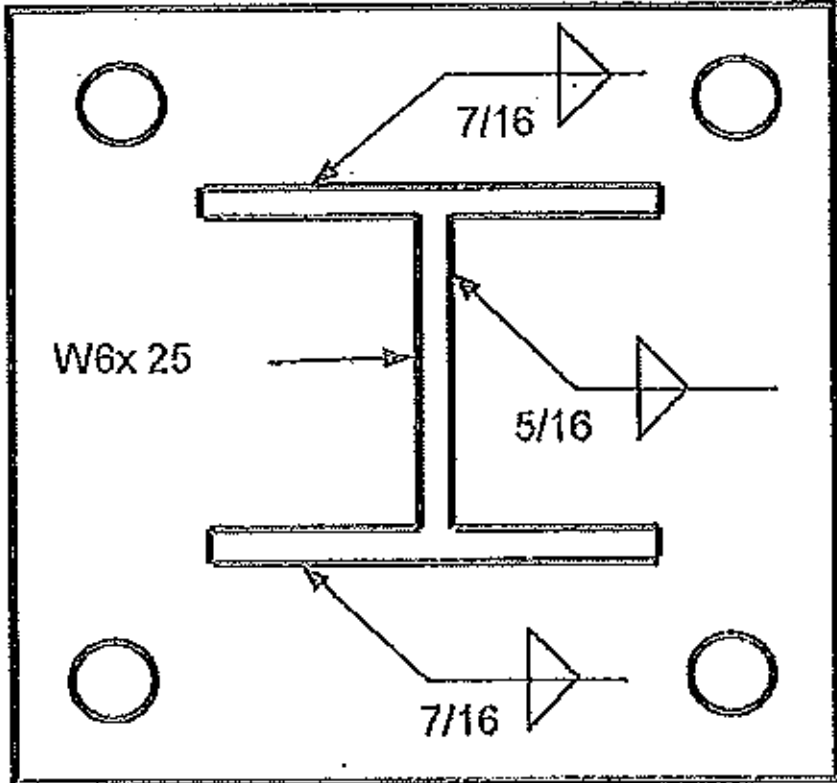
# Highway Safety Corporation

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  | <div>Joint detail</div>  |
|----------------------------------------------------------------------------------------------------------------------------------|----------|----------------|--------------------|-------------|---------------|--------------------------------------------------------------------------------------------------------------|
|                                                                                                                                  |          |                | Amperes            | Volts       |               |                                                                                                              |
| 5/16"                                                                                                                            | 1        | 0.062"         | 300 A<br>± 30      | 29 V<br>± 2 | 15 ipm<br>± 2 |                                                                                                              |
| 7/16"                                                                                                                            | 1 & 2    | 0.062"         | ↓                  | ↓           | 15 ipm<br>± 2 |                                                                                                              |
| <div>Trans Received JUN 27 2012</div> <div>CK'D BY JWC</div> <div>Resubmit BY</div> <div>APPROVED DATE 7/2/12</div> <div>✓</div> |          |                |                    |             |               |                                                                                                              |

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-VTPEDPOST1  
Revision no. 0  
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Project Name Woodford, VT

Fabricator Highway Safety Corporation  
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