

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

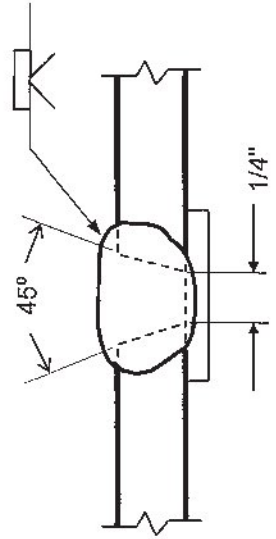
Root treatment clean base metal

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 

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: Paut Radice

Supporting PQR no. Pre-Qualified

Date 4/23/15

Project Name Barton, Vermont

Project Number BRO 1449(31)

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 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 THE REVIEW SHALL BE INDICATED BY CHECKS AND COMMENTS TO THE CONTRACT DOCUMENTS FOR THE PROJECT. THE CONTRACTOR SHALL BE RESPONSIBLE FOR GENERAL COMPLIANCE WITH THE DESIGN CONCEPT OF THE PROJECT AND DOCUMENTS. THE CONTRACTOR IS RESPONSIBLE FOR CONFIRMING AND VERIFYING ALL DIMENSIONS AND CONDITIONS OF THE WORK SHALL BE IN ACCORDANCE WITH THAT OF ALL OTHER TRACES AND PERFORMING THEIR WORK IN A SAFE AND SATISFACTORY MANNER.



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Reviewed By: AEG

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