

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)

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)

Postweld heat treatment

None

Electrode extension

3/4" ± 1/4"

Vermont Agency of Transportation

RECEIVED

CK'D BY RSF

OK'D BY CLB

April 13, 2018

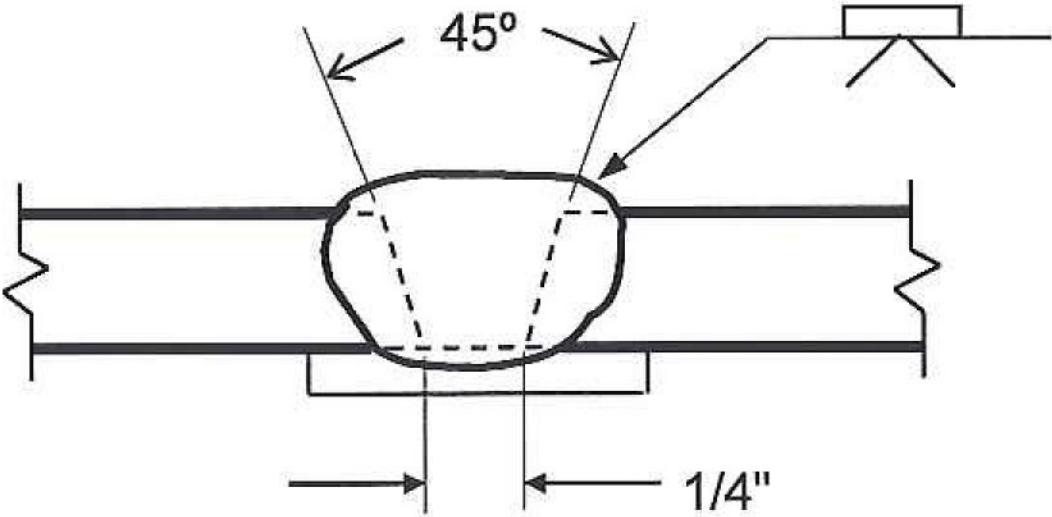
RESUBMIT NO

Approved

BY C. CARLSON

DATE 04/27/18

WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
	1	1/16"	290 A to 330 A	29 V	17 - 19 ipm	B-U2a-GF 

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-VGwBCK-VT

Revision no.

3

Supporting PQR no.

HSCTGD15052416

Fabricator

Highway Safety Corporation

Prepared By:

Robert Light

Date

2/24/17

Project Name

Morristown, VT

Project Number

BRS 0240(3) S