

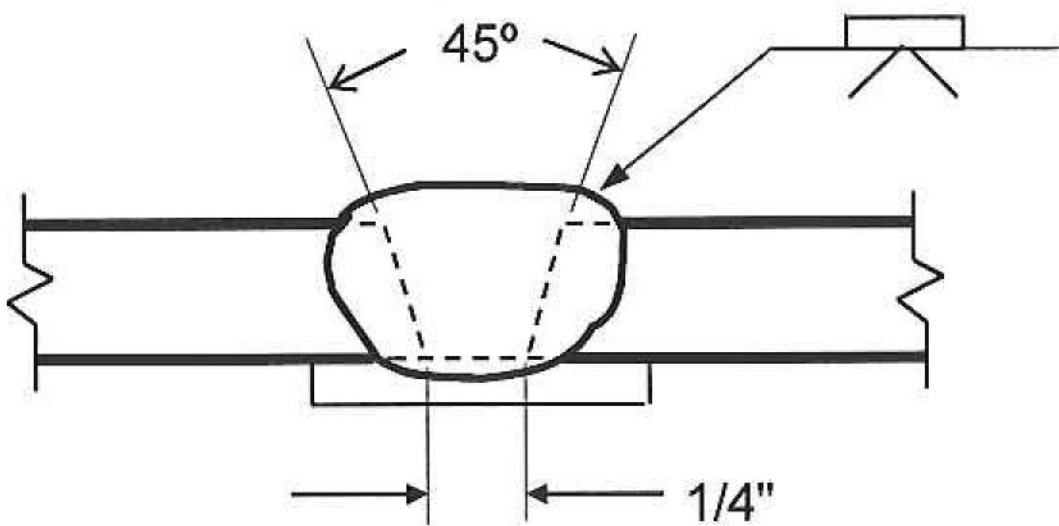
Highway Safety Corporation

Glastonbury, CT

Welding Procedure Specification

Material specification	ASTM A500 gr B		Vermont Agency of Transportation RECEIVED	
Welding process	Gas Metal Arc Welding (GMAW)		CK'D BY	OK'D BY R. FOSTER
Manual, semi-automatic, or automatic	Semi-Automatic		February 17, 2017	
Position of welding	Flat (1F)		RESUBMIT NO	Approved
Filler metal specification	AWS A5.18		BY C. CARLSON	DATE 02/24/2017
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)			
Postweld heat 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	1/16"	290 A to 330 A	29 V	17 - 19 ipm	B-U2a-GF 

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-VGwBCK-VT**
Revision no. **3**
Supporting PQR no. **HSCTGD15052416**

Fabricator **Highway Safety Corporation**
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Date **2/17/17** **CWI 98070221**
QC1 EXP. 7/1/2019

Project Name **BRADFORD, VERMONT** Project Number **BF 0191 (29)**