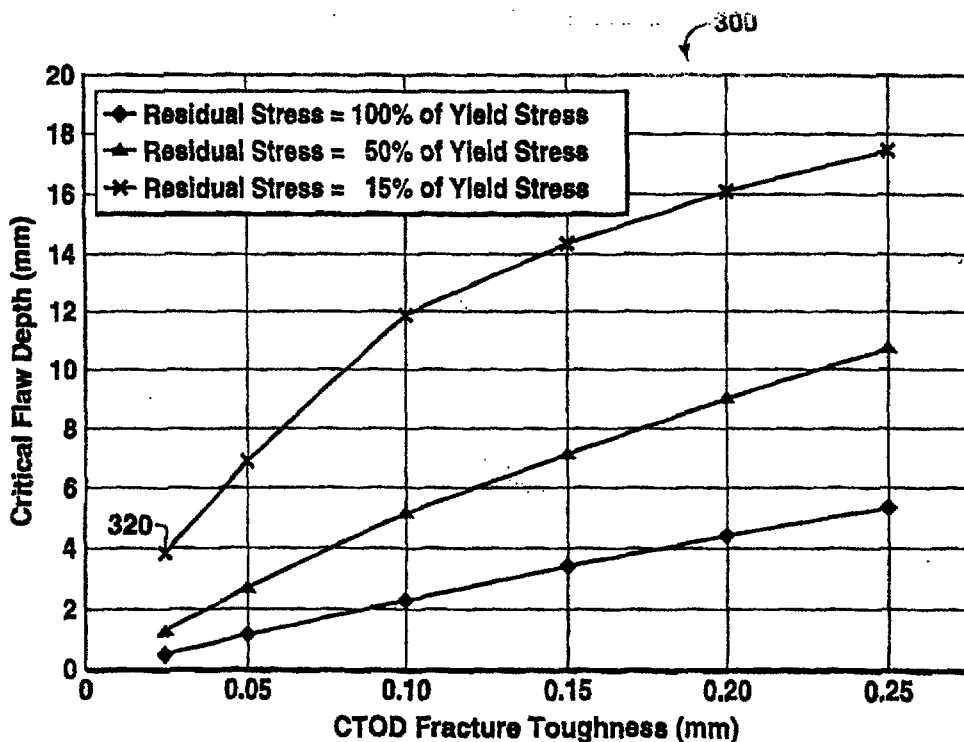




INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ : B23K 9/16		A1	(11) International Publication Number: WO 98/58758
			(43) International Publication Date: 30 December 1998 (30.12.98)
(21) International Application Number: PCT/US98/12738		(81) Designated States: AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GE, GH, GM, GW, HU, ID, IL, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, UA, UG, UZ, VN, YU, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).	
(22) International Filing Date: 18 June 1998 (18.06.98)			
(30) Priority Data: 60/050,280 20 June 1997 (20.06.97) US 60/053,966 28 July 1997 (28.07.97) US 60/085,462 14 May 1998 (14.05.98) US			
(71) Applicant: EXXON PRODUCTION RESEARCH COMPANY [US/US]; 3120 Buffalo Speedway, P.O. Box 2189, Houston, TX 77252-2189 (US).		Published With international search report.	
(72) Inventor: FAIRCHILD, Douglas, P.; 4814 Scot Court, Sugar Land, TX 77479 (US).			
(74) Agents: CASAMASSIMA, Salvatore, J. et al.; Exxon Production Research Company, P.O. Box 2189, Houston, TX 77252-2189 (US).			

(54) Title: ULTRA-HIGH STRENGTH CRYOGENIC WELDMENTS



(57) Abstract

Welding methods are provided for use in joining ultra-high strength, low alloy steels to produce weldments having tensile strengths greater than about 900 MPa (130 ksi) with weld metals having fracture toughness suitable for cryogenic applications according to known principles of fracture mechanics.