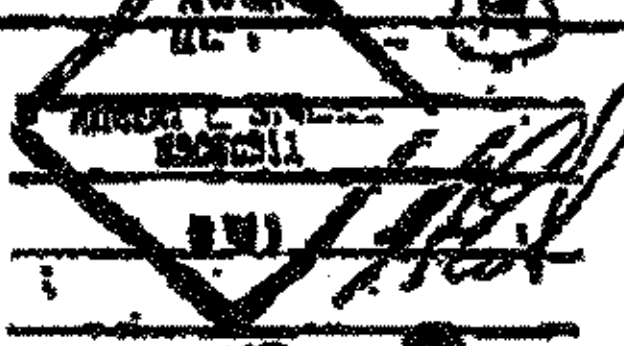
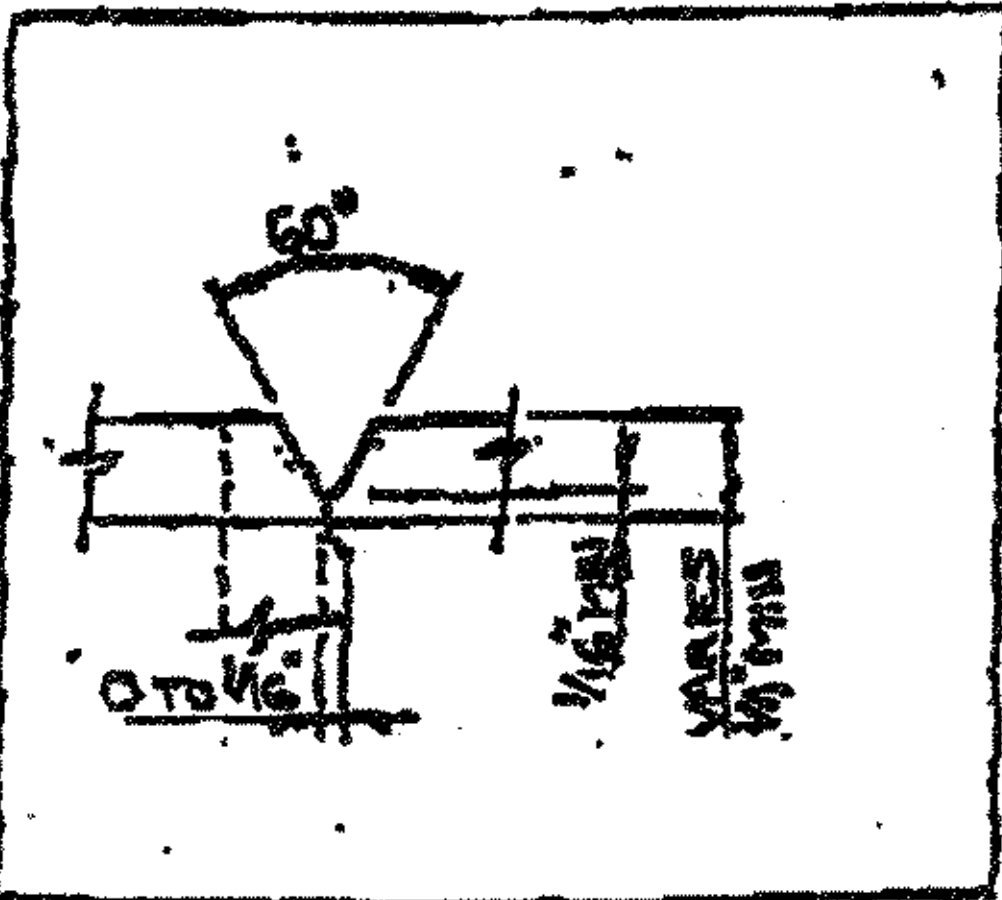


WELDING PROCEDURE SPECIFICATION (WPS)

Welding procedure specification no. <u>AL-106</u> Date <u>7-19-90</u> Approved _____ Revisions <u>1</u> Date <u>11-16-97</u> Approved _____ _____ _____ _____		
Supporting AWS Number <u>AL-100</u>		
DATE: <u>NOV 19 1997</u> APPROVED BY: _____ BY: <u>ROBERT W. HUNT</u>		
Joint Drawn Design Sheet	Filler metal Size <u>22</u> AWS No. <u>ER 5356</u>	
	Size of electrode <u>.035</u> Type of electrode <u>BARE WIRE</u> Other _____	
	Shielding gas Shielding gas(es) <u>ARGON</u> Argon composition <u>100%</u> Flow rate <u>35 cfm</u> Other _____	
Beading Type _____ Penetration _____ Reinforced _____ Other _____	Position Position of groove <u>FLAT (IG)</u> Welding progression <u>FOREHAND</u> Other _____	
Base Metal Group no. <u>3</u> Thickness <u>1/4" 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>	