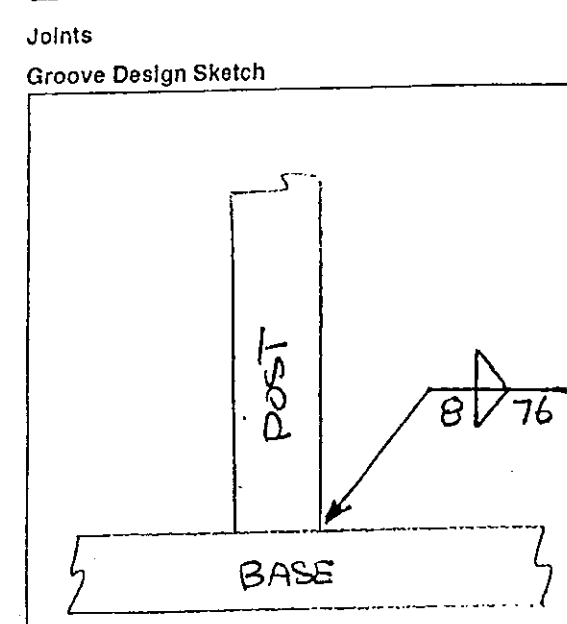


WELDING PROCEDURE SPECIFICATION (WPS)

Welding Procedure Specification No. 2009-01 Date 8/13/2009 Approved Philippe Lefebvre
 Revisions _____ Date _____ Approved _____

 Supporting PQR Numbers 40



Filler Metal
 F-No. 23 AWS No. ER 5356
 Size of electrode 3/64
 Type of electrode ALUMINUM
 Other _____
 Shielding Gas
 Shielding gas(es) HELIUM - ARGON
 Percent composition 75% - 25%
 Flow rate 40 TO 75 CFH
 Other _____

Backing
 Type N/A
 Permanent _____
 Removed _____
 Other _____

Position
 Position of groove FILLET - 2F
 Welding progression FOREHAND
 Other _____

Base Metals
 M No. 23 Thickness 3mm to 25mm
 Alloy and Temper 6061-T6

Preheat
 Preheat temperature 150° F
 Interpass temperature _____

Form E1a
RECEIVED
 CK'D BY _____
 SEP 29 2009
 BY _____ DATE 10/14/09

RECEIVED
 CK'D BY _____
 AUG 24 2009
 BY we DATE 8/15/09

RECEIVED
 CK'D BY _____
 SEP 8 2009
 BY _____ DATE _____