

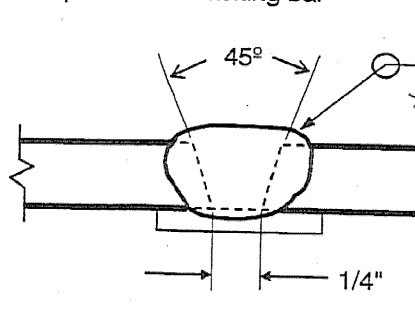
# Highway Safety Corporation

Glastonbury, CT

## Welding Procedure Specification

Material specification ASTM A500 Gr B  
 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" (60°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	0.045"	300 A ± 30	29 V ± 2	14 ipm ± 2	full penetration groove weld with permanent backing bar 
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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

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 Revision no. 0 Authorized by Paul Radice  
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