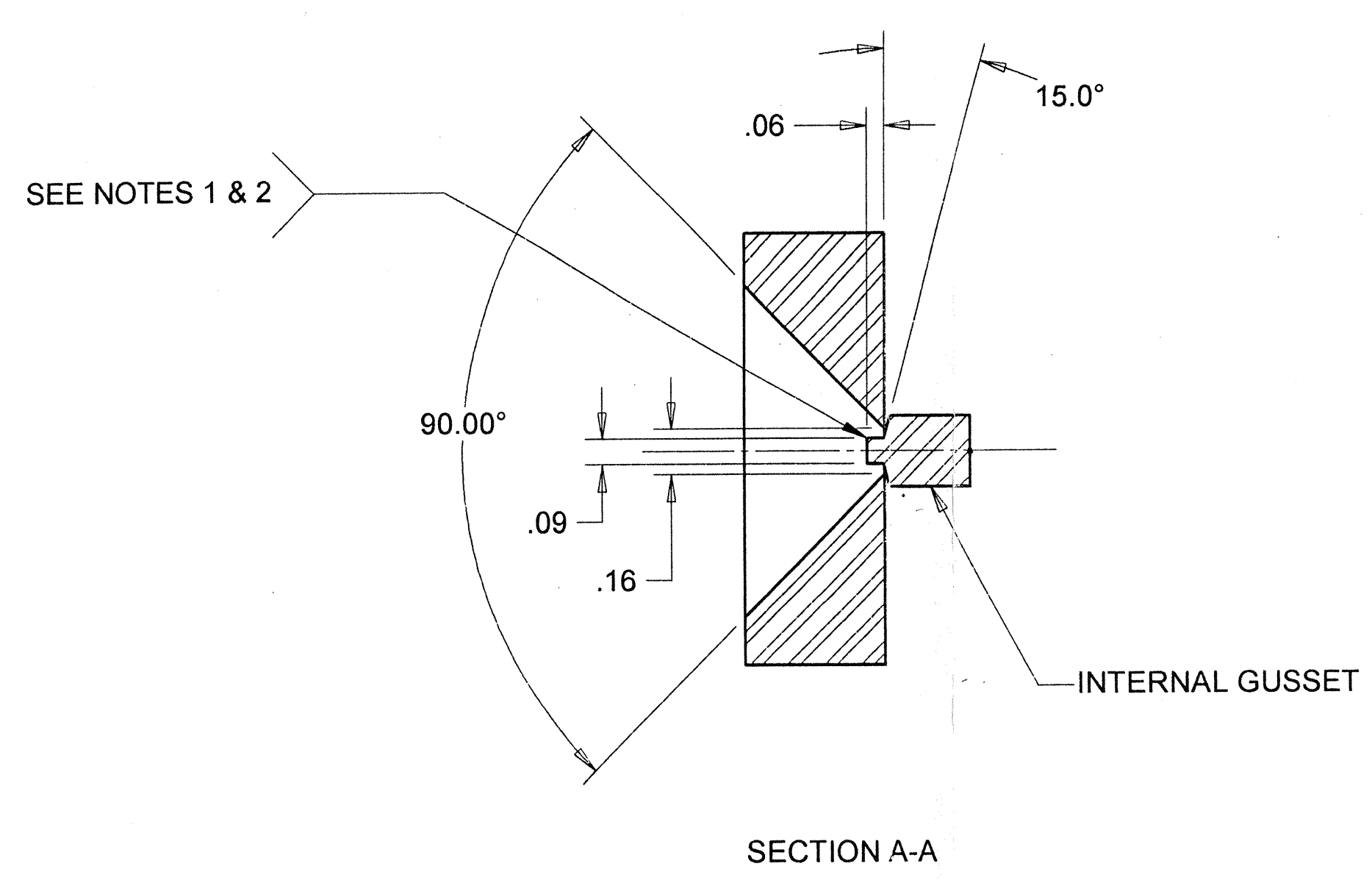
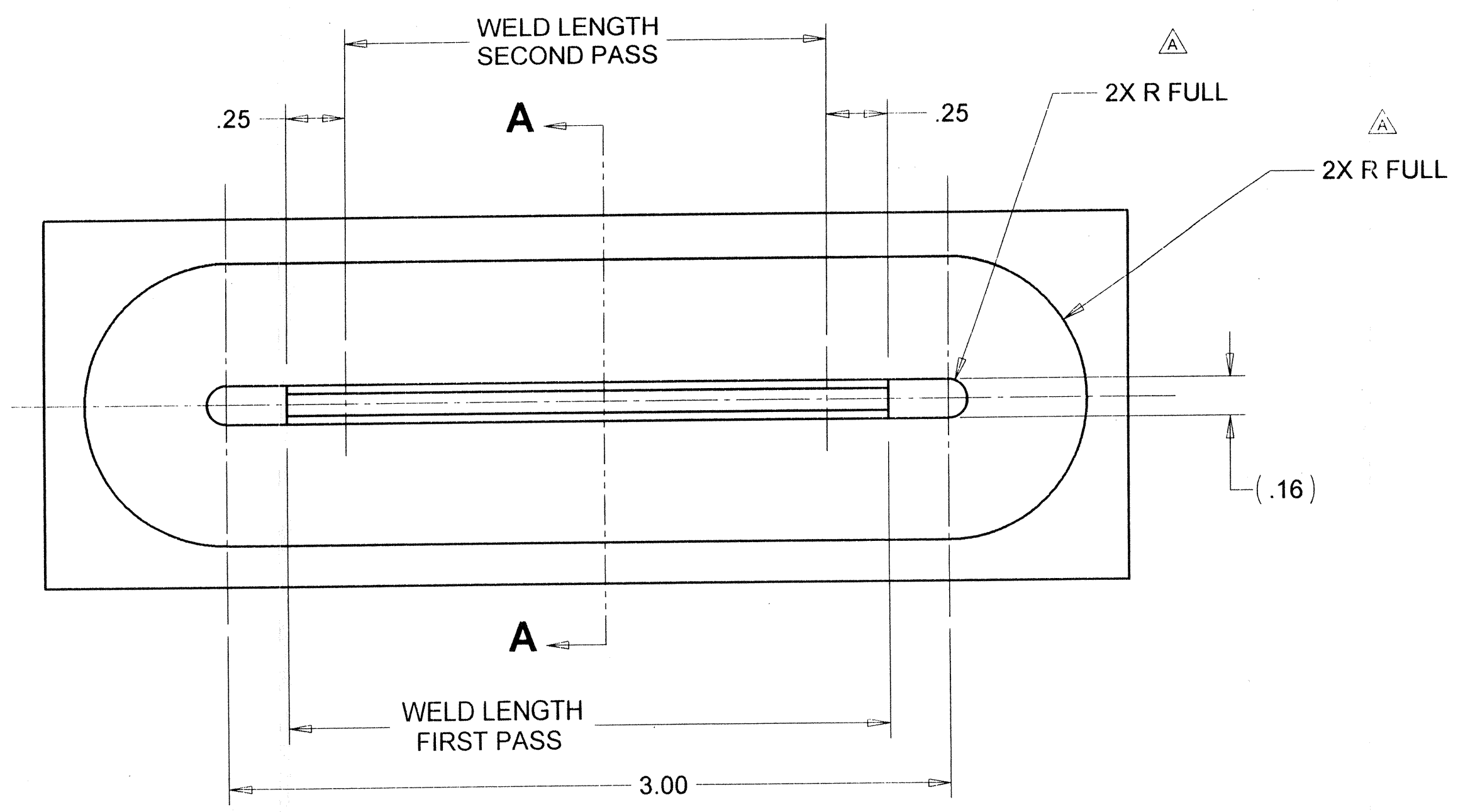
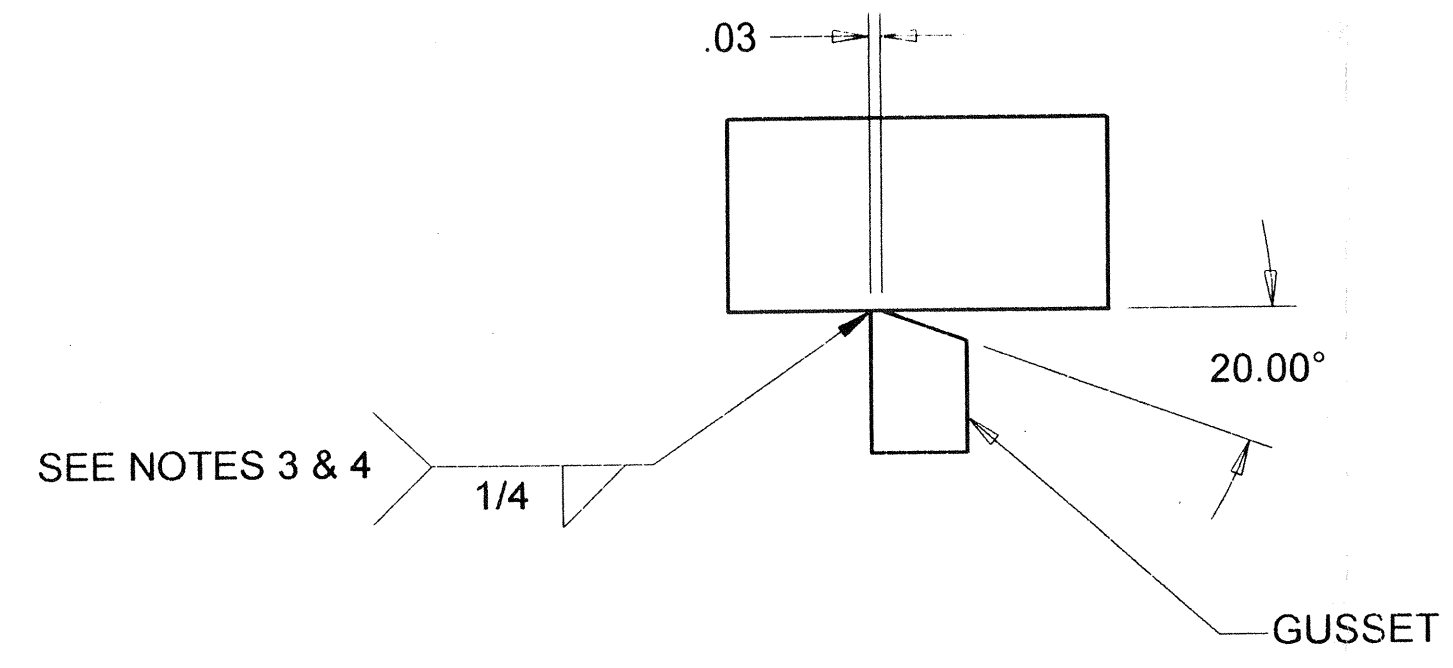


8 7 6 5 4 3 2 1

REVISIONS		
REV.	DESCRIPTION	DATE
A	SEE ECN# D972202-A FOR CHANGE LIST	11-03-97
		T. THOMPSON



TYPICAL PLUG WELD



TYPICAL FILLET WELD

NOTES:

- FIRST 2 PASSES FULL PENETRATION AUTOGENOUS WELD USING 100% ARGON SHIELD, DC, POLARITY OPTIONAL.
- NEXT 2 PASSES TO BE AC WITH 4043 FILLER, SHIELD GAS MIXTURE OPTIONAL. DO NOT FILL GROOVE.
- FIRST PASS FULL PENETRATION AUTOGENOUS DC STRAIGHT POLARITY WITH 100% He TO 50/50 Ar/He SHIELD & 100% ARGON BACK PURGE.
- SECOND PASS AC WITH 4043 FILLER. SHIELD GAS MIXTURE OPTIONAL. STAY BACK FROM FIRST PASS BY .25".

PARTS LIST			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING	
DECIMALS XX = +/- .03 XXX = +/- .010	ANGULAR = +/- .30° SURFACE FINISH = 250	<p><b>HYTEC, INC</b></p> <p>TITLE LIGO WELD PREP &amp; WELD PROCEDURE</p>	
FINISH	SIGNATURE	DATE	
	ROGER L. SMITH	5-28-97	
	ROGER L. SMITH	5-28-97	DWG. NO.
	HARRY SALAZAR	6-6-97	SIZE SHEET NO.
	T. THOMPSON	7-10-97	D972202 D 1 of 1
PART NO. D972202-1	APPROVED T. THOMPSON	7-10-97	SCALE 2/1 REVISION A

8 7 6 5 4 3 2 1

D  
C  
B  
A

D  
C  
B  
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