

WELDING PROCEDURE SPECIFICATION

MATERIAL SPECIFICATION A572 GR 50
 WELDING PROCESS FCAW
 MANUAL, SEMIAUTOMATIC, AUTOMATIC SEMIAUTOMATIC
 POSITION OF WELDING 1F (FLAT)
 FILLER METAL SPECIFICATIONS AWS 5.20
 FILLER METAL CLASSIFICATION E71T-1
 ELECTRODE & MANUFACTURE Ultracore 71C (Lincoln)
 FLUX & MANUFACTURE N/A
 SHIELDING GAS 100% CO2 DEW POINT -40°F FLOW RATE MIN 41 CFH MAX 56 CFH
 SINGLE OR MULTIPLE PASS MULTIPLE
 SINGLE OR MULTIPLE ARC N/A
 WELDING CURRENT DC POLARITY DCEP (REVERSE)
 WELDING PROGRESSION N/A
 ROOT TREATMENT CLEAN TO REMOVE ALL CONTAMINANT
 PREHEAT AND INTERPASS 3/4 TO 1 1/2 = 70°F, 1 1/2 TO 2 1/2 = 150°F > 2 1/2 = 225°F
300°F MAX INTERPASS TEMP.
 POSTHEAT TREATMENT NONE

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	AMPS	VOLTS	TRAVEL SPEED IN/MIN	JOINT DETAIL
ALL	1/16"	300	27	11.6	Stock Bridge post
		Max 330	Max 29	Max 12.7	
		Min 270	Min 25	Min 10.5	

Base plate 1" to 1-9/16" A572 Gr 50
 Illustrated in the horizontal position for clarity only welding to be completed in the flat position.

PROCEDURE NO. DI-04 FABRICATOR DI-HIGHWAY SIGN & STRUCTURE

OUR JOB NO. Stock Bridge Post AUTHORIZED BY [Signature]

PQR REF NO. DI-01-09a DATE 11/28/10

