

BCCM

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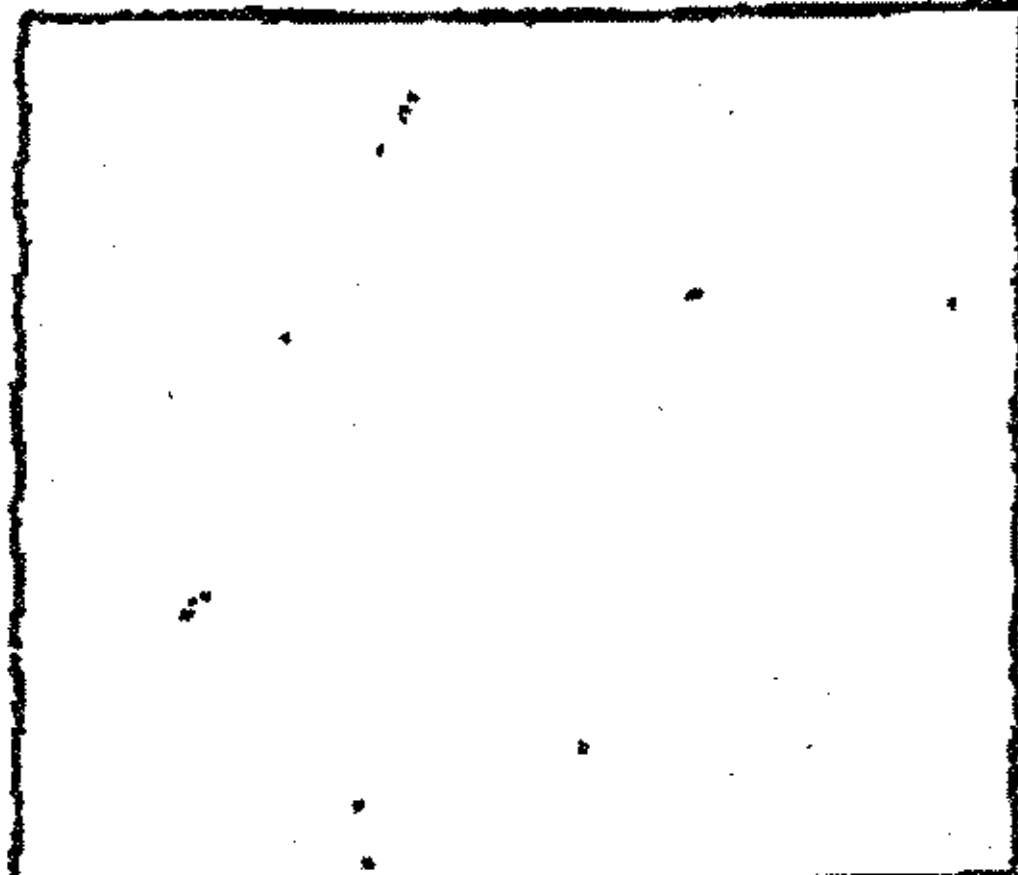
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ROBERT HUNT PIT

WELDING PROCEDURE SPECIFICATION (WPS)

Welding procedure specification no. <u>AL-103</u> Date <u>10-30-90</u> Approved _____	
Revision <u>1</u> Date <u>11-14-97</u> Approved _____	
Supporting PQR Number <u>AL-100</u>	
Joint Cross Section Sketch 	Filler metal F-No. <u>22</u> AWS No. <u>ER5356</u>
	Size of electrode <u>.035"</u> Type of electrode <u>BARE WIRE</u> Other _____
Shielding gas Shielding gas(es) <u>ARGON</u> Percent composition <u>100%</u> Flow rate <u>35 cfh</u> Other _____	Position Position <u>FLAT (IF)</u> Welding progression <u>FORWARD</u> Other _____
Base Metals 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>

APPROVED
ROBERT F. HUNT
DATE NOV 13 1997