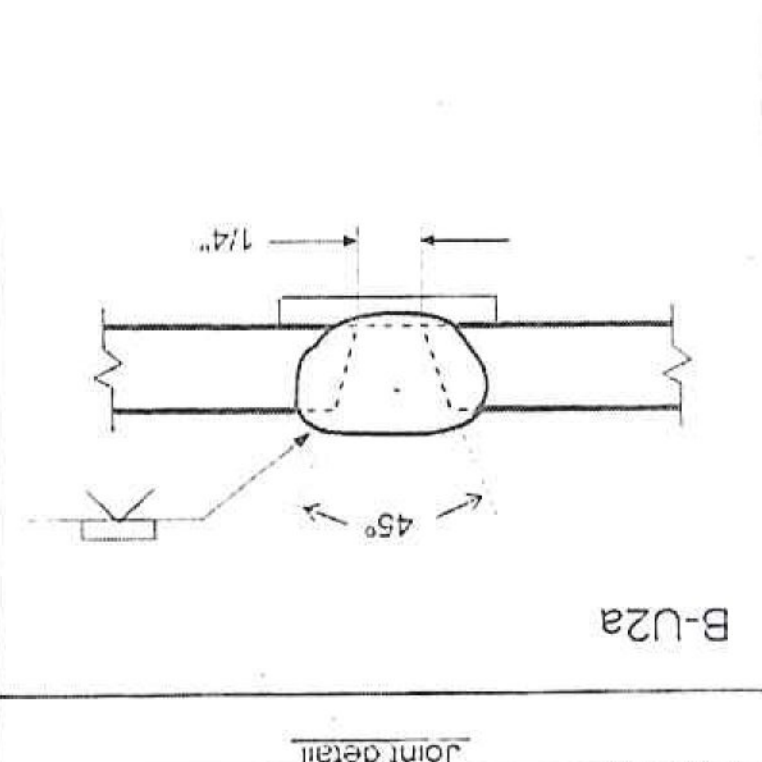


Highway Safety Corporation
Glastonbury, CT
Welding Procedure Specification

Material specification: ASTM A500 gr B
 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
 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: clean base metal
 Preheat and interpass temperature: base metal up to 3/4" (50°F)
 Postheat treatment: None
 Electrode extension: 3/4" ± 1/4"

Weld size	Pass no.	Electrode size	Welding parameters	Travel speed	Joint detail
1	1	0.045"	300 A ± 30 29 V ± 2	14 ipm ± 2	B-U2a 

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-1791C
 Revision no. 0
 Supporting PQR no. Pre-Qualified
 Project Name: Hartford (Wilder) Vermont
 Project Number: STP 1444 (35)
 Prepared By: Paul Radice
 Date: 12/14/10
 Fabricator: Highway Safety Corporation

RECEIVED
 VTRAWS
 JUN 06 2011
 APPROVED
 BY KMH DATE 06/06/11
 OK'D BY JWC