

WELDING PROCEDURE SPECIFICATION

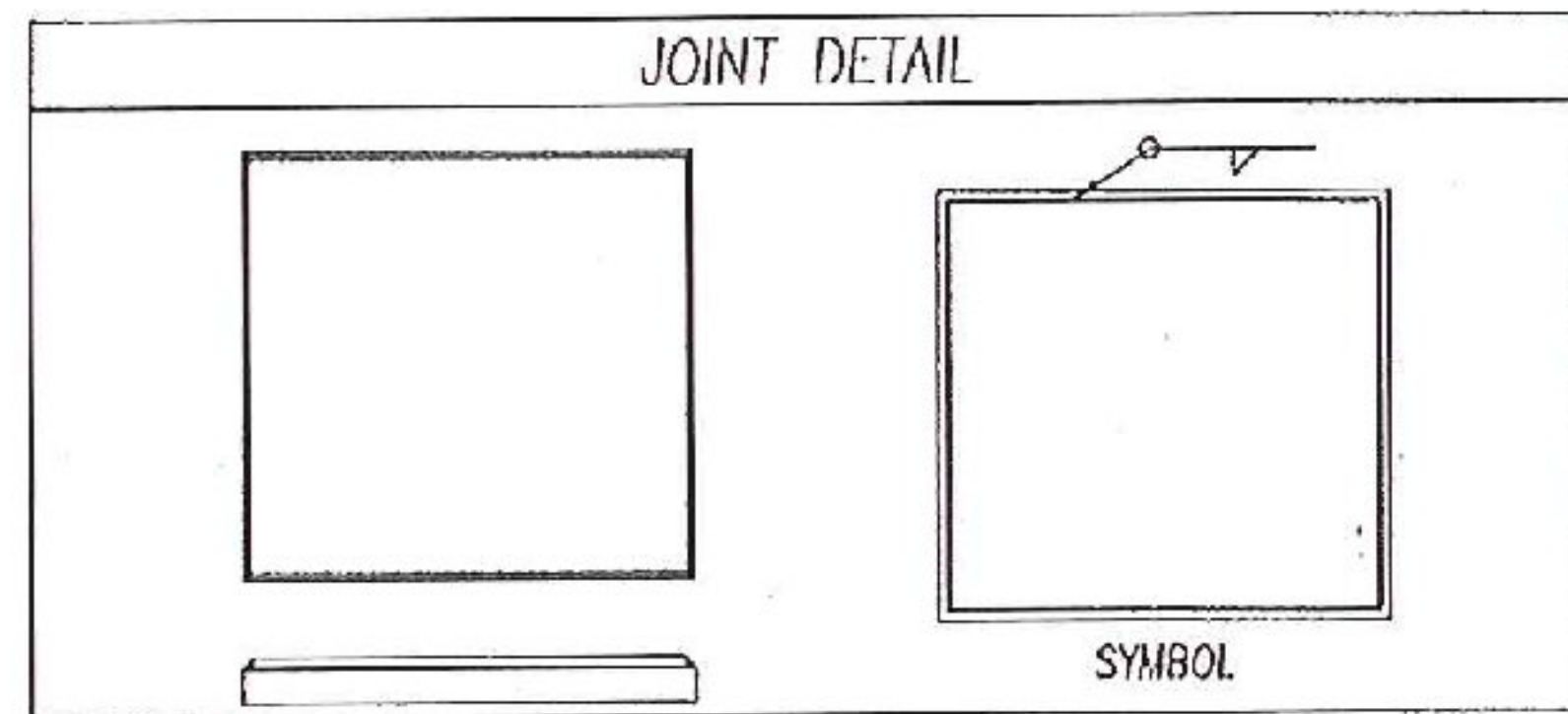
OR

PROCEDURE QUALIFICATION RECORD

Specification No.: 57948 A.L.St. Onge
 Customer: Standard Fusion of T-304 to CS Backing Plate Customer P.O.#: Signed Quote
 Base Metals: A709 Gr345 P-NO.: 1 Group NO.: 1 to P-NO.: 8 Group NO.: 1
 Material Specification Type & Grade: T-304 S.S. to Carbon Steel Backing Plate A709 Gr345
 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
 Filler Metal Classification: N/A
 Shielding Gas: Argon 20-30 cfh
 Single or Multiple Pass: Single
 Single or Multiple Arc: Single
 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

CR'D BY _____
 VITANS Received JWC
 OK'd BY _____
 OCT 10 2012
 Rebuilt BY _____ APPROVED DATE 10/29/12

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: Peter Somogyi

Date: 10/9/12