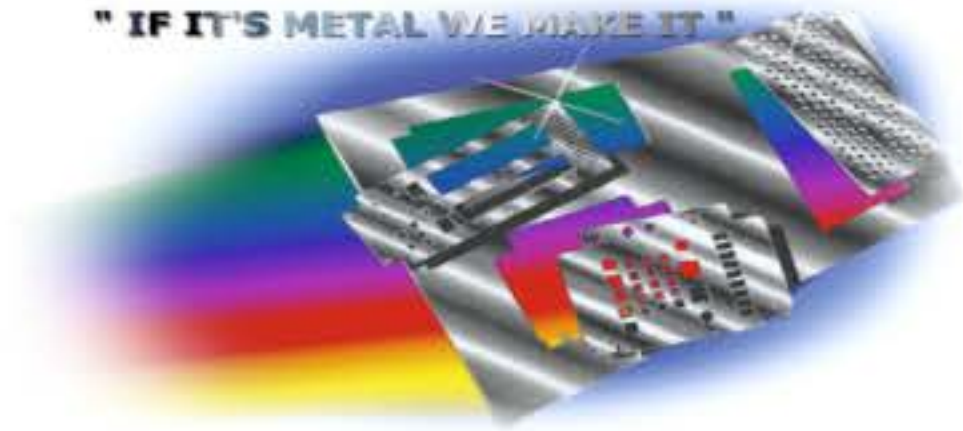


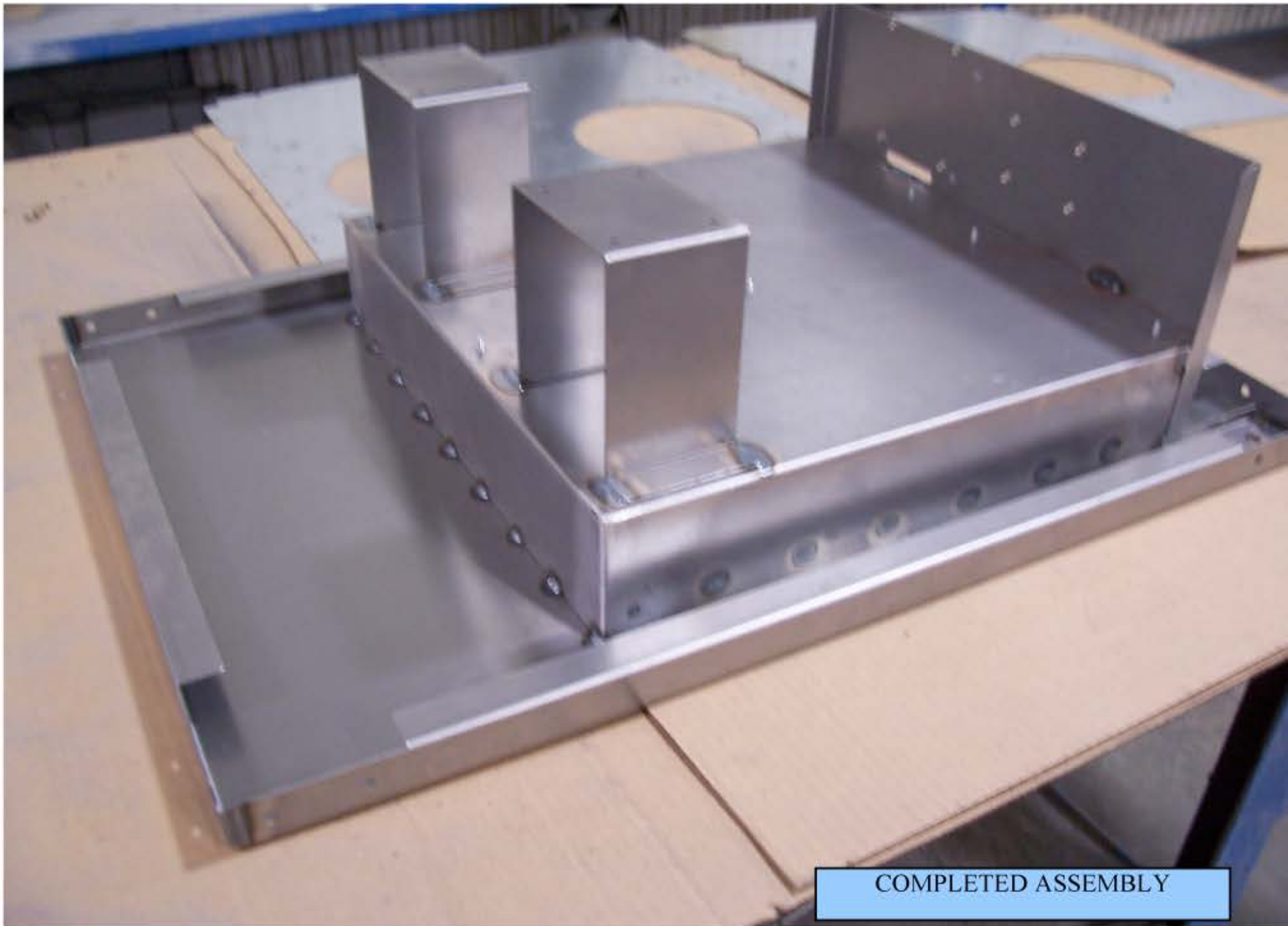
" IF IT'S METAL WE MAKE IT "



R.R. LeDUC CORPORATION

100 BOBALA ROAD
HOLYOKE, MA. 01040
413 536-4329 FAX 413 533-8063

FILL & DRAIN PROGRAM WELD PROCEDURE #WI-056 REV A ***UPPER WELDMENT*** PN 9898 EC N44209



COMPLETED ASSEMBLY

DAVID P. SOROKA
QCM
dsoroka@rrleduc.com

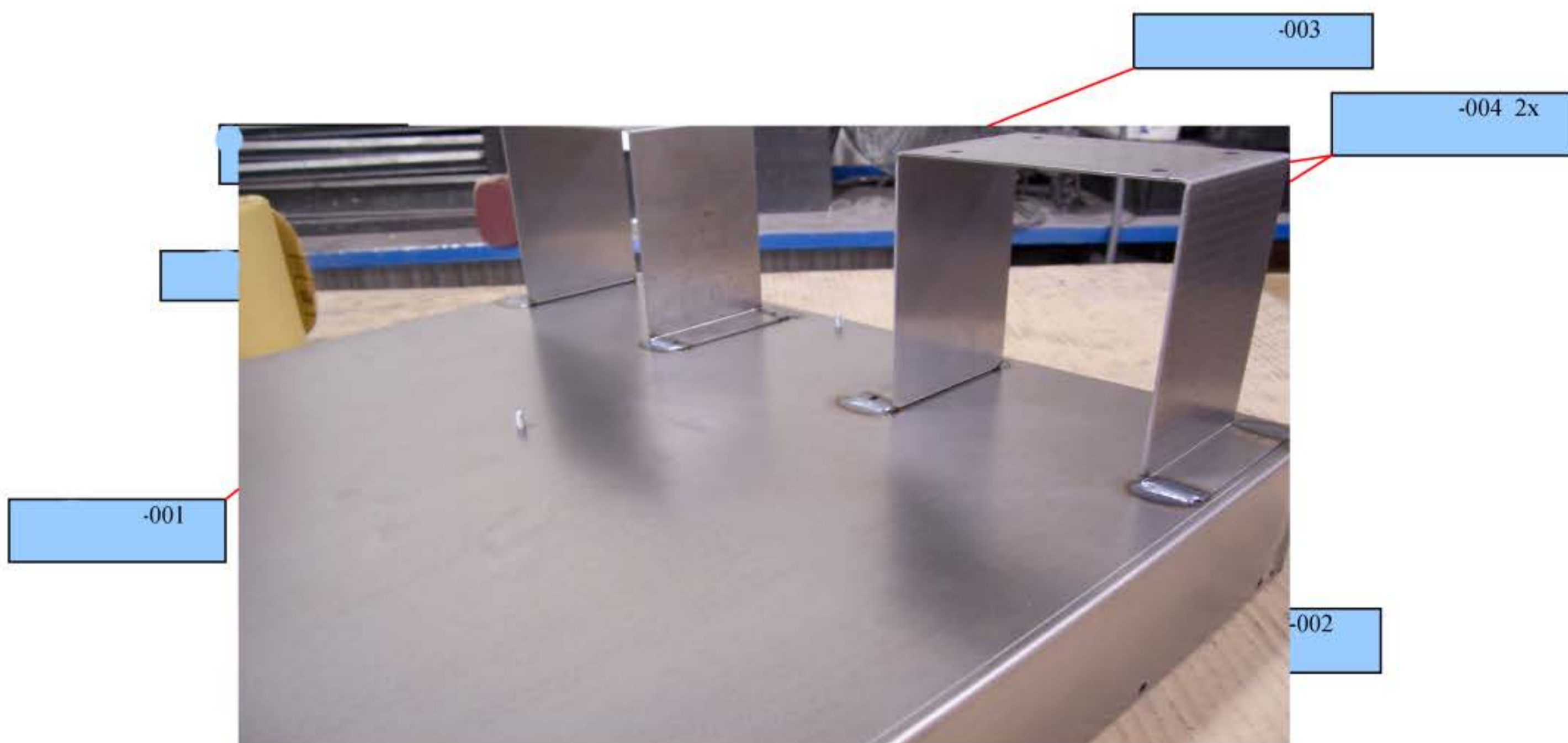
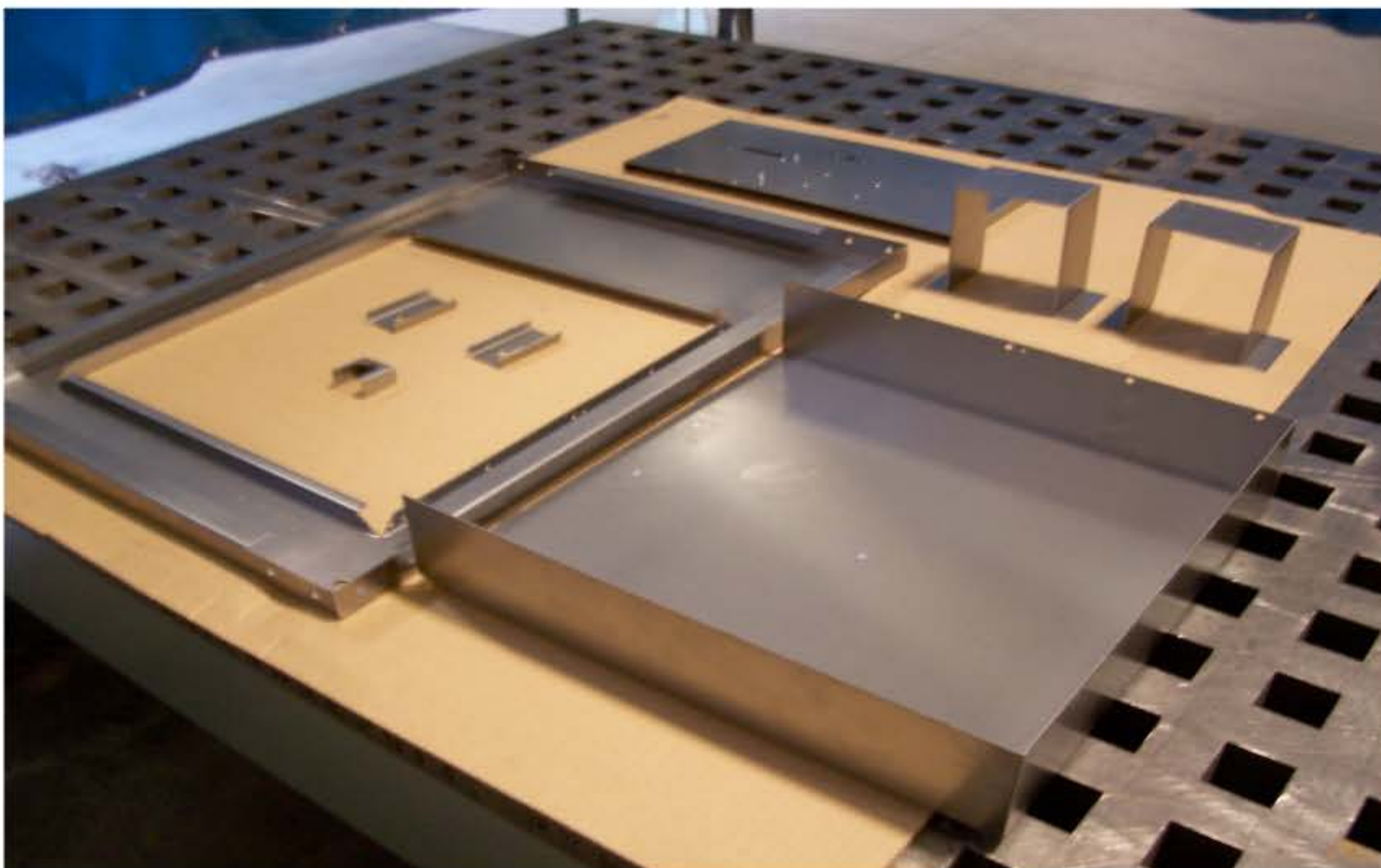
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SUBJECT:

UPPER WELDMENT
FILL & DRAIN PROGRAM

ORIGINATOR
DAVE SOROKA

APPROVED
DAVE SOROKA



STEP 1

VIEW SHOWING ALL THE DETAILS THAT MAKE UP THE UPPER WELDMENT

(over)

R.R. LeDUC CORPORATION	PROCEDURE	
WORK INSTRUCTIONS	DEPT. WELD	REV. A
SUBJECT: UPPER WELDMENT FILL & DRAIN PROGRAM	ORIGINATOR DAVE SOROKA	APPROVED DAVE SOROKA

PURPOSE:

The purpose of this procedure is to assure that all welds have been accurately placed with strict conformance to applicable Engineering Specifications, Drawings, and mechanical aids.

APPLICABLE DOCUMENTS:

IBM Specification 5453712 EC 10000J14094F
 IBM Drawing EC N44209
 -001 Top
 -002 Hose Tray
 -003 Electric Panel
 -004 Pump Bracket
 -005 Handle Brace
 -006 Switch Guard

TOOLING / HARDWARE:

Cleeko Hardware:
 8ea Insertion Pins
 1ea Installer

WELD PROCESS:

Miller Welder Syncrowave 359, Model 902976
 GTAW thru-out with exception of tooling / cleeko holes, then GMAW
 Filler Rod, ER70S TIG Ø.06

RESPOSIBILITY:

It shall be the responsibility of the weld operator to assure that all welds are present and professionally applied with no spatter or snots.

PROCEDURE:

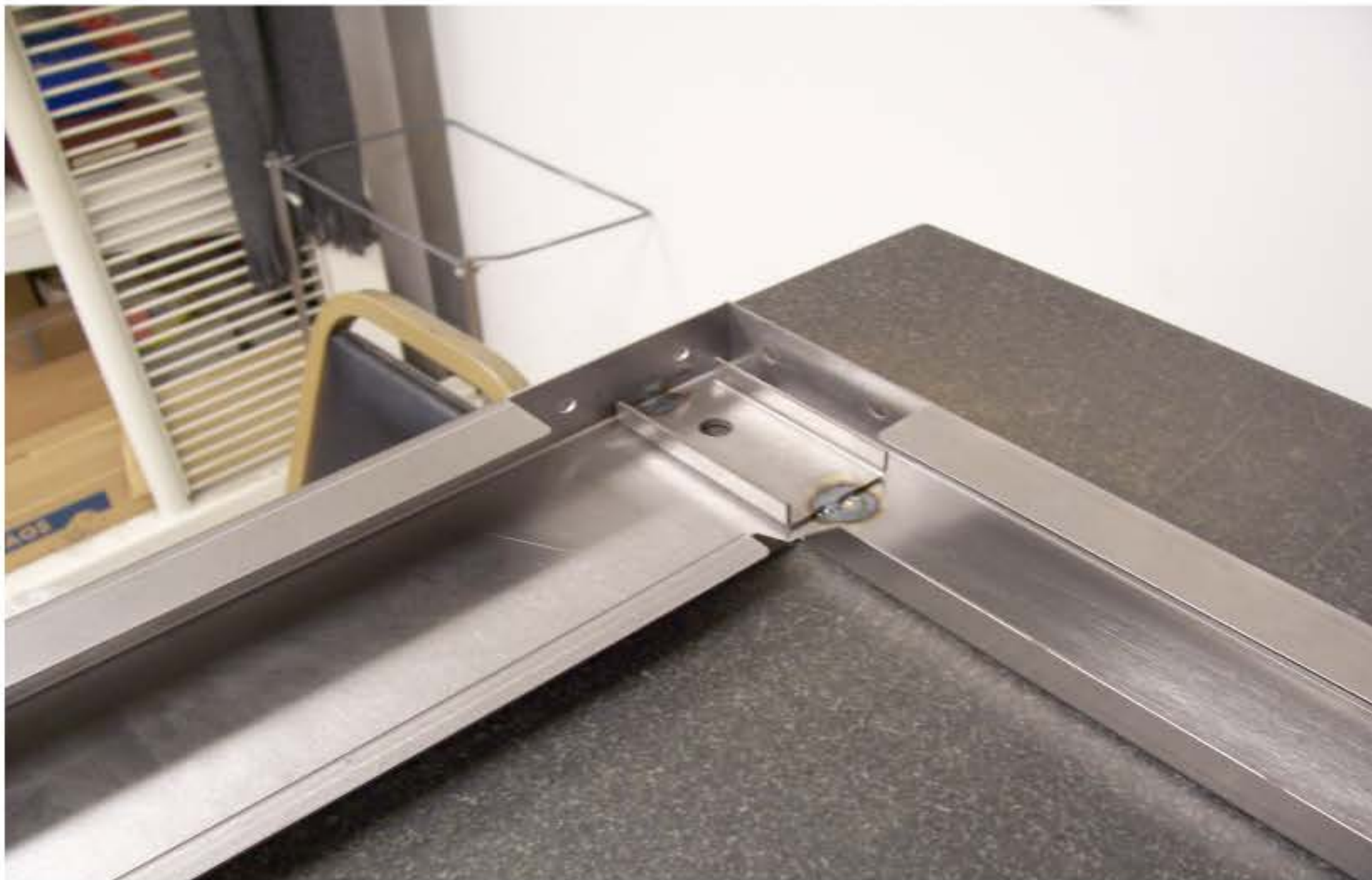
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INITIAL RELEASE: 07/23/2012	AUTHORIZED SIGNATURE: DAVID P. SOROKA	PAGE 1 OF 4
DATE LAST REVIEWED:		

R.R. LeDUC CORPORATION	PROCEDURE	WI- 056
WORK INSTRUCTIONS	DEPT. WELD	REV. A
SUBJECT: UPPER WELDMENT FILL & DRAIN PROGRAM	ORIGINATOR DAVE SOROKA	APPROVED DAVE SOROKA

(cont'd) 3.0 Weld 9898-006 is located on -002 Tray(inside) via tab & slot. Apply 2ea .25 long welds "opposite side."

STEP 4:



4.0 The -005 details are located via slot & tab.

4.1 Weld 9898-005 Handle Braces, 2x, to the inside of -001 Top. **The fillet welds shall encompass the full width of the Brace. Note: the illustration above depicts only 1/2 " long** welds to be welded the full the full width of the -005 part.

WELD 9898-005 TO -001 TOP, 2 PLCS AS SHOWN BOTH SIDES.

This completes the weldment

Weld operator shall inspect 1st build thoroughly prior to QC acceptance. Each weldment must be checked by the operator to assure all welds are in place before moving to Finishing.

9898-005

9898-001