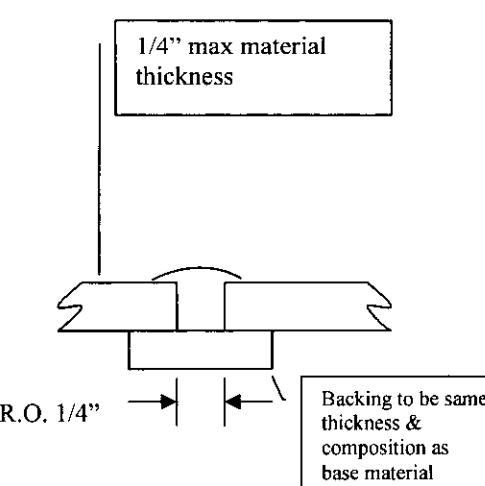


WELDING PROCEDURE SPECIFICATION

MATERIAL SPECIFICATION A36, A53GR B, A252 GR 2, OR 3, 5LX52, A500 GR B
 WELDING PROCESS FCAW
 MANUAL, SEMIAUTOMATIC, AUTOMATIC SEMIAUTOMATIC
 POSITION OF WELDING 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 SINGLE
 SINGLE OR MULTIPLE ARC SINGLE
 WELDING CURRENT DC POLARITY DCEP (REVERSE)
 WELDING PROGRESSION N/A
 ROOT TREATMENT CLEAN TO REMOVE ALL CONTAMINANT
 PREHEAT AND INTERPASS <3/4=50°F, 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
1	1/16	300	27	11.6	Used for 6 X 6 x 3/16 guide rail 5 X 3 X 1/4 bridge rail 3 X 3 X 3/16 pedestrian rail 
		MAX 330 MIN 270	MAX 29 MIN 25	12.7 TO 10.5	

PROCEDURE NO. DI-06 FABRICATOR DI-HIGHWAY SIGN & STRUCTURE

OUR JOB NO. Stock bridge rail & guide rail AUTHORIZED BY 

PQR REF NO. DI-01-09a DATE 1/2/2010 

REEL W. SHAS
 CRN 9602971
 QCS 09.04.01.14