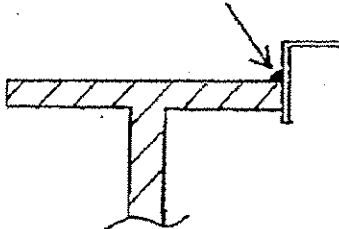


POSITION OF WELDING _____
 FILLER METAL SPECIFICATION AWS A.W.S. 5.1
 FILLER METAL CLASSIFICATION E7018
 ELECTRODE AND MANUFACTURER Lincoln - Jet LH-78
 FLUX AND MANUFACTURER N/A
 SHIELDING GAS N/A DEW POINT N/A FLOW RATE N/A
 SINGLE OR MULTIPLE PASS Single
 SINGLE OR MULTIPLE ARC Single Arc
 WELDING CURRENT 165 AMP
 POLARITY D.C. Positive
 WELDING PROGRESSION Horizontal Flat
 ROOT TREATMENT No Root Treatment
 PREHEAT AND INTERPASS TEMPERATURE No Preheat Procedures necessary/ weld above 20 F
 POSTHEAT TREATMENT None

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING PARAMETERS		TRAVEL SPEED	JOINT DETAIL
		AMPERES	VOLTS		
I	5/32	165	20 v.	15 inches per minute	single pass 
RECEIVED CK'D BY _____ MAY 13 2008 RESUBMIT _____ BY _____		CK'D BY <u>JWC</u> APPROVED ✓ DATE <u>5/13/08</u>		Sequence of weld passes shall be shown diagrammatically	

This procedure may vary due to fabrication sequence, fit up, pass size, etc., within the limitations of variables given in section 8A

Procedure no. _____ Fabricator or Erector Northern Stud Welding, LLC
 Revision no. _____ Authorized by Dary Blue
 Date JAN 2007

RECEIVED

FIGURE 704 - SAMPLE WELDING PROCEDURE SPECIFICATION

MAY 16 2008

G.P.I.