

**Highway Safety Corporation**  
 Glastonbury, CT  
**Welding Procedure Specification**

Vermont Agency of Transportation  
**RECEIVED**  
 CK'D BY R. Foster OK'D BY WDL  
 January 3, 2017  
 RESUBMIT No Approved  
 BY RSY DATE 01/31/2017

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"

**WELDING PROCEDURE**

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
5/16"	1	1/16"	310 A ± 30	29 V ± 1	17 - 19 ipm	
7/16"	1 & 2	1/16"	↓	↓	↓	

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-VTPEDPOST1 Fabricator Highway Safety Corp  
 Revision no. 2 Prepared By: Paul Radice  
 Supporting PQR no. H SCTGD15052416 Date 12/21/16  
 Project Name Richmond, VT Project Number BF 0284 (28)

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 CWI 88070221  
 QCT EXP. 7/1/2019