

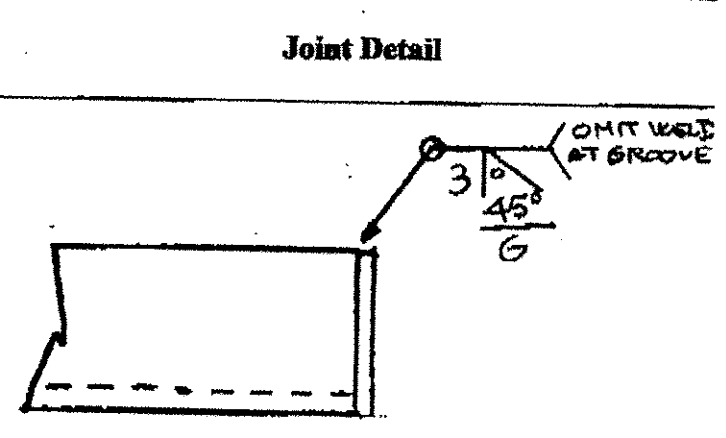
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Aluminum Production Joint Welding Procedure Specification
 Procedure No: 2010-01 Date Issued: 04/05/2010
 Revision No: _____ Rev. Date: _____ D1.2-2003

- Referenced PQR No(s): 2007-03
- Base Metal M Num. & Alloy M23 Temper 6061-T6
- Base Metal M Num. & Alloy _____ Temper _____
- Base Metal Thickness: 6 MM To 12.7 MM
- Welding process: GMAW X GTAW _____
- Manual, machine, or semiautomatic: SEMI AUTO
- Position(s) of welding: 1G
- Filler metal F number: F22
- Filler metal classification: ER5356 ALCOPEC/HARRIS
- Shielding gas: 75% HELIUM - 25% ARGON Flow rate _____
- Single or multiple pass: MULTIPLE
- Polarity: DCEP
- Welding progression: FORRHAND OK BY: JWC
- Stringer X Weave _____ Backing Type _____
- Root treatment _____
- Postheat treatment _____ RESUBMIT _____ APPROVED ✓
 Original Temper _____ Final Temper _____ Temperature BY: OC DATE: 4/21/10
 Time _____ Quench _____
- AWS A5.12 Tungsten Electrode Class _____
- Initial Cleaning: Oxide SS WIRE BRUSH Oil & Dirt SOLVENT
- Interpass Cleaning: Oxide SS WIRE BRUSH

Additional Shop Notes:
 VITRANS RECEIVED
 APR 08 2010
 APPROVED ✓
 DATE 4/21/10

Weld size	Pass No(s)	Electrode Ext.	Electrode Size	Welding Process Variables		Travel Speed
				AMPS	VOLTS	
3/8	ALL	1/2	.035	221-299	24-33	29-43
1/2	ALL	1/2	.045	221-299	24-33	29-43



Preparer's Signature: *[Handwritten Signature]*

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