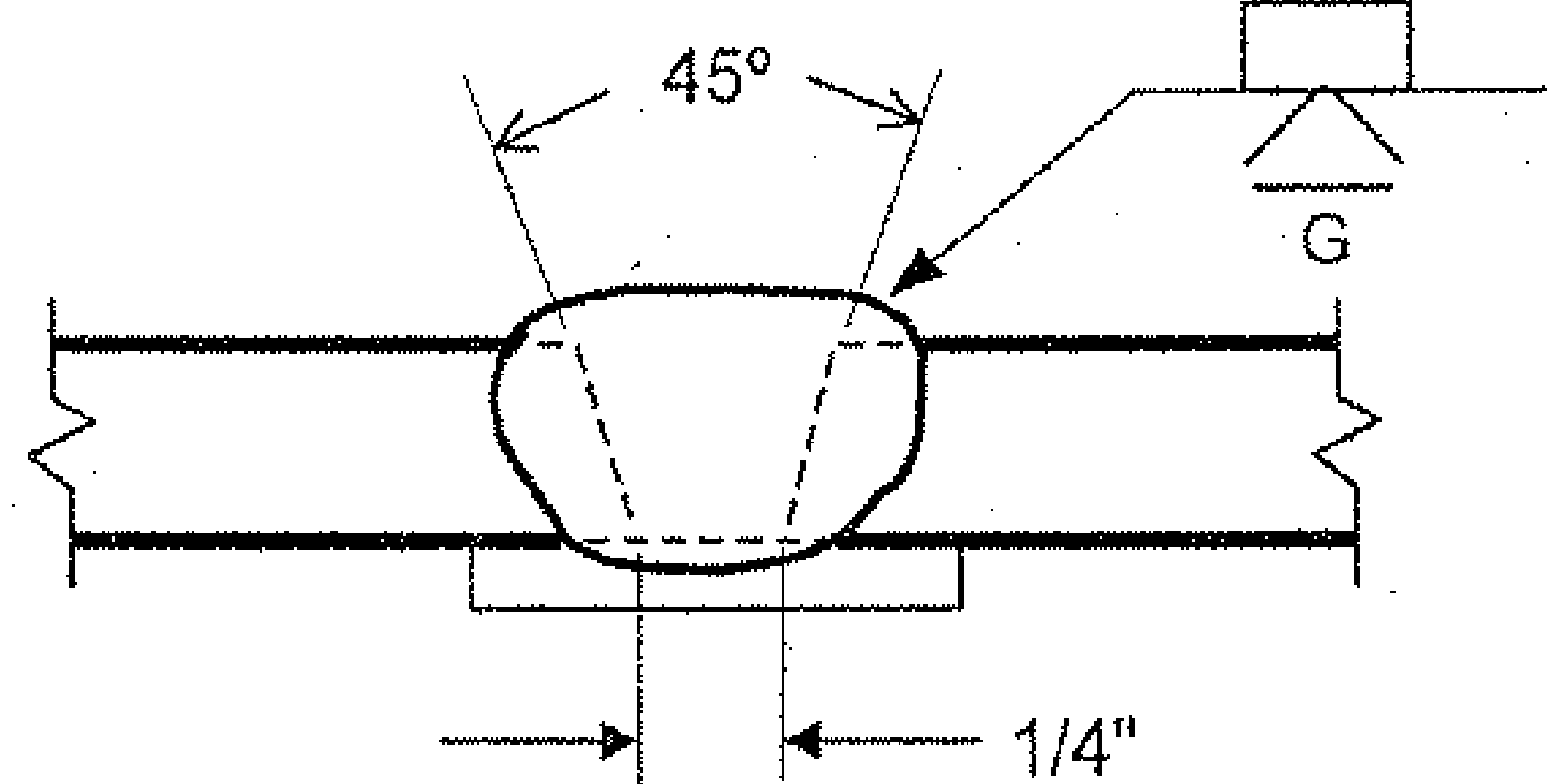


Single or multiple pass Multiple
 Single or multiple arc Single
 Welding current AC
 Polarity N/A
 Welding progression Stringers
 Root treatment None
 Preheat and interpass temperature 50°F (min)
 Postheat treatment None
 Electrode extension N/A

V.A.O.T. RECEIVED
 OK'D BY _____ OK'D BY JWC
JAN 29 2004
 RESUBMIT _____ APPROVED ✓
 BY _____ DATE 02-03-04

WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
	ALL	5/32"	150 A to 220 A		VARIES	B-U2a 

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

WPS no. W-1400-A
 Revision no. 0
 Supporting PQR no. Pre-Qualified
 Project Name Waterbury, Vermont

Fabricator Highway Safety Corporation
 Authorized by Paul Radice
 Date 1/19/03
 Project Number TH-3-9637

025
RAIL