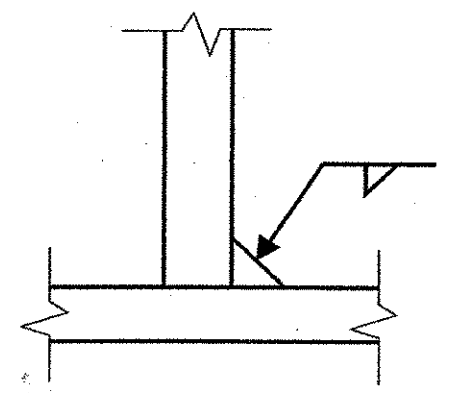


**Highway Safety Corporation**  
Glastonbury, CT  
**Welding Procedure Specification**

Material specification ASTM A36, A572 gr 50, A709 Gr 36, ASTM A709 Gr 50  
 Welding process Gas Metal Arc Welding (GMAW)  
 Manual, semi-automatic, or automatic Semi-Automatic  
 Position of welding 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 DC  
 Polarity Reverse  
 Welding progression Stringers  
 Root treatment None  
 Preheat and interpass temperature Base Metal up to 3/4" (50°F) ; over 3/4-1 1/2" (70°F)  
 Postheat treatment None  
 Electrode extension 3/4" ± 1/4"

**WELDING PROCEDURE**

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
1/4"	1	0.045"	300 A ± 30	29 V ± 2	14 ipm ± 2	TYPICAL ALL FILLET WELDS 
V.A.O.T. RECEIVED CK'D BY: JWC NOV 13 2003 RESUBMITTED APPROVED ✓ BY: DATE 11-18-03						

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 D1.5

WPS no. w-VTG11-a Fabricator Highway Safety Corporation  
 Revision no. 0 Authorized by Paul Radice  
 Supporting PQR no. pre-qualified Date 9/23/03  
 Project Name PROCTOR - PLYMOUTH Project Number # 647 840 1443 (37)

062-35

