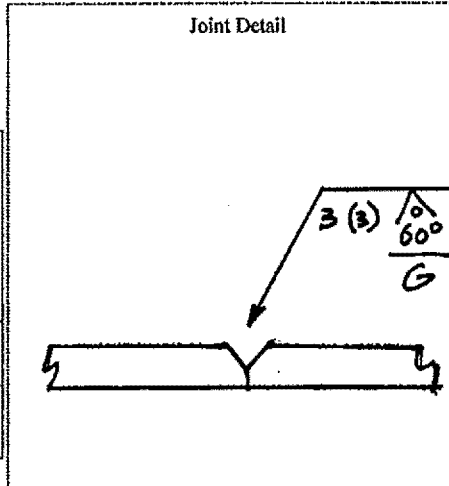


AUCIELLO IRON WORKS, INC.
 560 Main Street
 Hudson, MA 01749
 Phone: 978-568-8382
 Fax: 978-662-9982
 AucielloIron.com

Aluminum Production Joint Welding Procedure Specification
 Procedure No: 2011-02 Date Issued: 06/06/2011
 Revision No: _____ Rev. Date: _____ D1.2-2003

1. Contractor (Fabricator) Auciello Iron Works Prepared by: Phillipa Lefebvre QC
2. Referenced PQR No(s) 10
3. Base Metal M Num. & Alloy 23 Temper 6061-T6
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5. Base Metal Thickness (es) 3 mm To 12 mm
6. Welding process(es): GMAW GTAW _____ PAW-VP _____
7. Manual , Machine , Semiautomatic
8. Position(s) of welding 1G
9. Filler metal F number 23
10. Filler metal classification and brand name ALCOTEC/HARRIS ER 5356
11. Shielding gas 75%HELIUM 25% ARGON Flow rate (cfh) _____
12. Single or multiple pass MULTIPLE
13. Polarity DCEP
14. Welding progression FOREHAND
15. Stringer Weave _____ Backing Type _____
16. Root treatment _____
17. Postheat treatment _____
 Original Temper _____ Final Temper _____ Temperature _____
 Time _____ Quench _____
18. AWS A5.12 Tungsten Electrode Class _____
19. Initial Cleaning: Oxide SS WIRE BRUSH Oil & Dirt SOLVENT
20. Interpass Cleaning: Oxide SS WIRE BRUSH

| Weld Process | Weld size | Pass No(s) | Electrode Ext | Electrode Size | Welding Process Variables | | Travel Speed |
|--------------|-----------|------------|---------------|----------------|---------------------------|-------|--------------|
| | | | | | AMPS/AWS | VOLTS | |
| GMAW | 2 | AL | 1/2" | .035 | 116-174 | 21-29 | 10-26 |



*Wire feed speed may be used along with any angle (include chart)
 Preparer's Signature: _____
 Additional Notes:

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

RECEIVED

OK'D BY _____ OK'D BY JWC
 JUN 06 2011
 RESUBMIT _____ APPROVED _____
 BY _____ DATE 06/13/11