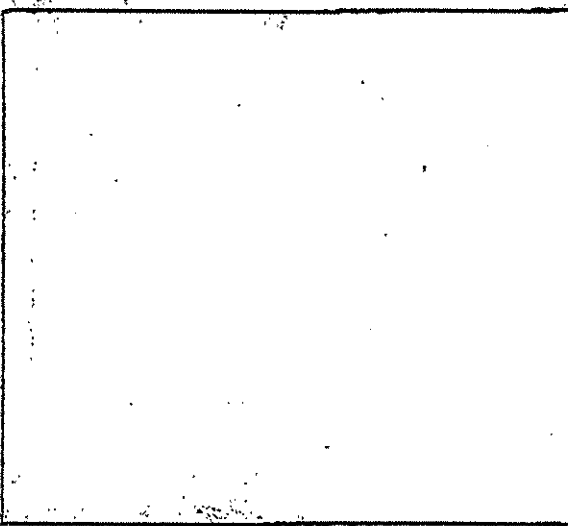


Appendix E/131

WELDING PROCEDURE SPECIFICATION (WPS)

Welding procedure specification no. <u>AL-100</u>		Date <u>10-30-90</u>	Approved _____
Revisions _____	Date _____	Approved _____	Approved _____
Supporting PQR Numbers: <u>AL-100</u>			
Joints Groove Design Sketch 	Filler metal	F-No. <u>22</u>	AWS No. <u>A5.10-80</u>
		Size of electrode <u>.035"</u>	Class _____
		Type of electrode <u>ER 5356</u>	Other _____
		Shielding gas	Shielding gas(es) <u>ARGON</u>
		Flow rate <u>35 cfh</u>	Other _____
Backing	Type _____	Permanent _____	Removed _____
Other _____	Position <u>FLAT</u>	Welding progression _____	Other _____
Base Metals	Group no. <u>3</u>	Thickness <u>1/8" MIN.</u>	Preheat
Alloy and temper <u>G061-T6 OR G063-T6</u>			Preheat temperature <u>N/A</u>
			Interpass temperature <u>N/A</u>