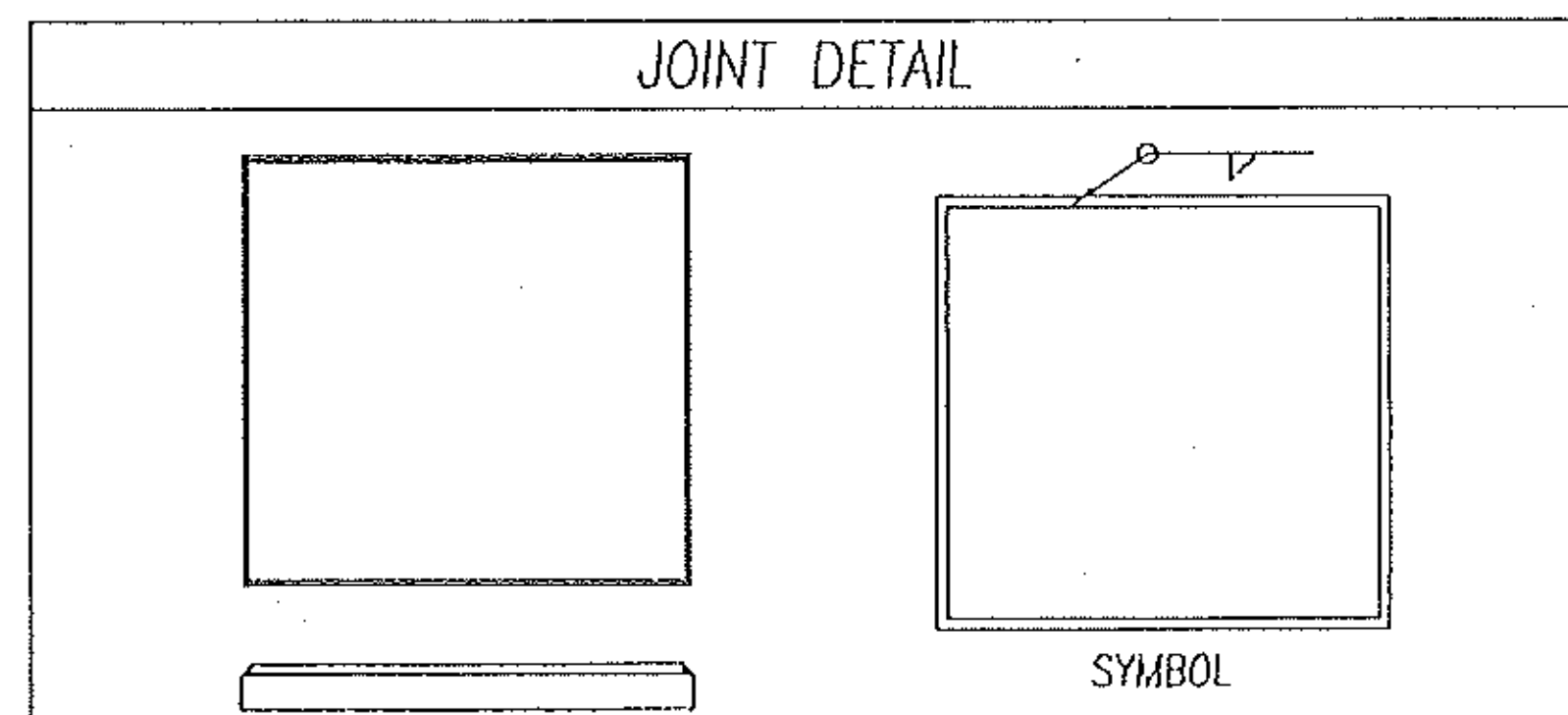


WELDING PROCEDURE SPECIFICATION
OR
PROCEDURE QUALIFICATION RECORD

Specification No.: 57948 BECK & BELLUCCI
 Customer: Standard Fusion of T-304 to CS Backing Plate Customer P.O.#: BETHEL, VT.
 Base Metals: _____ P-NO.: 8 Group NO.: _____ to P-NO.: 1 Group NO.: 1
 Material Specification Type & Grade: T-304 S.S. to Carbon Steel Backing Plate
 Welding Process: G.T.A.W. 1/2" dia. nozzle w/gas lens
 Manual or Machine: Manual
 Position of Welding: 1G Flat
 Filler Metal Specification: N/A OK'D BY SSS OK'D BY JAK
 Filler Metal Classification: N/A RECEIVED
 Shielding Gas: Argon 20-30 cfh OCT 13 2011
 Single or Multiple Pass: Single RESUBMIT _____ APPROVED
 Single or Multiple Arc: Single BY _____ DATE 10/14/11
 Welding Current: Direct
 Polarity: Straight
 Root Treatment: Remove all oil, grease, scale etc. on weld preparation face and adjacent plate surface
 Preheat and Interpass Temp: N/A
 Post weld Heat Treatment: N/A

Filler Metal			Pass No.	Process	Welding Current		Travel Speed
Class	Dia.	F No.			Amperes	Voltage	
N/A	N/A		1	G.T.A.W.	100-170	19-23	5-7 ipm



Manufacturer: Amscot Structural Products Authorized By: [Signature]
 Date: 10/16/11