

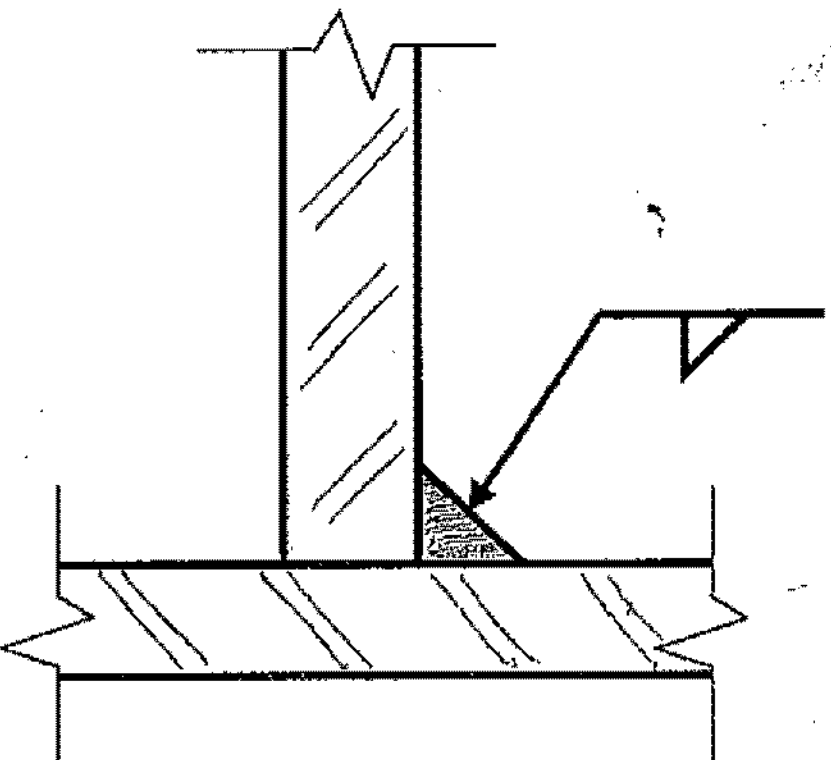
Highway Safety Corporation

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
 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"

WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
3/16" 3mm	1	0.045"	300 A ± 30	29 V ± 2	14 ipm ± 2	<p>TYPICAL ALL FILLET WELDS</p> 
5/16" 8mm	1	0.062"	300 A ± 30	29 V ± 2	10 ipm ± 2	

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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
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 Project Name READSBORO, VT Project Number BRF 0105 (3)