

Glastonbury, CT

|                                      |                                   |               |
|--------------------------------------|-----------------------------------|---------------|
| 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                       | None                              |               |
| Preheat and interpass temperature    | 50°F (min)                        |               |
| Postheat treatment                   | None                              |               |
| Electrode extension                  | N/A                               |               |

|           |          |                |                                                      |              |                                                                                             |
|-----------|----------|----------------|------------------------------------------------------|--------------|---------------------------------------------------------------------------------------------|
| Weld size | Pass no. | Electrode size | Welding parameters<br>Amperes Volts                  | Travel speed | Joint detail                                                                                |
|           | ALL      | 5/32"          | 150 A to 220 A                                       | VARIES       |                                                                                             |
|           |          |                | TRANS RECEIVED                                       |              | B-U2a                                                                                       |
|           |          | CK'D BY        | CK'D BY <i>True</i>                                  |              | <p>Diagram of a butt joint with a 45° bevel and a 1/4" gap. The joint is labeled B-U2a.</p> |
|           |          | RESUBMIT BY    | AUG 0 4 2006 APPROVED <i>✓</i><br>DATE <i>8-3-06</i> |              |                                                                                             |

|                    |                            |                |                                   |
|--------------------|----------------------------|----------------|-----------------------------------|
| WPS no.            | <b>W-1562A</b>             | Fabricator     | <b>Highway Safety Corporation</b> |
| Revision no.       | <b>0</b>                   | Authorized by  | <b>Paul Radice</b>                |
| Supporting POR no. | <b>Pre-Qualified</b>       | Date           | <b>7/28/06</b>                    |
| Project Name       | <b>Montgomery, Vermont</b> | Project Number | <b>BRO 1448 (20)</b>              |

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