

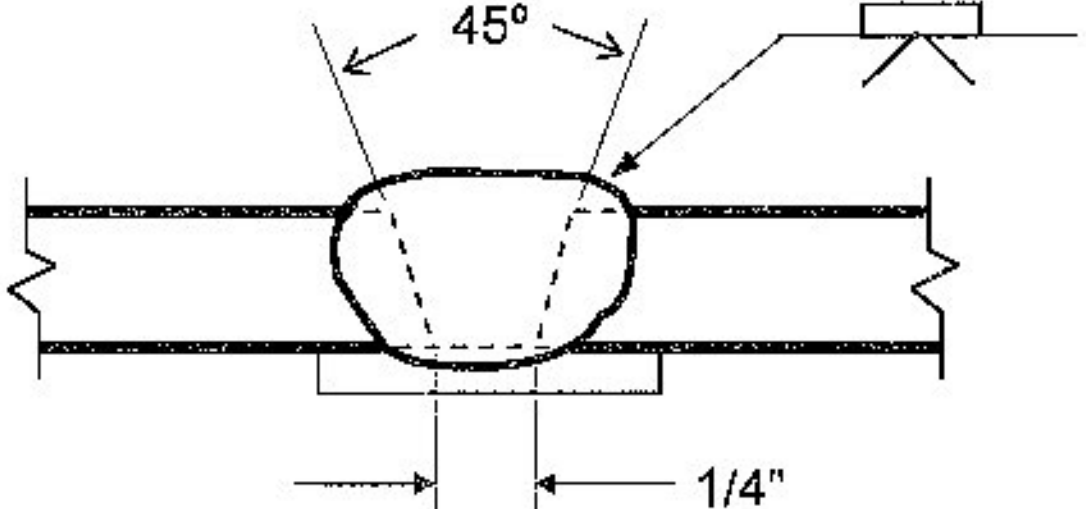
Highway Safety Corporation

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"

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  |

Vermont Agency of Transportation
RECEIVED
 CK'D BY JC OK'D BY _____
 May 13, 2013
 RESUBMIT _____ APPROVED ✓
 BY MEM _____ DATE 5-13-2013

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
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