
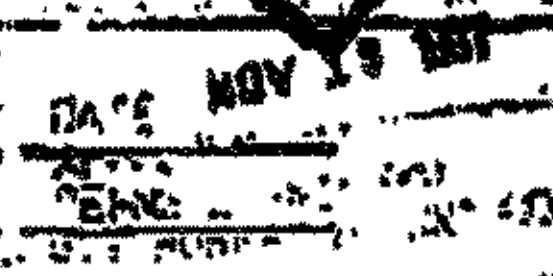
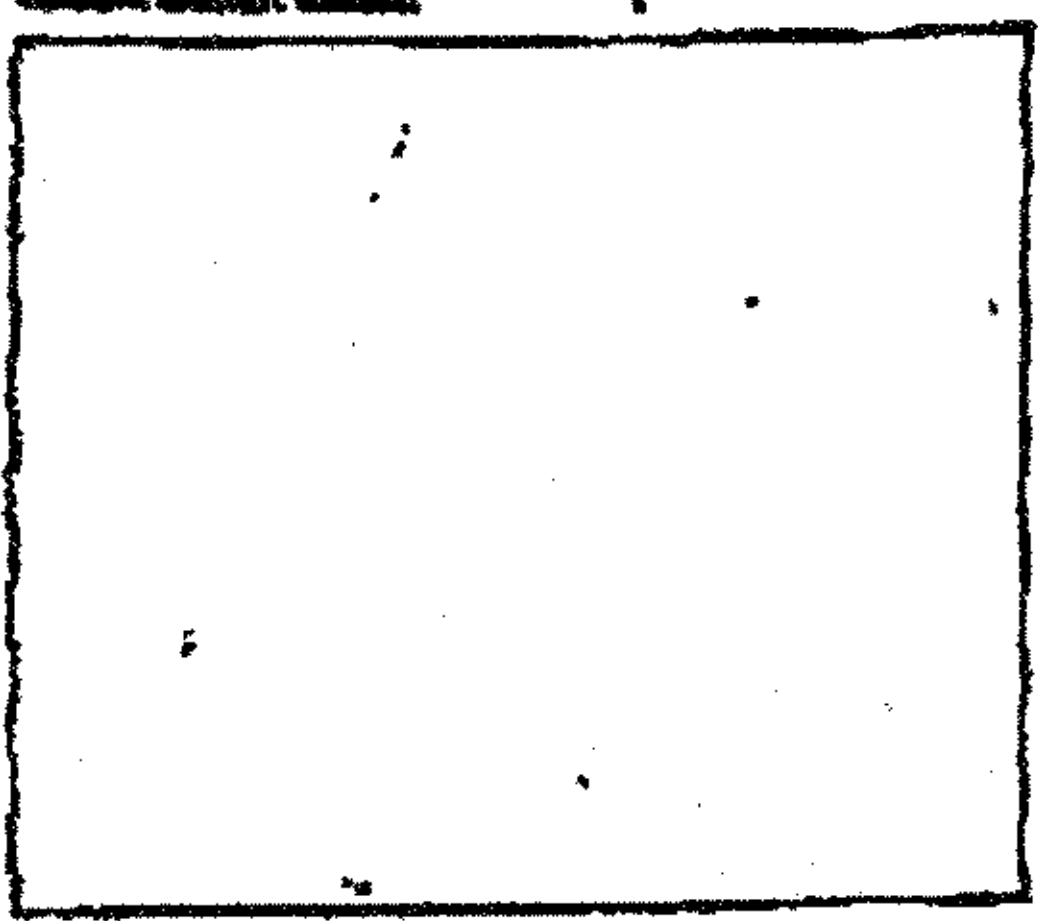


WELDING PROCEDURE SPECIFICATION (WPS)

Welding procedure specification no. <u>AL-102</u> Date <u>10-4-96</u> Approved _____	
Revisions <u>1</u> Date <u>11-14-97</u> Approved _____	
	
Supporting PCM Number: <u>AL-100</u>	
	
Joint Group Section Sketch 	Filler metal P-No. <u>22</u> AWS No. <u>ER5356</u>
	Size of electrode <u>.035"</u> Type of electrode <u>BARE WIRE</u> Other _____
Beading Type _____ Removal _____ Other _____	Shielding gas <u>ARGON</u> Shielding gas(es) <u>100%</u> Flow rate <u>35 cph</u> Other _____
	Position <u>HORIZONTAL (2F)</u> Position <u>FOREHAND</u> Welding progression _____ Other _____
Base Metal Group no. <u>3</u> Thickness <u>1/8" MIN.</u> Alloy and temper <u>6061-T6 OR 6063-T6</u>	Preheat Preheat temperature <u>N/A</u> Interpass temperature <u>N/A</u>