

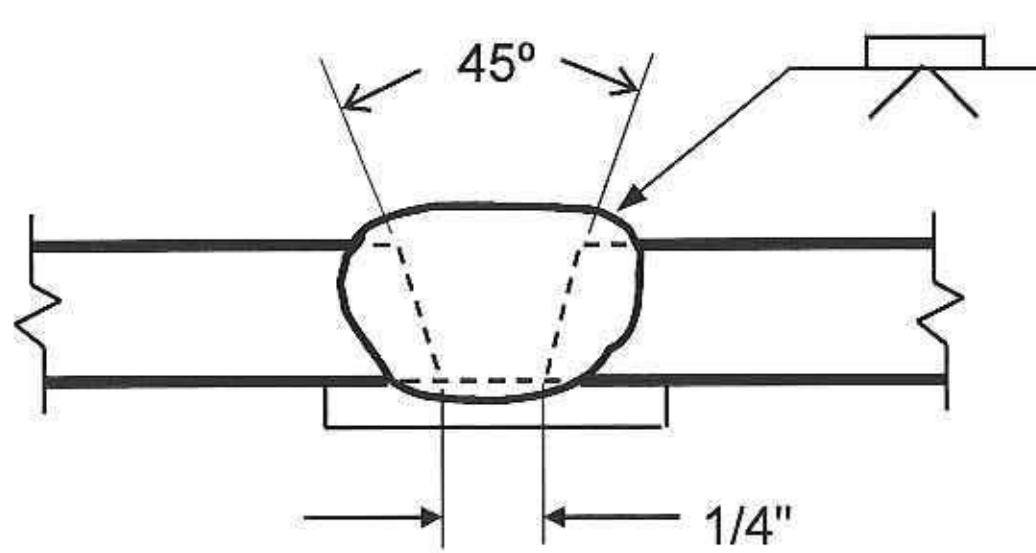
# Highway Safety Corporation

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" (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 

SHOP DRAWING REVIEW

REVIEWED AS REQUIRED BY THE CONSTRUCTION CONTRACT DOCUMENTS AND APPROVED, BUT ONLY FOR CONFORMANCE TO THE DESIGN CONCEPT OF THE WORK, AND SUBJECT TO FURTHER LIMITATIONS AND REQUIREMENTS CONTAINED IN THE CONSTRUCTION CONTRACT DOCUMENTS.

REJECTED    REVISE AND RESUBMIT    APPROVED AS NOTED

CORRECTIONS OR COMMENTS MADE ON THE SHOP DRAWINGS DURING THIS REVIEW DID NOT RELIEVE CONTRACTOR FROM COMPLIANCE WITH REQUIREMENTS OF THE DRAWINGS AND SPECIFICATIONS. THIS CHECK IS ONLY FOR REVIEW OF GENERAL CONFORMANCE WITH THE DESIGN CONCEPT OF THE PROJECT AND GENERAL COMPLIANCE WITH THE INFORMATION GIVEN IN THE CONTRACT DOCUMENTS. THE CONTRACTOR IS RESPONSIBLE FOR CORRECTING AND CORRELATING ALL QUANTITIES AND DIMENSIONS; SELECTING FABRICATION PROCESSES AND TECHNIQUES OF CONSTRUCTION; COORDINATING THEIR WORK WITH THAT OF ALL OTHER TRADES; AND PERFORMING THEIR WORK IN A SAFE AND SATISFACTORY MANNER.

CLD Consulting Engineers 340 Commerce Street Manchester, NH 03101 603-688-8223	Job Number: 16-0223 Reviewed by: NDC Date: 12/2017
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Vermont Agency of Transportation  
RECEIVED

CK'D BY CLD&RF   OK'D BY TAS  
December 29, 2016

RESUBMIT No Approved  
BY T Sumner   DATE 01/03/2016

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  
 Supporting PQR no. HSCTGD15052416 Date 12/21/16  
 Project Name Ludlow, VT Project Number STP DECK (39)

AWS  
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