

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

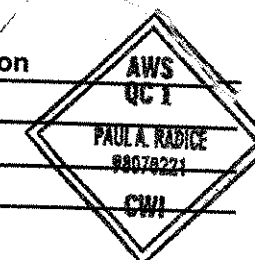
WELDING PROCEDURE

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-11a full penetration weld joint w/ permanent backing bar</p> <p>T 1 = 1/4" (max) R = T 1</p>
<p>RECEIVED JUN 6 2006 APPROVED DATE 7-17-06</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 D1.1

WPS no. W-1552b
 Revision no. 0
 Supporting PQR no. Pre-Qualified
 Project Name Mendon, Vermont

Fabricator Highway Safety Corporation
 Authorized by Paul Radice
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