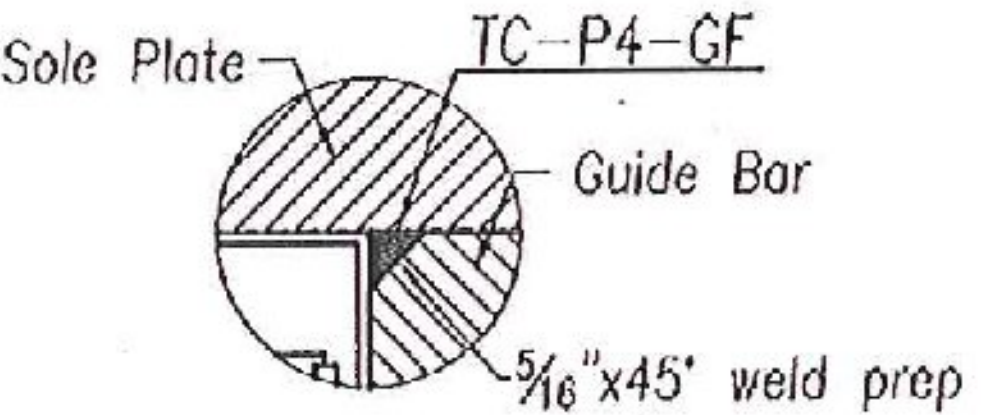


WELDING PROCEDURE SPECIFICATION
OR
PROCEDURE QUALIFICATION RECORD

Specification No.: 402919 A.L.St. Onge
 Customer: Single Bevel Groove Partial Joint Penn. Customer P.O.#: Signed Quote
 Base Metals: A709 Gr345 P-NO.: 1 Group NO.: 1 to P-NO.: 1 Group NO.: 1
 Material Specification Type & Grade: A709 Gr345 to A709 Gr345
 Welding Process: F.C.A.W.
 Manual or Machine: Manual
 Position of Welding: Flat 1-F
 Filler Metal Specification: A 5.29
 Filler Metal Classification: E-80T1-W, Esab Dual Shield 8100-W
 Shielding Gas: CO² Rate: 25 CFH
 Single or Multiple Pass: Single VTrans Received
CK'D OK'd BY: JWC
 Single or Multiple Arc: Single OCT 10 2012
 Welding Current: Direct Resubmit APPROVED BY DATE: 10/29/12
 Polarity: Reverse
 Root Treatment: Remove all scale, grease, etc. from weld preparation face
 Preheat and Interpass Temp: 200 Deg F. to 250 Deg F.
 Post weld Heat Treatment: N/A
 Travel Speed: 13-15 ipm

Pass No.	Electrode Size	Welding Current		Weld Size	Joint Detail
		Amperes	Volts		
1	.06	300-310	30-31	5/16"	SINGLE BEVEL GROOVE WELD - TC-P4-GF 

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Manufacturer: Amscot Structural Products Authorized By: Peter Somogyi
 Date: 10/9/12