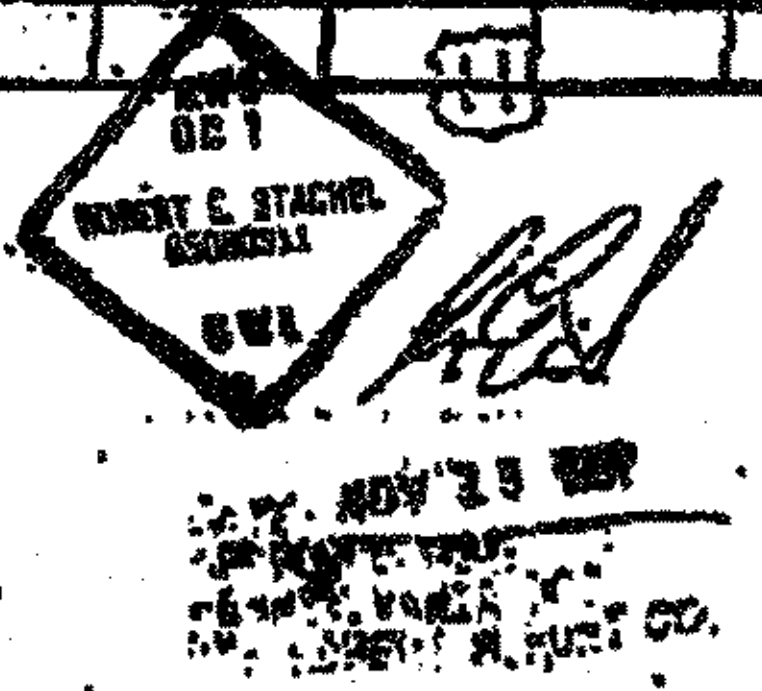
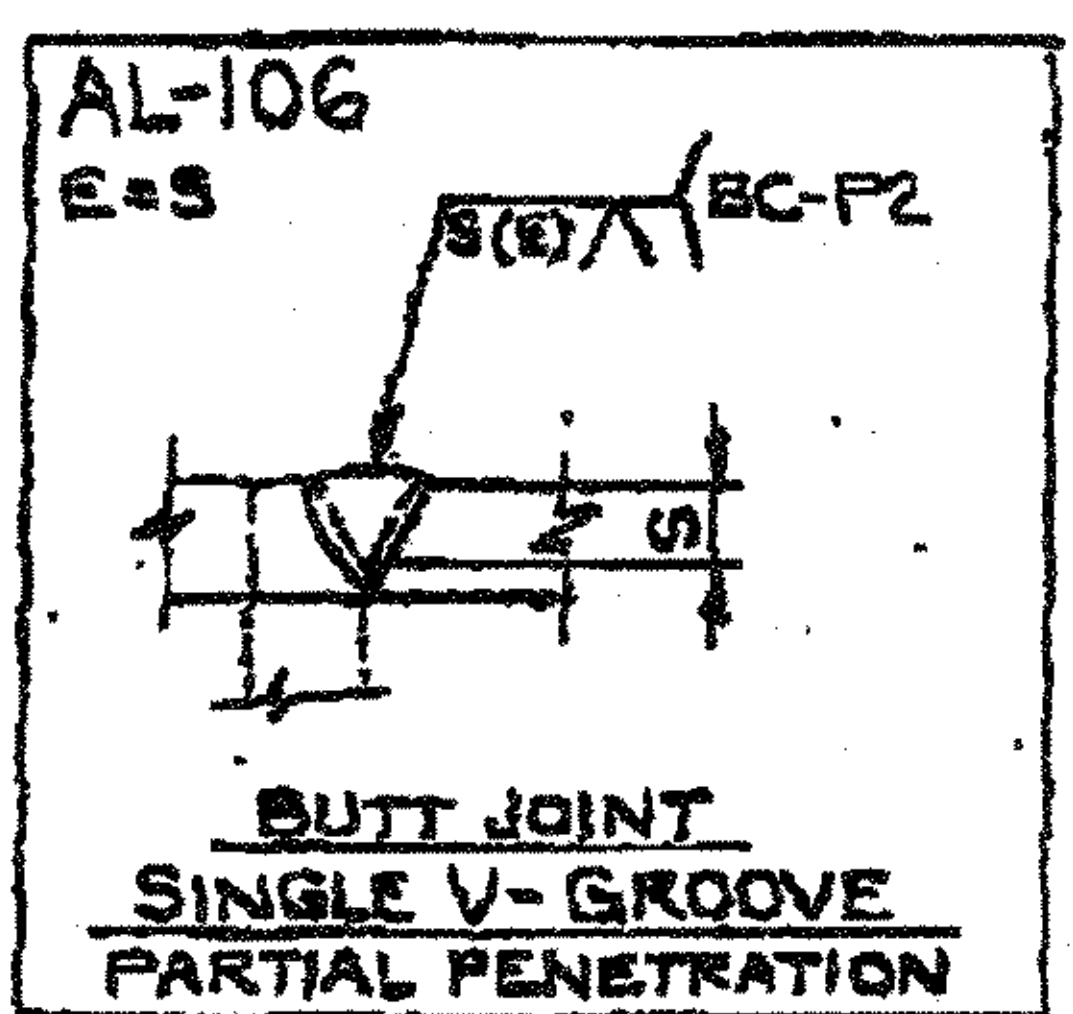


L. O. FUSNER CO.  
 R.D.#2 BOX C  
 BEDFORD INDUSTRIAL PARK  
 BEDFORD, PA, 15522

WELDING PROCEDURE SPECIFICATION (WPS AL-106)

Cleaning Initial cleaning method <u>WIRE BRUSH</u> Initial cleaning oil and dirt <u>SAME</u> Interpass cleaning _____ Post Weld Heat Treatment _____ Original temper <u>N/A</u> Final temper <u>N/A</u> Temperature <u>N/A</u> Time <u>N/A</u> Quench <u>N/A</u>	<table border="1"> <thead> <tr> <th>S</th> <th>Pass No.</th> <th>Welding process</th> <th>Temp</th> <th>Volts</th> <th>Travel speed</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>1</td> <td>GMAW</td> <td>160</td> <td>23</td> <td>20-37%</td> </tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> </tbody> </table>	S	Pass No.	Welding process	Temp	Volts	Travel speed	1	1	GMAW	160	23	20-37%																																																						
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Process(es) Process <u>GMAW</u> Type <u>SEMI-AUTOMATIC</u> Process _____ Type _____ Electrode (GTAW) _____ Technique Stringer or weave bead <u>STRINGER</u> Orifice of gas cup size <u>5/8" DIAMETER</u> Gas flow <u>NO</u> Contact tube to work distance <u>1/2"</u> Single pass or multipass <u>SINGLE OR MULTIPASS</u> Tungsten extension <u>N/A</u> Method of backgauging <u>N/A</u> Other _____ _____ _____																																																																			
_____ _____ _____	 <p>BUTT JOINT                  SINGLE V-GROOVE                  PARTIAL PENETRATION</p> <p>Sketch of welding sequence</p>																																																																		