

Highway Safety Corporation

Glastonbury, CT

Welding Procedure Specification

Material specification ASTM A36, A572 gr 50, A709 Gr 36, ASTM A709 Gr 50, 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 & Multiple

Single or multiple arc Single

Welding current DC

Polarity Reverse

Welding progression Stringers

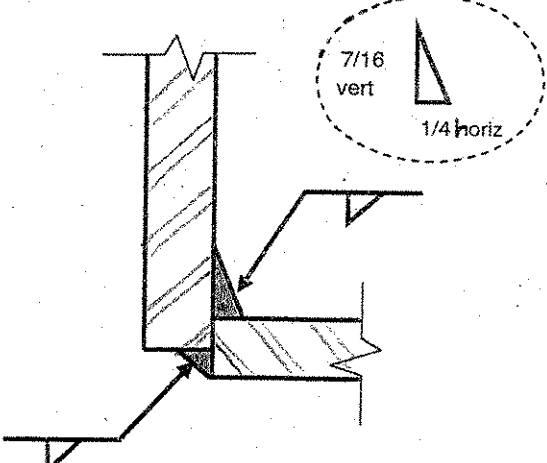
Root treatment None

Preheat and interpass temperature Base Metal up to 3/4" (50°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    |              |                                                                                                                                            |
| 7/16" x 1/4" | 1 & 2    | 0.045"         | 300 A ± 30         | 29 V ± 2 | 14 ipm ± 2   | UN-EQUAL LEG FILLET WELD<br>@ BASE PLATE CONNECTION<br> |

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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