

# Highway Safety Corporation

Glastonbury, CT

## Welding Procedure Specification

Material specification ASTM A709 gr 36

Welding process Gas Metal Arc Welding (GMAW)

Manual, semi-automatic, or automatic Semi-Automatic

Position of welding Flat (1G)

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)

Postheat treatment None

Electrode extension 3/4" ± 1/4"

### WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
	1	0.045"	300 A ± 30	29 V ± 2	14 ipm ± 2	B-11a
<p>TRANS RECEIVED</p> <p>OK'D BY <u>JUL</u></p> <p>JUL 26 2007</p> <p>APPROVED</p> <p>DATE 8-2-07</p>						
						<p>T 1 = 1/4" (max) R = T 1</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 / D1.5

WPS no. W-1600-b

Fabricator Highway Safety Corporation

Revision no. 0

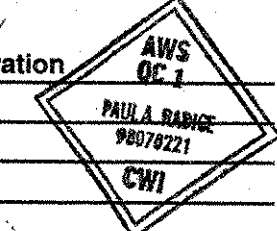
Authorized by Paul Radice

Supporting PQR no. Pre-Qualified

Date 7/18/07

Project Name Warren, VT

Project Number BHF 0188(7)



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