

COSMEC INC.
WELDING PROCEDURE SPECIFICATION

SPECIFICATIONS AND CODE: D1.6 (D1.3)
MATERIAL SPECIFICATION: ASTM A240 TYPE 304 TO ASTM A709 GR 50W
WELDING PROCESS: GTAW
MANUAL OR MACHINE: MANUAL
POSITION OF WELDING: 1F & 2F
FILLER METAL SPECIFICATION: ER309L CLASSIFICATION: A5.9
MANUFACTURER: HARRIS WELCO TRADENAME:
FLUX: INTERNAL
SHIELDING GAS: ARGON FLOW RATE: 45 CFH
SINGLE OR MULTIPLE PASSES: SINGLE
SINGLE OR MULTIPLE ARC: SINGLE
WELDING CURRENT: DC
POLARITY: REVERSE (EN)
WELDING PROGRESSION: _____
ROOT TREATMENT: CLEANED & PREPARED BRIGHT METAL
PREHEAT AND INTERPASS TEMPERATURE: SEE BELOW
POSTHEAT TEMPERATURE: N/A
HEAT INPUT: MIN. _____ MAX. _____

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	TRAVEL SPEED VOLTS	JOINT DETAIL
ALL	3/32"	130-150	14-17	LAP JOINT

18 GA THRU 10 GA
BM THICKNESS

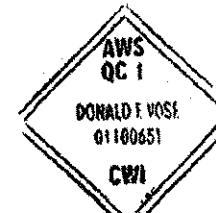
PREHEAT TEMPS. ***PREHEAT UNTIL NO MOISTURE PRESENT
THICKNESS TTEMP.
UP TO 3/4" 100 DEG.
OVER 3/4" TO 1 1/2" 100 DEG.
OVER 1 1/2" TO 2 1/2" 100 DEG.
OVER 2 1/2" 100 DEG.

THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS SIZE, ETC.
WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 5.
SUPPORTING PQR: GTAW-WF-05
PROCEDURE NO. GTAW-WF

CONTRACTOR: COSMEC INC.
AUTHORIZED BY: DONALD VOSE
CW# 01100651 *Donald Vose*

REVISION NO. 1

DATE: 2/1/2005



VTRANS
RECEIVED
OK'D BY *JWC*

APR 11 2005
RESUBMIT APPROVED *JWC*
BY DATE 4-13-05

TOTAL P. 01