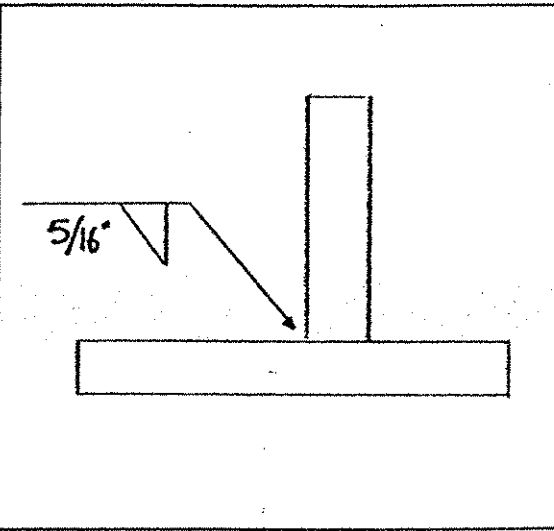


WELDING PROCEDURE SPECIFICATION (WPS) #44

Welding Procedure Specification No. #44 Date 03.01.02 Approved Philippe
 Revisions _____ Date _____ Approved _____
 Supporting PQR Numbers #15

Joints
 Groove Design Sketch


Filler Metal
 F-No. E22 AWS No. ER 5556
 Size of electrode .045 ± 1/64
 Type of electrode Aluminum
 Other _____

Shielding Gas
 Shielding gas(es) Helium - Argon
 Percent composition 15% - 25%
 Flow rate 55 CFH (+50% - 20%)
 Other _____

Backing
 Type _____
 Permanent _____
 Removed _____
 Other _____

Position
 Position of groove Fillet - 2F Horizontal
 Welding progression Forehand
 Other _____

Base Metals
 Group No. M23 Thickness 3/4 to 3/4
 Alloy and Temper 6061-T6

Preheat
 Preheat temperature 50°F Min
 Interpass temperature _____

TRANS RECEIVED
 OK'D BY _____ OK'D BY JWC
 FEB 28 2007
 RESUBMIT _____ APPROVED ✓ 1203R
 BY _____ DATE 3-22-07