Highway Safety Corporation

Glastonbury, CT

Welding Procedure Specification

Material specification: **A572 gr 50, A709 Gr 50, A36, A709 gr 36, A500 gr B**

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: **38 - 46 CFH**

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) ; over 3/4 thru 1-1/2" (150°F) : over 1-1/2" thru 2-1/2" (225°F)**

Postweld heat treatment: **None**

Electrode extension: **3/4" ± 1/4"**

Vermont Agency of Transportation

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Morristown BRS 0240(3)S Approach Rail Weld Procedure_Approved 4-27-18.pdf

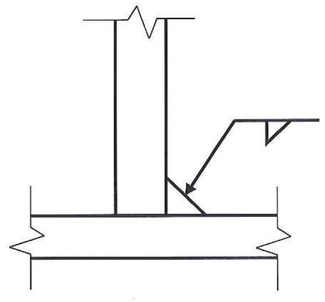
CK'D BY RSF OK'D BY CLB

April 13, 2018

RESUBMIT NO Approved

BY C. CARLSON DATE 04/27/18

WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters Amperes	Welding parameters Volts	Travel speed	Joint detail
3/16	1	1/16"	290 A to 330 A	29 V	19 - 21 ipm	TYPICAL ALL FILLET WELDS 
1/4	1	1/16"	↓	↓	17 - 19 ipm	
5/16	1	1/16"	↓	↓	16 - 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. **W-1PFILLET-VT**

Revision no. **2**

Supporting PQR no. **HSCTGD15052416**

Fabricator **Highway Safety Corp**

Prepared By: **Paul Radice**

Date **2/13/18**

Project Name **Morristown, VT**

Project Number **BRS 0240(3) S**