



East Coast Repair & Fabrication LLC.

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QUALIFIED WELDING PROCEDURES

| | | |
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| ECR-100 | SMAW | HY-100 to HY-100 Plate with Backing |
| ECR-101 | SMAW | Carbon Steel Pipe with Backing |
| ECR-102 | FCAW | Carbon Steel Plate with Backing |
| ECR-102C | FCAW | Carbon Steel Plate with Ceramic Backing |
| ECR-103 | FCAW | HY-80 to HY-80 Plate with Backing |
| ECR-104 | GTAW | Carbon Steel Pipe with Backing |
| ECR-104TWS | GTAW | Carbon Steel Thin Wall Sockets |
| ECR-105 | SMAW | Carbon Steel Pipe with Backing |
| ECR-105TWS | SMAW | Carbon Steel Thin Wall Sockets |
| ECR-106 | GTAW | Carbon Steel Pipe without Backing |
| ECR-107 | FCAW | Carbon Steel to Stainless Steel Plate with Backing |
| ECR-200 | SMAW | Stainless Steel Plate with Backing |
| ECR-201 | GTAW | Stainless Steel Pipe with Backing |
| ECR-201TWS | GTAW | Stainless Steel Thin Wall Sockets |
| ECR-201FTWS | GTAW | Stainless Steel Thin Wall Sockets |
| ECR-202 | GTAW | Stainless Steel Pipe without Backing |
| ECR-203 | GTAW | Stainless Steel Pipe (Pipe Boss) |
| ECR-225TWS | GTAW | 5XXX Aluminum Socket Welds |
| ECR-400 | GTAW | Copper Nickel Pipe with Backing |
| ECR-400TWS | GTAW | Copper Nickel Thin Wall Socket |
| ECR-401 | GTAW | Copper to Copper Nickel Pipe with Backing |
| ECR-401TWS | GTAW | Copper to Copper Nickel Thin Wall Socket |
| ECR-402 | GTAW | Copper Nickel Pipe without Backing |
| ECR-408 | FCAW | Stainless Steel Plate with Backing |

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| ECR-500 | SMAW | Carbon Steel to Stainless Steel Plate with Backing |
| ECR-501 | GTAW | Carbon Steel to Copper Nickel Pipe with Backing |
| ECR-501 TWS | GTAW | Carbon Steel to Copper Nickel Thin Wall Socket |
| ECR-600 | GMAW | 5XXX Aluminum Plate with Backing |
| ECR-600C | GMAW | 5XXX Aluminum Plate with Ceramic Backing |
| ECR-601 | GMAW-P | Carbon Steel Plate with Ceramic Backing |
| ECR-602 | GMAW-P | 6XXX Aluminum Plate with Ceramic Backing |
| ECR-603 | GMAW-P | 6XXX to 5XXX Aluminum Plate with Ceramic Backing |
| ECR-604 | FCAW | HY-80 to HY-80 (to 2") Double Bevel |
| ECR-700 | Arc Stud | Carbon Steel Studs to Carbon Steel Base, |
| ECR-702 | Arc Stud | Stainless Steel Studs to Stainless Steel Base |
| ECR-703 | Arc Stud | Stainless Steel Studs to Carbon Steel Base |
| ECR-800 | FCAW | Alloy 8620 to HSLA-80 Welded Both Sides |
| ECR-801 | SMAW | Alloy 8620 to HSLA-80 Welded Both Sides |
| ECR-802 | FCAW | Alloy 8620 to HY-100 Welded Both Sides |
| ECR-803 | SMAW | Alloy 8620 to HY-100 Welded Both Sides |
| ECR-804 | FCAW | Alloy 8620 to HSLA-100 Welded Both Sides |
| ECR-805 | SMAW | Alloy 8620 to HSLA-100 Welded Both Sides |
| ECR-806 | FCAW | Alloy 8620 to HY-80 Welded Both Sides |
| ECR-807 | SMAW | Alloy 8620 to HY-80 Welded Both Sides |
| ECR-808 | FCAW | Alloy 8620 to Stainless Steel Welded Both Sides |
| ECR-809 | SMAW | Alloy 8620 to Stainless Steel Welded Both Sides |