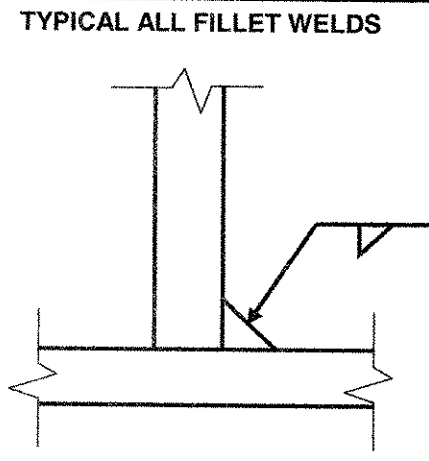


**Highway Safety Corporation**  
Glastonbury, CT

**Welding Procedure Specification**

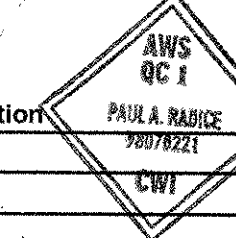
Material specification A572 gr 50, ASTM A709 Gr 50, AASHTO M222  
Welding process Gas Metal Arc Welding (GMAW)  
Manual, semi-automatic, or automatic Semi-Automatic  
Position of welding Flat (1F) or Horizontal (2F)  
Filler metal specification AWS A5.18  
Filler metal classification ER70S-3  
Electrode and manufacturer Lincoln Electric Lincoln Weld L-50  
Flux and manufacturer N/A  
Shielding gas 85% Argon / 15% CO2 Flow rate 19-27 L / min  
Single or multiple pass Single  
Single or multiple arc Single  
Welding current DCEP  
Polarity Reverse - electrode positive  
Welding progression Stringers  
Root treatment None  
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		
1/4"	1	.062"	350 A ± 30	28 V ± 2	12 ipm ± 2	 <p>TYPICAL ALL FILLET WELDS</p>
<p>TRANS RECEIVED  CK'D BY _____ DK'D BY <u>JWC</u>  AUG 04 2006  RESUBMIT _____ APPROVED _____  BY _____ DATE <u>8-8-06</u></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 D1.5

WPS no. W-1562B Fabricator Highway Safety Corporation  
Revision no. 0 Authorized by Paul Radice  
Supporting PQR no. pre-qualified Date 7/28/06  
Project Name Montgomery, Vermont Project Number BRO 1448 (20)



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