Highway Safety Corporation

Glastonbury, CT

Welding Procedure Specification

Material specification **A572 gr 50, A709 Gr 50**

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 **35-45 CFM**

Single or multiple pass **Single or Multiple**

Single or multiple arc **Single**

Welding current **DCEP**

Polarity **Reverse - electrode positive**

Welding progression **Stringers**

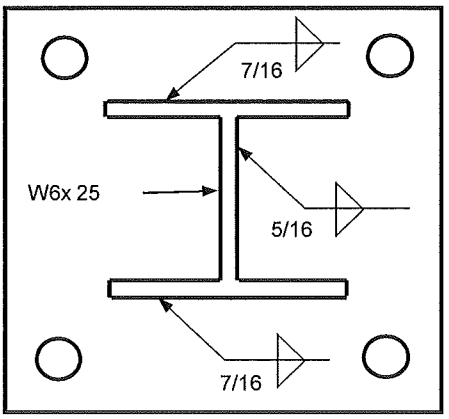
Root treatment **clean base metal**

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)**

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
5/16"	**1**	**0.062"**	**300 A ± 30**	**29 V ± 2**	**15 ipm ± 2**	
7/16"	**1 & 2**	**0.062"**	↓	↓	**15 ipm ± 2**	

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

Paul A Radice
CWI 98070221
QC1 EXP. 7/1/2016

WPS no. **W-VTPEDPOST1**

Revision no. **0**

Supporting PQR no. **Pre-Qualified**

Project Name **HYDE PAR, VT**

Fabricator **Highway Safety Corporation**

Prepared By: **Paul Radice**

Date **07-14-14**

Project Number **STP CULV (26)**

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 **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 **35-45 CFM**

Single or multiple pass **Single**

Single or multiple arc **Single**

Welding current **DCEP**

Polarity **Reverse - electrode positive**

Welding progression **Stringers**

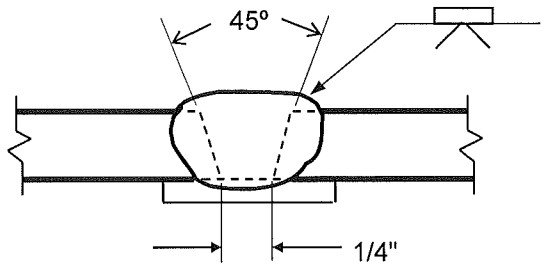
Root treatment **clean base metal**

Preheat and interpass temperature **base metal up to 3/4" (50°F)**

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	0.063"	300 A ± 30	29 V ± 2	15 ipm ± 2	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 D1.1

WPS no. **W-VGwBCK**

Revision no. **0**

Supporting PQR no. **Pre-Qualified**

Project Name **HYDE PAR, VT**

Fabricator **Highway Safety Corporation**

Prepared By: **Paul Radice**

Date **07-14-14**

Project Number **STP CULV (26)**

Paul A Radice
CWI 98070221
QC1 EXP. 7/1/2016