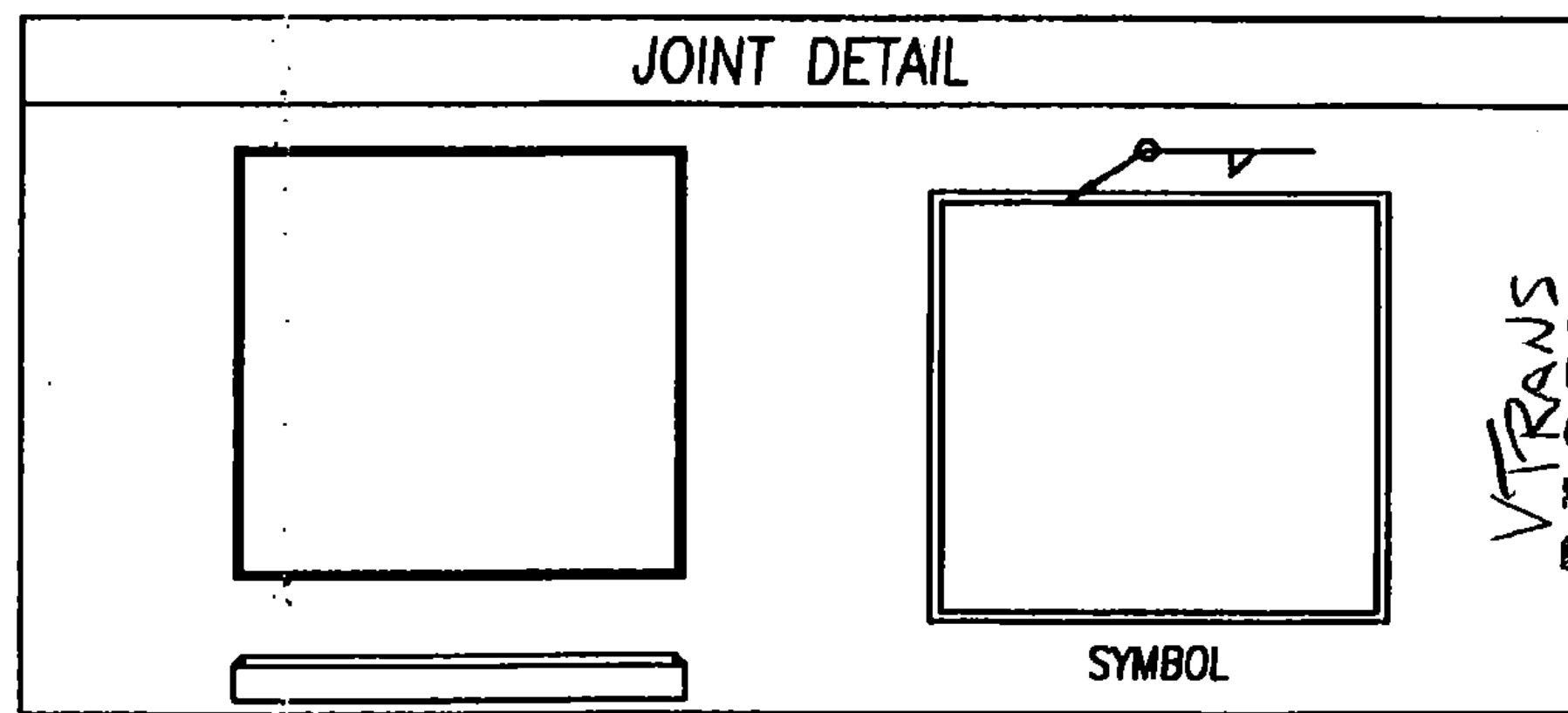


WELDING PROCEDURE SPECIFICATION BRIDGEWATER
OR
PROCEDURE QUALIFICATION RECORD BRS 0149 (4)

Specification No.: 57948 Miller Construction, Inc.
 Customer: Standard Fusion of T-304 to CS Backing Plate Customer P.O.#: P.O. No. #62810
 Base Metals: _____ P-NO.: 8 Group NO.: _____ to P-NO.: 1 Group NO.: 1
 Material Specification Type & Grade: T-304 S.S. to Carbon Steel Backing Plate
 Welding Process: G.T.A.W. 1/2" dia. nozzle w/gas lens
 Manual or Machine: Manual
 Position of Welding: 1G Flat
 Filler Metal Specification: N/A
 Filler Metal Classification: N/A
 Shielding Gas: Argon 20-30 cfh
 Single or Multiple Pass: Single
 Single or Multiple Arc: Single
 Welding Current: Direct
 Polarity: Straight
 Root Treatment: Remove all oil, grease, scale etc. on weld preparation face and adjacent plate surface
 Preheat and Interpass Temp: N/A
 Post weld Heat Treatment: N/A

Filler Metal			Pass No.	Process	Welding Current		Fillet Size
Class	Dia.	F.No.			Amperes	Voltage	
N/A	N/A		1	G.T.A.W.	100-170	19-23	Fuse Materials



VTRANS RECEIVED
 OK'D BY JWC
 SEP 22 2010
 RESUBMIT APPROVED ✓
 DATE 9/29/10
 BY _____

Manufacturer: Amscot Structural Products Authorized By: [Signature]
 Date: 8/19/10