

# 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**

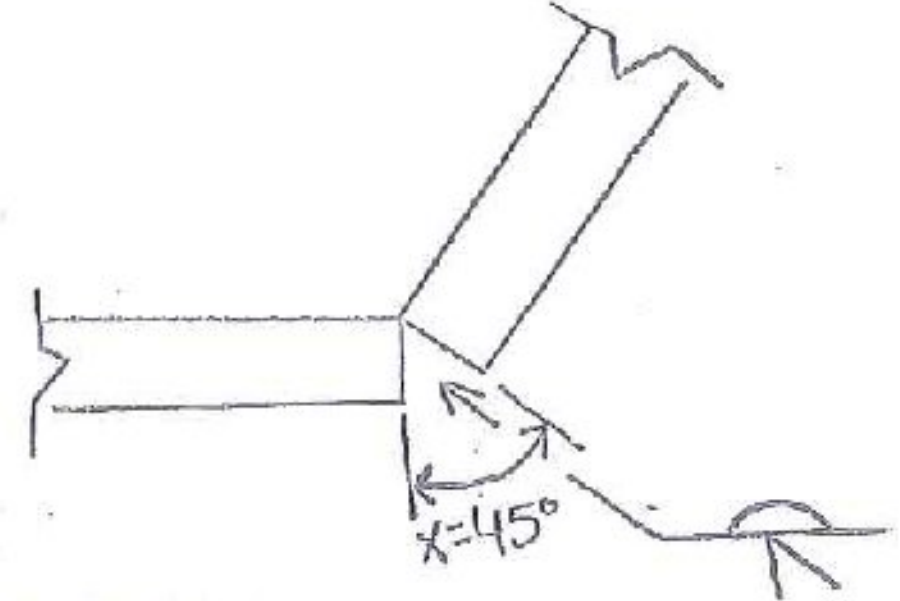
CK'D BY RK/JC OK'D BY RY

February 20, 2015

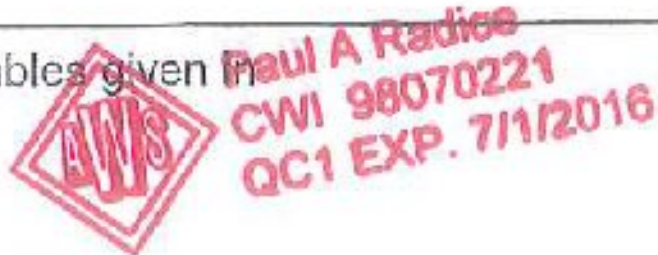
RESUBMIT No Approved

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	29	15 ipm	<p><u>TC-U4b-GF</u></p>  <p>X = 45 As Fitup: X=+10, -5 All Thicknesses</p>
			+/- 30	+/- 3	+/- 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



WPS no. W-2030-B Fabricator Highway Safety Corporation  
 Revision no. 0 Prepared By: Paul Radice  
 Supporting PQR no. Pre-Qualified Date 02-18-15  
 Project Name Fairfield, Vermont Project Number BRF0281 (25) / BRO 1448(41)