

**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: MANU
 POSITION OF WELDING: 1F & 2F
 FILLER METAL SPECIFICATION: N/A
 MANUFACTURER: CLASSIFICATION: N/A
 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

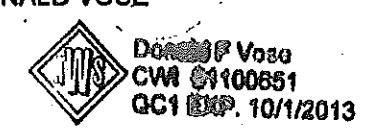
PASS NO.	ELECTRODE SIZE	WELDING CURRENT AMPERES	VOLTS	TRAVEL SPEED	JOINT DETAIL
ALL	3/32"	130-165	14-17	11-12 IPM	LAP JOINT

PREHEAT TEMPS. ***PREHEAT UNTIL NO MOSITURE PRESENT

THICKNESS	TEMP.
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-WOF-06
 PROCEDURE NO. GTAW-WOF
 CONSTRUCTOR: COSMEC INC.
 AUTHORIZED BY: DONALD VOSE
 CWI#: 01100651

REVISION NO. 2
 DATE: 2/19/2010



VTRAW RECEIVED
 CKD BY: OK'D BY: JWC
 DEC 06 2010
 RECEIVED APPROVED
 BY: DATE: 12/06/10

Steinhilber
 12/06/10