

Highway Safety Corporation

Glastonbury, CT

Welding Procedure Specification

Material specification ASTM A36, A572 gr 50, A709 Gr 36, ASTM A709 Gr 50, A500 gr B, A53 gr B
 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
 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"

Vermont Agency of Transportation
RECEIVED

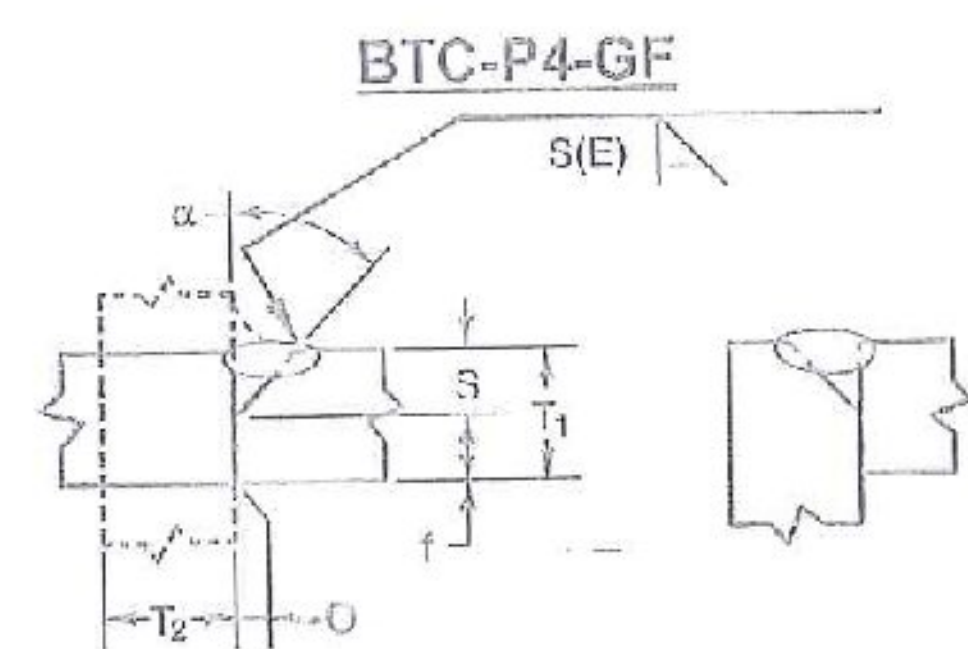
CK'D BY RK/JC OK'D BY RY

February 20, 2015

RESUBMIT No Approved

BY RY DATE 03/09/2015

WELDING PROCEDURE

| Weld size | Pass no. | Electrode size | Welding parameters | | Travel speed | Joint detail |
|-----------|----------|----------------|--------------------|-----------|---------------|---|
| | | | Amperes | Volts | | |
| n/a | 1 | 0.063 | 300 A ± 30 | 29 ± 3 | 15 ipm ± 2 |  <p>BTC-P4-GE</p> <p>X = 45 As Fitup: X = +10, -5 1/4" min. thk. f = 1/8" As Fitup: f = +1/16</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 D1.1 / D1.5

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