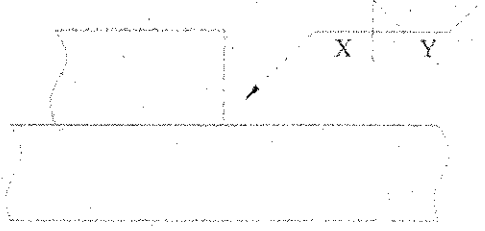


# ISI WELDING PROCEDURE SPECIFICATION

DESIGNED BY: Juc  
 DATE: OCT 29 2007  
 APPROVED BY: [Signature]  
 DATE: 11-5-07

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	2F - Horizontal			
Filler Metal Specification	AWS A5.18			
Filler Metal Classification	AWS ER70S-6			
Electrode and Manufacturer	ESAB Spoolarc 86			
Shielding Gas	85% Argon 15% CO <sub>2</sub>	Dew Point	-40degreeF Min.	Flow Rate 40 cfh
Single or Multiple Pass	Single (see chart below)			
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.			

NOTES:

Pass no.	Electrode size	Welding Parameters		Travel speed	FILLET WELD JOINT DETAIL
		Amperes	Volts		
1	.045	257-300	26.5-29	14.5 - 16 IPM	
Number of Passes Based on Fillet Weld Size					
Weld Size "X"		Number of Passes			
3/16" (5mm)		Single			
1/4" (6mm)		Single			
5/16" (8mm)		Single			

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

Procedure no. IDSI-6-5A Fabricator Interlocking Deck Systems International, LLC  
 Revision no. 2 Authorized By Brad King CWI #02100701  
 Date 05-04-2007

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