

Highway Safety Corporation
Glastonbury, CT
Welding Procedure Specification

Material specification A572 gr 50, A709 Gr 50
 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 or Multiple
 Single or multiple arc Single or Multiple
 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"

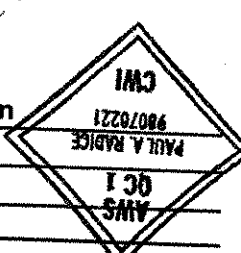
WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
8mm	1	2 mm	275 A ± 25	25 V ± 2	200-250 mm / min	
5/16"	1	0.062"			8-10 ipm	
12 mm	1 & 2	2 mm			200-250 mm / min	
7/16"	1 & 2	0.062"			8-10 ipm	

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 RESUBMIT APPROVED BY JWC DATE 7-1-06

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

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 Supporting PQR no. Pre-Qualified Date 6/8/06
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