

Highway Safety Corporation

Glastonbury, CT

Welding Procedure Specification

Material specification <u>A572 gr 50, A709 Gr 50</u>	Vermont Agency of Transportation
Welding process <u>Gas Metal Arc Welding (GMAW) Spray Transfer</u>	RECEIVED
Manual, semi-automatic, or automatic <u>Semi-Automatic</u>	CK'D BY <u>RSF</u> OK'D BY <u>CLB</u>
Position of welding <u>Flat (1F) or Horizontal (2F)</u>	April 13, 2018
Filler metal specification <u>AWS A5.18</u>	RESUBMIT <u>NO</u> Approved
Filler metal classification <u>ER70S-6</u>	BY <u>C. CARLSON</u> DATE <u>04/27/18</u>
Electrode and manufacturer <u>Lincoln Electric Lincoln Weld L-56</u>	
Flux and manufacturer <u>N/A</u>	
Shielding gas <u>86% Argon / 14% CO2</u> Flow rate <u>38 - 46 CFH</u>	
Single or multiple pass <u>Single or Multiple</u>	
Single or multiple arc <u>Single</u>	
Welding current <u>DCEP</u>	
Polarity <u>Reverse - electrode positive</u>	
Welding progression <u>Stringers</u>	
Root treatment <u>clean base metal</u>	
Preheat and interpass temperature <u>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)</u>	
Postweld heat treatment <u>None</u>	
Electrode extension <u>3/4" ± 1/4"</u>	

WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
5/16"	1	1/16"	290 A to 330 A	29 V	16 - 18 ipm	
1/2"	1 & 2	1/16"	↓	29 V	17 - 18 ipm	

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. <u>W-VTPEDPOST2</u>	Fabricator <u>Highway Safety Corp</u>
Revision no. <u>2</u>	Prepared By: <u>Robert Light</u>
Supporting PQR no. <u>HSCTGD15052416</u>	Date <u>2/24/17</u>
Project Name <u>Morristown, VT</u>	Project Number <u>BRS 0240(3) S</u>