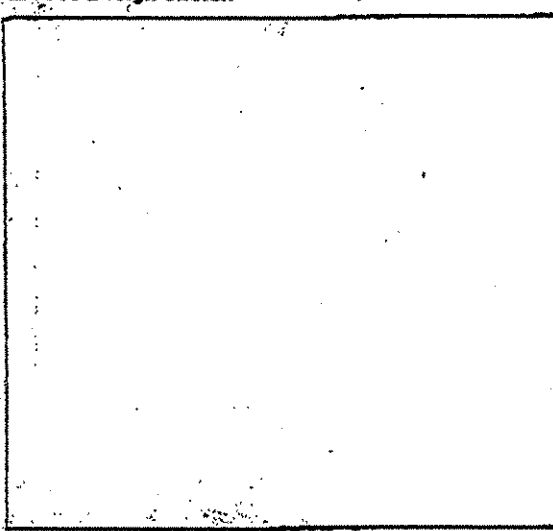


WELDING PROCEDURE SPECIFICATION (WPS)

Welding procedure specification no. <u>AL-100</u> Date <u>10-30-90</u> Approved _____		
Revisions _____	Date _____	Approved _____
Supporting QR Numbers <u>AL-100</u>		
Joints		Filler metal
Stroke Design Sketch 		F-No. <u>22</u> AWS No. <u>A5.10-80</u> Class _____
		Size of electrode <u>.035"</u>
		Type of electrode <u>ER 5356</u>
		Other _____
		Shielding gas _____
		Shielding gas(es) <u>ARGON</u>
		Percent composition <u>100%</u>
		Flow rate <u>35 cfh</u>
		Other _____
Backing		Position _____
Type _____		Position <u>FLAT</u>
Permanent _____		Welding progression _____
Removed _____		Other _____
Other _____		
Base Metals		Preheat
Group no. <u>3</u> Thickness <u>1/8" MIN.</u>		Preheat temperature <u>N/A</u>
Alloy and temper <u>6061-T6 OR 6063-T6</u>		Interpass temperature <u>N/A</u>