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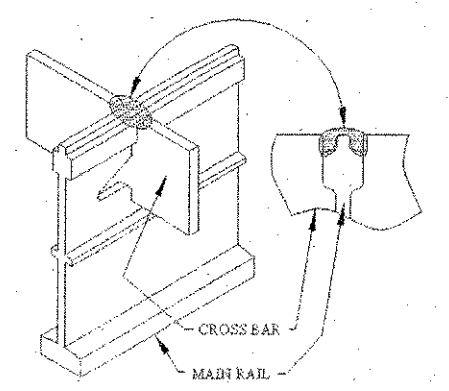
ISI WELDING PROCEDURE SPECIFICATION

| | | | |
|-------------------------------|---|-----------|------------------|
| Proc. Qual. Record No. (PQR#) | IDSI-6 | | |
| Material Specification | ASTM A36, A588, A709 Gr 36, A709 Gr 50, A709 Gr 50W, A572 Gr50 or A992 - as per approved shop drawings. | | |
| Welding Process | GMAW | | |
| Manual or Semi-auto | Semi-automatic | | |
| Position of Welding | 1G - Flat | | |
| Filler Metal Specification | AWS A5.18 | | |
| Filler Metal Classification | AWS ER70S-6 | | |
| Electrode and Manufacturer | ESAB Spoolarc 86 | | |
| Shielding Gas | 85% Argon 15% CO2 | Dew Point | -40degree F Min. |
| Flow Rate | 40 cfh | | |
| Single or Multiple Pass | Single | | |
| Single or Multiple Arc | Single | | |
| Welding Current | DC | | |
| Polarity | Reverse | | |
| Welding Progression | NA | | |
| Root Treatment | Wire brush as necessary to remove foreign material | | |
| Preheat and Interpass Temp. | 50 degree F min to 400 degree F Max | | |
| Postheat Temperature | None | | |
| Heat Input | 25.5 kJ/in Min. to 36 kJ/in Max. | | |

DATE 11-5-07

NOTES:

WELDING PROCEDURE

| Pass no. | Electrode size | Welding Parameters | | Travel speed | MAIN RAIL PUDDLE WELD JOINT DETAIL |
|----------|----------------|--------------------|---------|---------------|---|
| | | Amperes | Volts | | |
| All | .045 | 257-300 | 26.5-29 | 14.5 - 16 IPM |  |

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in AWS D1.3, Section 5A.

Procedure no. IDSI-6-1A Fabricator Interlocking Deck Systems International, LLC
 Revision no. 1 Authorized By Brad King CWI #02100701
 Date 08-07-2006

051-PGW/P