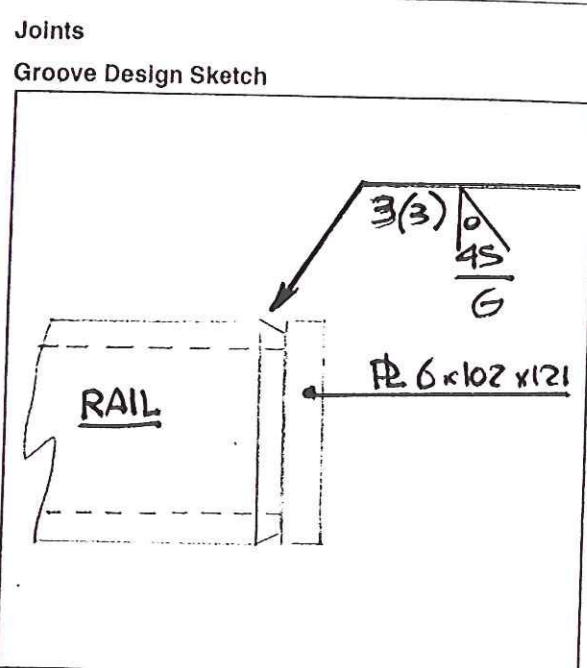


WELDING PROCEDURE SPECIFICATION (WPS)

Welding Procedure Specification No. 2009-02 Date 8/13/2009 Approved Philippe Lefebvre
 Revisions _____ Date _____ Approved _____
 Supporting PQR Numbers 40



Filler Metal
 F-No. 23 AWS No. ER5356
 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 _____

Backing
 Type N/A
 Permanent _____
 Removed _____
 Other _____

Position
 Position of groove = 6G
 Welding progression FOREHAND
 Other _____

Base Metals
 M No. 23 Thickness 3mm to 25mm
 Alloy and Temper 6061-T6

Preheat
 Preheat temperature 150° F
 Interpass temperature VT TRANS

RECEIVED
 CK'D BY _____ OK'D BY JLUC
 AUG 24 2009
 BY me APPROVED ✓
 DATE 8/14/09