

Highway Safety Corporation

Glastonbury, CT

Welding Procedure Specification

Material specification A572 gr 50, A709 Gr 50
 Welding process Gas Metal Arc Welding (GMAW) Spray Transfer

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 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"

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 SHALL BE MADE IN THE MARGINS OF THE DRAWINGS AND SPECIFICATIONS. THIS CHECK IS ONLY FOR REVIEW OF GENERAL COMPLIANCE WITH THE DESIGN CONCEPT OF THE PROJECT AND DOCUMENTS. THE CONTRACTOR IS RESPONSIBLE FOR CONFIRMING AND VERIFYING ALL DIMENSIONS, MATERIALS, PROCESSES AND TECHNIQUES OF CONSTRUCTION, COORDINATING THE WORK WITH THE PROJECT SCHEDULE AND THE PROJECT MANAGER.

Construction Safety
 500 Glastonbury Street
 Glastonbury, CT 06033

Date: 04/23/15
 Reviewed by: AEG
 Scale: AS SHOWN

WELDING PROCEDURE

Weid size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
5/16"	1	0.062"	300 A ± 30	29 V ± 2	15 ipm ± 2	
7/16"	1 & 2	0.062"	↓	↓	15 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 D1.5

WPS no. **W-VTPEDPOST1** Fabricator Highway Safety Corporation
 Revision no. 0 Prepared By: Paul Radice
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