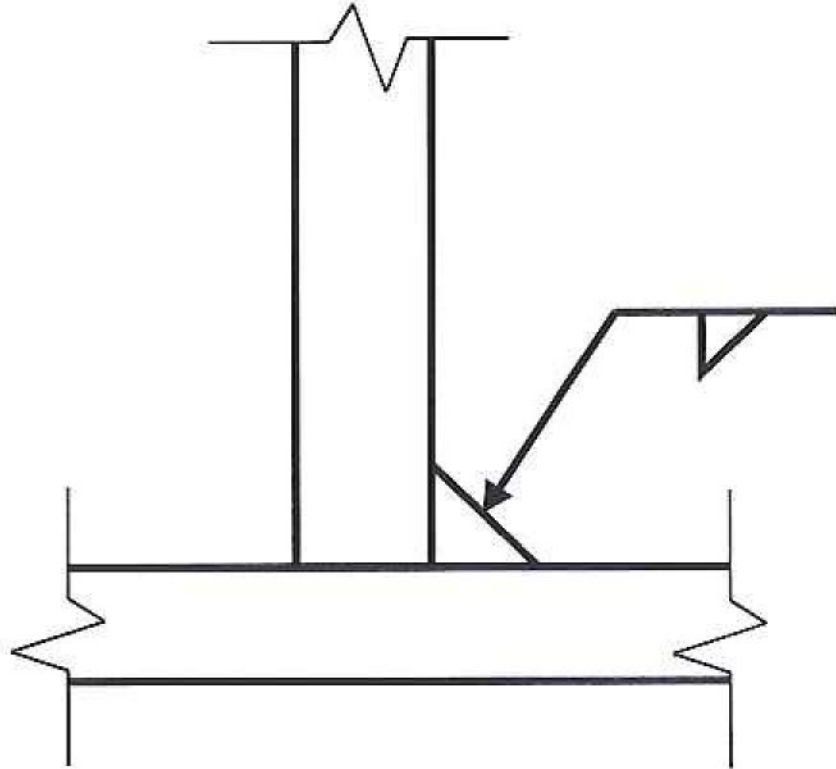


Highway Safety Corporation
Glastonbury, CT
Welding Procedure Specification

Material specification	A572 gr 50, A709 Gr 50, A36, A709 gr 36, A500 gr B		
Welding process	Gas Metal Arc Welding (GMAW) Spray Transfer		
Manual, semi-automatic, or automatic	Semi-Automatic		
Position of welding	Flat (1F) or Horizontal (2F)		
Filler metal specification	AWS A5.18		
Filler metal classification	ER70S-6		
Electrode and manufacturer	Lincoln Electric Lincoln Weld L-56		
Flux and manufacturer	N/A		
Shielding gas	86% Argon / 14% CO2	Flow rate	38 - 46 CFH
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) ; over 3/4 thru 1-1/2" (150°F) : over 1-1/2" thru 2-1/2" (225°F)		
Postweld heat treatment	None		
Electrode extension	3/4" ± 1/4"		

Vermont Agency of Transportation
RECEIVED
CK'D BY RSF OK'D BY CLB
April 13, 2018
RESUBMIT NO Approved
BY C. CARLSON DATE 04/27/18

WELDING PROCEDURE

Weld size	Pass no.	Electrode size	Welding parameters		Travel speed	Joint detail
			Amperes	Volts		
3/16	1	1/16"	290 A to 330 A	29 V	19 - 21 ipm	TYPICAL ALL FILLET WELDS 
1/4	1	1/16"	↓	↓	17 - 19 ipm	
5/16	1	1/16"	↓	↓	16 - 18 ipm	

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

WPS no.	W-1PFILLET-VT	Fabricator	Highway Safety Corp
Revision no.	2	Prepared By:	Paul Radice
Supporting PQR no.	HSCTGD15052416	Date	2/13/18
Project Name	Morristown, VT	Project Number	BRS 0240(3) S