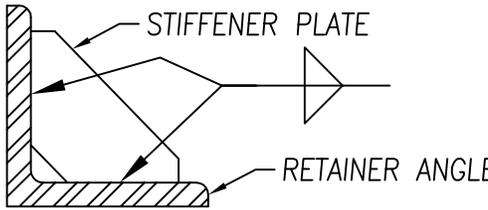


WELDING PROCEDURE SPECIFICATION

OR

PROCEDURE QUALIFICATION RECORD

Specification No.: 55928 A.L.St.Onge
 Customer: Standard Fillet Weld Customer P.O.#: P.O. Signed Quote
 Base Metals: A-709 Gr. 36 P-NO.:1 Group NO.: 1 to P-NO.: 1 Group NO.: 1
 Material Specification Type & Grade: ASTM A-709 Gr. 36 to A-709 Gr. 36
 Welding Process: F.C.A.W.
 Manual or Machine: Manual
 Position of Welding: Flat 1-F
 Filler Metal Specification: A 5.29
 Filler Metal Classification: E-80T1-W, Esab Dual Shield 8100-W
 Shielding Gas: CO² Rate: 25 CFH
 Single or Multiple Pass: Single
 Single or Multiple Arc: Single
 Welding Current: Direct
 Polarity: Reverse
 Root Treatment: Remove all scale, grease, etc. from weld preparation face
 Preheat and Interpass Temp: 200 Deg F. to 250 Deg F.
 Post weld Heat Treatment: N/A
 Travel Speed: 13-15 ipm

Pass No.	Electrode Size	Welding Current		Weld Size	Joint Detail
		Amperes	Volts		
1	.06	300-310	30-31	5/16"	<p><u>FILLET WELD</u></p>  <p>STIFFENER PLATE</p> <p>RETAINER ANGLE</p>

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Manufacturer: Amscot Structural Products Authorized By: Peter Somogyi
 Date: 3/30/15