

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

38 - 46 CFH

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)

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		
5/16"	1	1/16"	290 A	29 V	16 - 18 ipm	
1/2"	1 & 2	1/16"	to 330 A	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.

W-VTPEDPOST2

Revision no.

2

Supporting PQR no.

HSCTGD15052416

Fabricator

Highway Safety Corp

Prepared By:

Robert Light

Date

2/24/17

Project Name

Morristown, VT

Project Number

BRS 0240(3) S