

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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CK'D BY _____ OK'D BY R. FOSTER

February 17, 2017

RESUBMIT NO Approved
 BY C. CARLSON DATE 02/24/2017

WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
3/16	1	1/16"	290 A to 330 A	29 V	19 - 21 ipm	<p>TYPICAL ALL FILLET WELDS</p>
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
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Fabricator Highway Safety Corp
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 Date 2/17/17
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Project Name BRADFORD, VERMONT

Project Number BF 0191 (29)