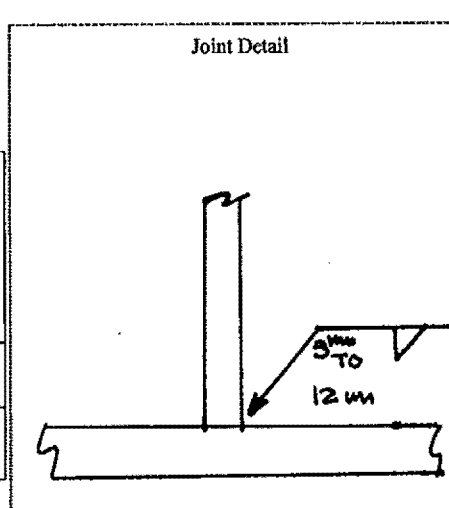


AUCIELLO IRON WORKS, INC.
 560 Main Street
 Hudson, MA 01749
 Phone: 978-568-8382
 Fax: 978-662-5982
 Aucielloiron.com

Aluminum Production Joint Welding Procedure Specification
 Procedure No: 2011-01 Date Issued: 06/06/2011
 Revision No: Rev. Date: D1.2-2003

- Contractor (Fabricator) Auciello Iron Works Prepared by: Philippe Lefebvre QC
- Referenced PQR No(s) 10
- Base Metal M Num. & Alloy 23 Temper 6061-T6
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- Base Metal Thickness (es) 3 mm To 12 mm
- Welding process(es): GMAW X GTAW PAW-VP
- Manual Machine Semiautomatic
- Position(s) of welding 2F
- Filler metal F number 23
- Filler metal classification and brand name ALCOTEC/HARRIS ER 5356
- Shielding gas 75% HELIUM 25% ARGON Flow rate (cfh)
- Single or multiple pass MULTIPLE
- Polarity DCEP
- Welding progression FOREHAND
- Stringer X Weave Backing Type
- Root treatment
- Postheat treatment
 Original Temper Final Temper Temperature
 Time Quench
- AWS A5.12 Tungsten Electrode Class
- Initial Cleaning: Oxide SS WIRE BRUSH Oil & Dirt SOLVENT
- Interpass Cleaning: Oxide SS WIRE BRUSH

Weld Process	Weld Size	Pass No(s)	Electrode Dia	Electrode Size	Welding Process Variables		Travel Speed
					AMPS/WRS	VOLTS	
GMAW	1/2"	ALL	1/8"	116-174	21-29	18-26	



*Wire feed speed may be used along with amperage (include chart)
 Preparer's Signature: *[Signature]*

Minimum preheat (°F)	Max Preheat & Interpass (°F)	Maximum Heat Exposure Time
50	150	250

VPTRANS
RECEIVED
 OK'D BY: *[Signature]*
 JUN 06 2011
 RESUBMIT APPROVED *[Signature]*
 DATE 06/13/11