Highway Safety Corporation

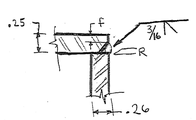
Glastonbury, CT

Welding Procedure Specification

Material specification **ASTM A36, A709 Gr 36**
Welding process **Gas Metal Arc Welding (GMAW)**
Manual, semi-automatic, or automatic **Semi-Automatic**
Position of welding **Horizontal**
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" (50ºF) ; over 3/4-1 1/2" (70ºF)**
Postheat treatment **None**
Electrode extension **3/4" ± 1/4"**

WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters Amperes	Welding parameters Volts	Travel speed	Joint detail
3/16"	**1**	**0.045"**	**300 A ± 30**	**29 V ± 2**	**28 ipm ± 2**	BTC - PH - GF



R = 0 +1/8 -1/16
f = 1/8 ± 1/16

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 and D1.5

WPS no. **W-1660A**
Revision no. **0**
Supporting PQR no. **Pre-qualified**
Project Name **Richford, VT**

Fabricator **Highway Safety Corporation**
Authorized by Paul Radice
Date **9/9/08**
Project Number **BHF 0302(3)S**