

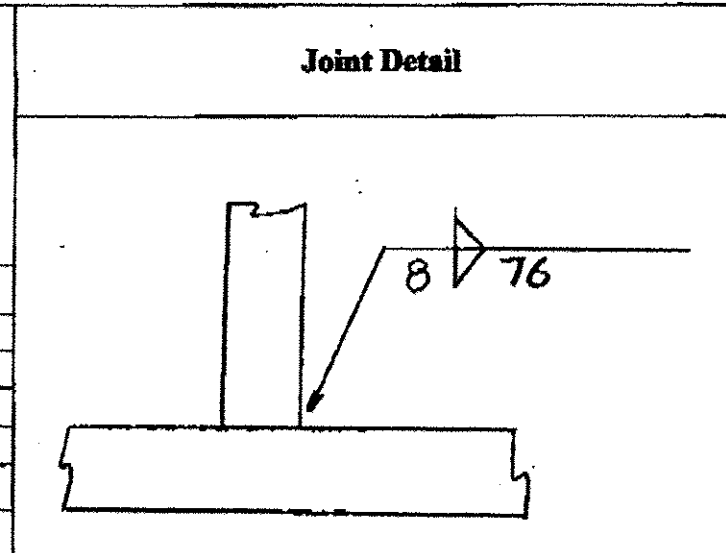
AUCIELLO IRON WORKS, INC.
 560 Main Street
 Hudson, MA 01749
 Phone: 978-568-8382
 Fax: 978-562-9982

Aluminum Production Joint Welding Procedure Specification
 Procedure No: 2010-02 Date Issued: 04/05/2010
 Revision No: Rev. Date: D1.2-2003

1. Referenced PQR No(s): 2007-03
2. Base Metal M Num. & Alloy: M23 Temper: 6061-T6
3. Base Metal M Num. & Alloy: _____ Temper: _____
4. Base Metal Thickness: 19 MM To 25.4 MM
5. Welding process: GMAW GTAW
6. Manual, machine, or semiautomatic: SEMI AUTO
7. Position(s) of welding: 2F
8. Filler metal F number: F22
9. Filler metal classification: ER3356 ALCOTEC/HARRIS
10. Shielding gas: 75% HELIUM - 25% ARGON Flow rate: _____
11. Single or multiple pass: SINGLE
12. Polarity: DCEP
13. Welding progression: FOREHAND
14. Stringer Weave _____ Backing Type _____
15. Root treatment _____
16. Postheat treatment _____
17. AWS A5.12 Tungsten Electrode Class _____
18. Initial Cleaning: Oxide SS WIRE BRUSH Oil & Dirt SOLVENT
19. Interpass Cleaning: Oxide SS WIRE BRUSH

Additional Shop Notes:
 TRANS RECEIVED
 APR 08 2010
 APPROVED BY [Signature]
 WITE 4/20/10

| Weld size | Pass No(s) | Electrode Ext. | Electrode Size | Welding Process Variables | | Travel Speed |
|-----------|------------|----------------|----------------|---------------------------|-------|--------------|
| | | | | AMPS | VOLTS | |
| 8 | ALL | 1/2 | .035 | 221-299 | 24-33 | 29-43 |
| 8 | ALL | 1/2 | .045 | 221-299 | 24-33 | 29-43 |
| | | | | | | |
| | | | | | | |



Preparer's Signature: [Signature]

Preheat and Interpass Temperature Chart

| Minimum preheat (°) | Max Preheat & Interpass (°) | Maximum Heat Exposure Time |
|---------------------|-----------------------------|----------------------------|
| 150 | 250 | |