

Highway Safety Corporation

Glastonbury, CT

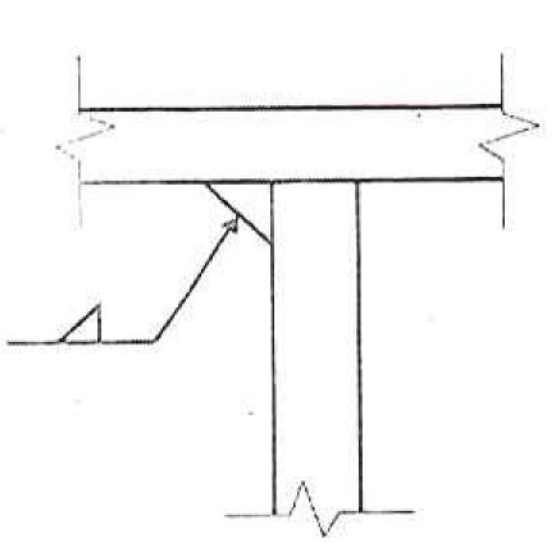
Welding Procedure Specification

Material specification: ASTM A56, A709 Gr 36, A500 gr B, A53 gr B  
 Welding process: Gas Metal Arc Welding (GMAW)  
 Manual, semi-automatic or automatic: Semi-Automatic  
 Position of welding: Flat (F) 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: 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
			Amps	Volts	
1/8"	1	0.045"	300 A	29 V	28 ipm ± 2
3/16"	1	0.045"	300 A	29 V	14 ipm ± 2

TYPICAL ALL FILLET WELDS



Joint detail

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 / D1.5

WPS no: W-1791B  
 Fabricator: Highway Safety Corporation  
 Prepared By: Paul Radice  
 Date: 12/14/10  
 Project Number: STP 1444 (35)  
 Supporting PQR no: Pre-Qualified  
 Project Name: Hartford (Wilden) Vermont

RECEIVED  
 VIKRAMS  
 OK'D BY: JWC  
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 BY: KMH  
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