

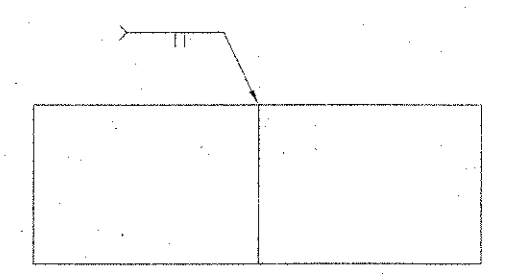
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 DATE: 11-5-07

**ISI** WELDING PROCEDURE SPECIFICATION

RESUBMIT: \_\_\_\_\_ APPROVED: [Signature]  
 BY: \_\_\_\_\_ 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	1G - Flat			
Filler Metal Specification	AWS A5.18			
Filler Metal Classification	AWS ER70S-6			
Electrode and Manufacturer	ESAB Spoolarc 86			
Shielding Gas	85% Argon	Dew Point	-40degreeF Min.	Flow Rate 40 cfm
	15% CO2			
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.			

**NOTES:**  
 1) Weld finish (grind or not) according to approved shop drawings.  
 2) Weld size as per approved shop drawings.

Pass no.	Electrode size	Welding Parameters		Travel speed	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 D1.5, Section 5A.

Procedure no. IDSI-6-100B Fabricator Interlocking Deck Systems International, LLC  
 Revision no. 0 Authorized By Brad King CWI #02100701  
 Date 10-24-2007

058-DGWP