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" (50ºF)**

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 Procedures_Approved 4.27.18.pdf

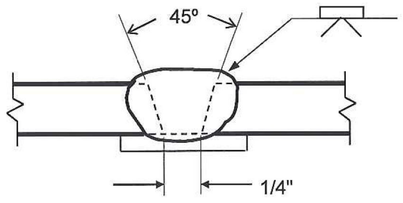
CK'D BY RSF OK'D BY CLB

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
	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**