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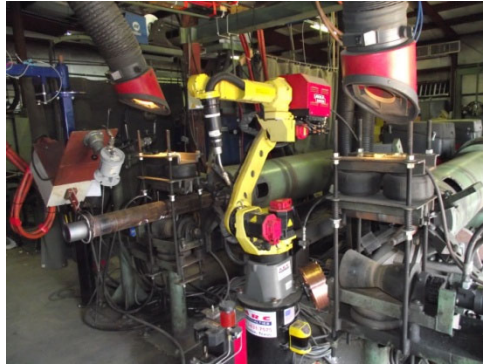
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WELDING

Weld Procedure Specifications (WPS): Welding is one part of the VIT manufacturing process that requires a number of elements to be in place to insure the highest quality finished product. These elements are: appropriate materials, operators performing the work must be capable and qualified according to the OTSI weld specifications, procedures must be appropriate for the oil field applications, and all procedures must be followed, . Finally, appropriate inspection must take place to ensure that all welding steps have been properly executed. American Welding Society (AWS) codes contain provisions describing minimum requirements for each of these elements, and documentation is required to assure each of these elements is in place. The OTSI welding specification is available upon request.

Procedure Qualification Record (PQR): Further, these weld procedure specifications (WPS's) are qualified on a periodic basis by test. These qualification tests are conducted on welding a sample using the parameters to be tested and by subjecting the weld to bend tests, tensile tests and Charpy V-notch tests. Test results and variables qualified are shown in a Procedure Qualification Record (PQR).

Robotic Welding is used on all welds:



Computer Controlled
Robotic Welding



Post Weld Heat Treating