

# 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 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

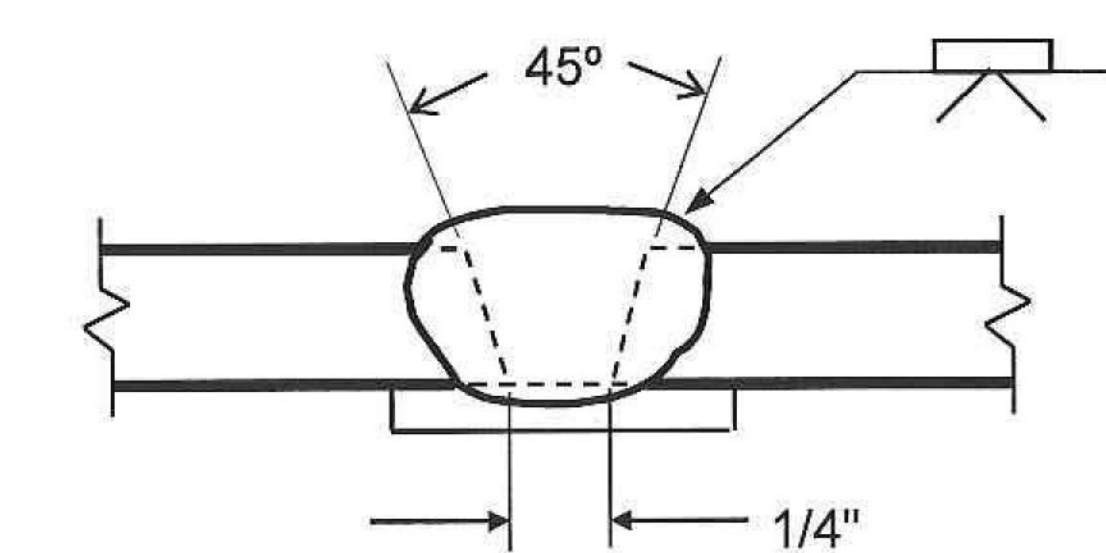
Root treatment clean base metal

Preheat and interpass temperature base metal up to 3/4" (50°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		
	1	1/16"	310 A ± 30	29 V ± 1	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 Fabricator Highway Safety Corporation

Revision no. 2 Prepared By: Paul Radice

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