

Highway Safety Corporation

Glastonbury, CT

Welding Procedure Specification

Material specification ASTM A36, A709 Gr 36, A500 gr B, A709 gr 50, A572 gr 50

Welding process Gas Metal Arc Welding (GMAW) Spray Transfer Vermont Agency of Transportation

Manual, semi-automatic, or automatic Semi-Automatic RECEIVED

Position of welding Flat (1F) or Horizontal (2F) ON: January 14, 2016

Filler metal specification AWS A5.18 and Checked for

Filler metal classification ER70S-6 CONFORMANCE

Electrode and manufacturer Lincoln Electric Lincoln Weld L-56 BY: ABC DATE:

Flux and manufacturer N/A

Shielding gas 86% Argon / 14% CO2 Flow rate 35-45 CFM

Single or multiple pass Single or Multiple

Single or multiple arc Single

Welding current DCEP

Polarity Reverse - electrode positive

Welding progression Stringers

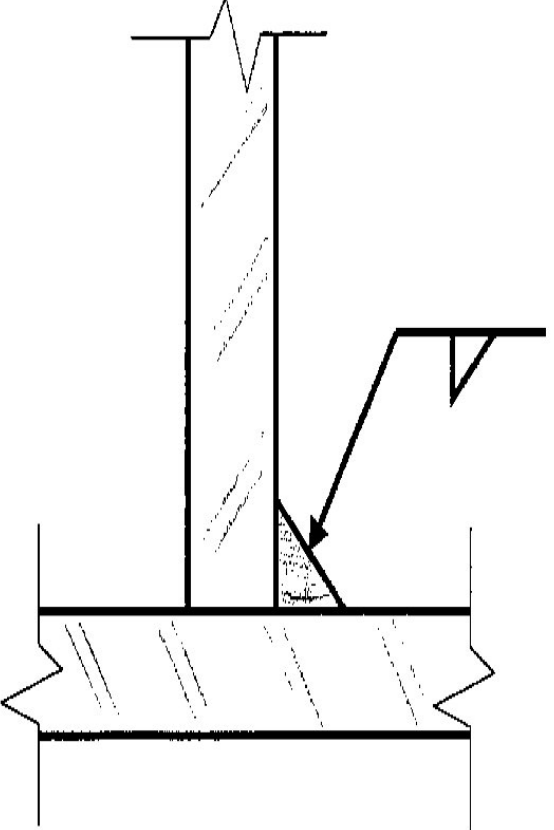
Root treatment clean base metal

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		
1/4"	1	0.062"	300 A ± 30	29 V ± 2	15 ipm ± 2	<p style="text-align: center;">TYPICAL ALL FILLET WELDS</p> 
5/16"	1	0.062"	300 A ± 30	29 V ± 2	10 ipm ± 2	

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 / D1.5

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Revision no. 0 Prepared By: Paul Radice

Supporting PQR no. Pre-Qualified Date 11/30/15

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