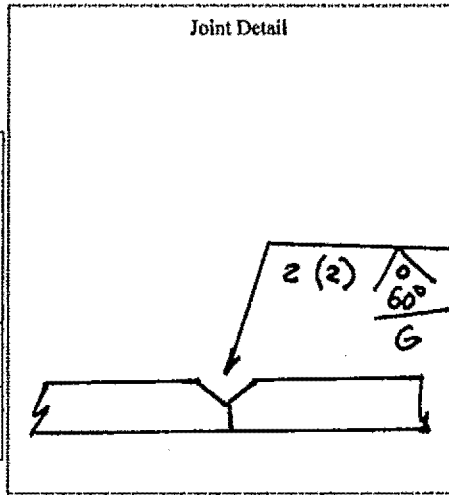


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Aluminum Production Joint Welding Procedure Specification
 Procedure No: 2011-01 Date Issued: 06/06/2011
 Revision No: _____ Rev. Date: _____ D1.2-2003

1. Contractor (Fabricator) Auciello Iron Works Prepared by: Phillippe 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 (as) 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	Puls. No. (Hz)	Electrode Ext.	Electrode Size	Welding Process Variables		Travel Speed
					AMPS/WFS	VOLTS	
GMAW	3	AL	1/2"	.025	116-174	21-29	18-26



*Wire feed speed may be used along with apparatus (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 _____ ON'D BY JWC
 JUN 06 2011
 RESUBMIT _____ APPROVED _____
 BY _____ DATE 06/13/11