

**Highway Safety Corporation**  
Glastonbury, CT

**Welding Procedure Specification**

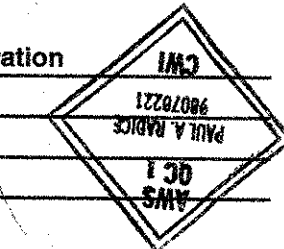
Material specification ASTM A500 Gr B / A53 gr B  
 Welding process Shielded Metal Arc Welding (SMAW)  
 Manual, semi-automatic, or automatic Manual  
 Position of welding Flat (1G)  
 Filler metal specification AWS A5.1  
 Filler metal classification ER7018  
 Electrode and manufacturer Lincoln Electric Jet LH 78 MR  
 Flux and manufacturer N/A  
 Shielding gas N/A Flow rate N/A  
 Single or multiple pass Multiple  
 Single or multiple arc Single  
 Welding current AC  
 Polarity N/A  
 Welding progression Stringers  
 Root treatment clean base metal  
 Preheat and interpass temperature 50°F (min)  
 Postheat treatment None  
 Electrode extension N/A

**WELDING PROCEDURE**

Weld size	Pass no.	Electrode size	Welding parameters Amperes Volts	Travel speed	Joint detail
	<b>ALL</b>	<b>5/32"</b>	<b>150 A to 220 A</b>	<b>VARIES</b>	<p><b>B-1a</b> full penetration weld joint w/ permanent backing bar</p> <p><b>T 1 = 1/4" (max)</b> <b>R = T 1</b></p>

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

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 Revision no. 0 Authorized by Paul Radice  
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