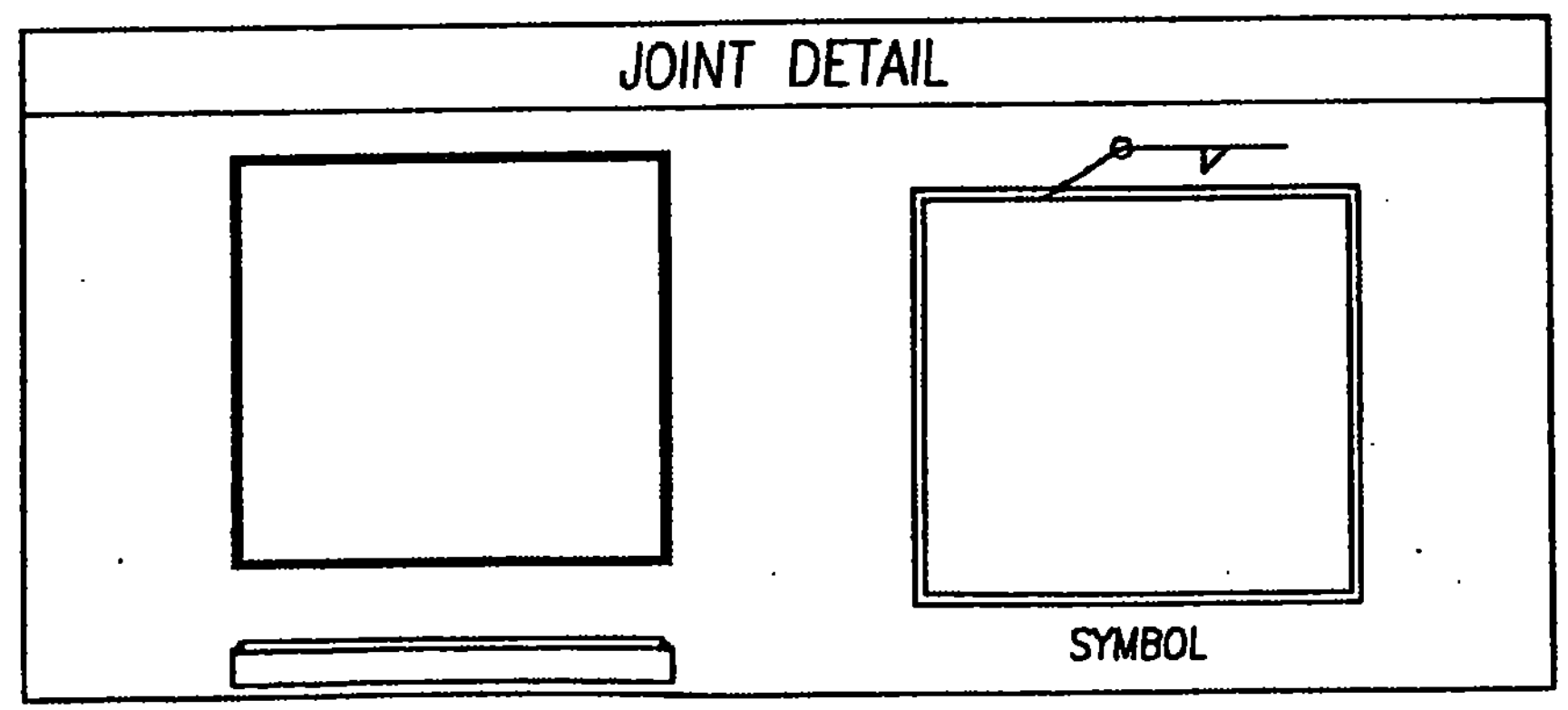


63 BRIDGE
BEARING

WELDING PROCEDURE SPECIFICATION
OR
PROCEDURE QUALIFICATION RECORD

Specification No.: 57948
 Customer: Standard Fusion of T-304 to CS Backing Plate Customer P.O.#: _____
 Base Metals: _____ P-NO.: 8 Group NO.: _____ to P-NO.: 1 Group NO.: 1
 Material Specification Type & Grade: T-304 S.S. to Carbon Steel Backing Plate
 Welding Process: G.T.A.W. 1/2" dia. nozzle w/gas lens
 Manual or Machine: Manual
 Position of Welding: 1G Flat RECEIVED
 Filler Metal Specification: N/A CK'D BY _____ OK'D BY _____
 Filler Metal Classification: N/A JUN 2 2010
 Shielding Gas: Argon 20-30 cfh RESUBMIT _____ APPROVED
 Single or Multiple Pass: Single BY CPW DATE 6/22/10
 Single or Multiple Arc: Single
 Welding Current: Direct
 Polarity: Straight
 Root Treatment: Remove all oil, grease, scale etc. on weld preparation face and adjacent plate surface
 Preheat and Interpass Temp: N/A
 Post weld Heat Treatment: N/A

Filler Metal			Pass No.	Process	Welding Current		Fillet Size
Class	Dia.	F No.			Amperes	Voltage	
N/A	N/A		1	G.T.A.W.	100-170	19-23	Fuse Materials



Manufacturer: Amscot Structural Products Authorized By: _____
 Date: _____