

Highway Safety Corporation

Glastonbury, CT

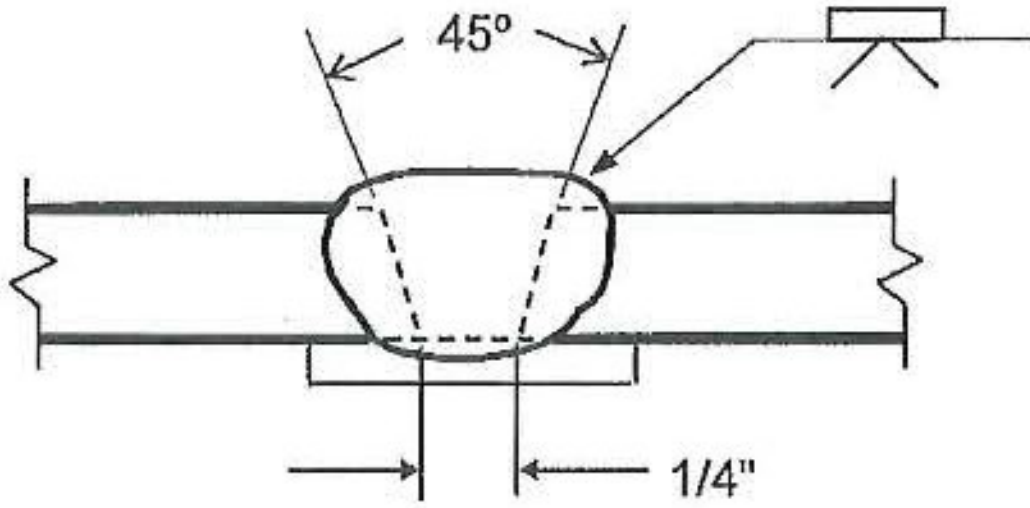
Welding Procedure Specification

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) 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 35-45 CFM
 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)
 Postheat treatment None
 Electrode extension 3/4" ± 1/4"

APPROVED

By Ryan Foster at 9:42 am, May 12, 2015

WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
	1	0.063"	300 A ± 30	29 V ± 2	15 ipm ± 2	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 D1.1

WPS no. W-VGwBCK Fabricator Highway Safety Corporation
 Revision no. 0 Prepared By: Paul Radice
 Supporting PQR no. Pre-Qualified Date 4/8/15
 Project Name Castleton, VT Project Number BRF 015-2(10)