

WELDING PROCEDURE SPECIFICATION (WPS)

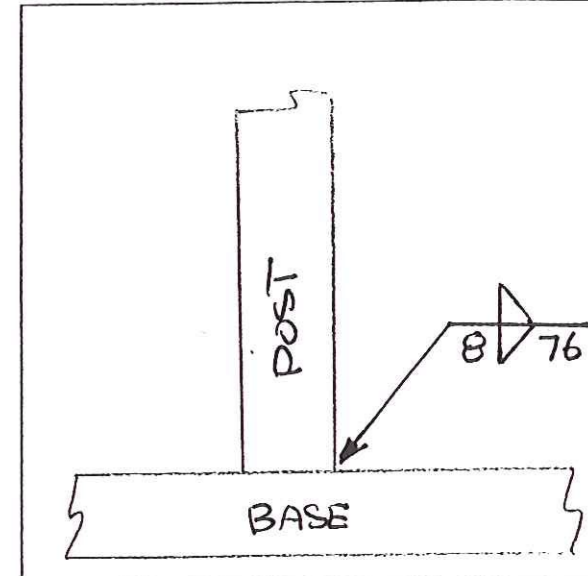
Welding Procedure Specification No. 2009-01 Date 8/13/2009 Approved Philippe Lefebvre

Revisions \_\_\_\_\_ Date \_\_\_\_\_ Approved \_\_\_\_\_

Supporting PQR Numbers 40

Joints

Groove Design Sketch



Backing

Type N/A

Permanent -

Removed -

Other -

Base Metals

M No. 23 Thickness 3mm to 25mm

Alloy and Temper 6061-T6

Filler Metal

F-No. 23 AWS No. ER 5356

Size of electrode 3/64"

Type of electrode ALUMINUM

Other \_\_\_\_\_

Shielding Gas

Shielding gas(es) HELIUM - ARGON

Percent composition 75% - 25%

Flow rate 40 TO 75 CFH

Other \_\_\_\_\_

Position

Position of groove FILLET = 2F

Welding progression FORWARD

Other \_\_\_\_\_

Preheat

Preheat temperature 150° F

Interpass temperature -

TRANS RECEIVED  
OK'D BY JWC  
AUG 24 2009  
APPROVED [Signature]  
DATE 8/13/09