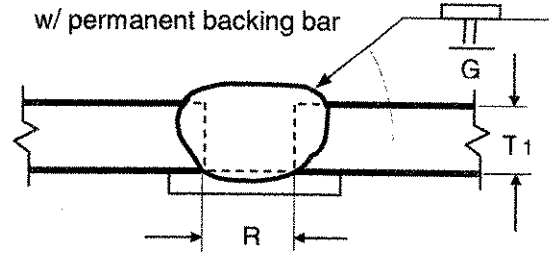


Highway Safety Corporation
Glastonbury, CT

Welding Procedure Specification

Material specification ASTM A500 Gr B
Welding process Shielded Metal Arc Welding (SMAW)
Manual, semi-automatic, or automatic Manual
Position of welding Flat (1G)
Filler metal specification AWS A5.1
Filler metal classification ER7018
Electrode and manufacturer Lincoln Electric Jet LH 78 MR
Flux and manufacturer N/A
Shielding gas N/A Flow rate N/A
Single or multiple pass Multiple
Single or multiple arc Single
Welding current AC
Polarity N/A
Welding progression Stringers
Root treatment clean base metal
Preheat and interpass temperature 50°F (min)
Postheat treatment None
Electrode extension N/A

WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters Amperes Volts	Travel speed	Joint detail
	ALL	5/32"	150 A to 220 A	VARIES	<p>B-L1a full penetration weld joint w/ permanent backing bar</p>  <p>T 1 = 1/4" (max) R = T 1</p>

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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

WPS no. W-1576-B
Revision no. 0
Supporting PQR no. Pre-Qualified
Project Name Cavendish, VT

Fabricator Highway Safety Corporation
Authorized by Paul Radice
Date 9/21/06
Project Number BRO 1442(23)

