

Filler metal classification ER70S-3 BY: UGP

Electrode and manufacturer Lincoln Electric Lincoln Weld L-50

Flux and manufacturer N/A

Shielding gas 85% Argon / 15% CO2 Flow rate 19-27 L / min

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)

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		
5/16"	1	0.062"	275 A ± 25	25 V ± 2	8-10 ipm	
7/16"	1 & 2	0.062"	↓	↓	8-10 ipm	
<p>CK'D BY _____ OK'D BY <u>Jec</u></p> <p>AUG 29 2008</p> <p>RESUBMIT _____ APPROVED <u>✓</u></p> <p>BY _____ DATE <u>9/8/08</u></p>						

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-1665-A

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Project Name Stockbridge, VT

Fabricator Highway Safety Corporation

Authorized by Paul Radice

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