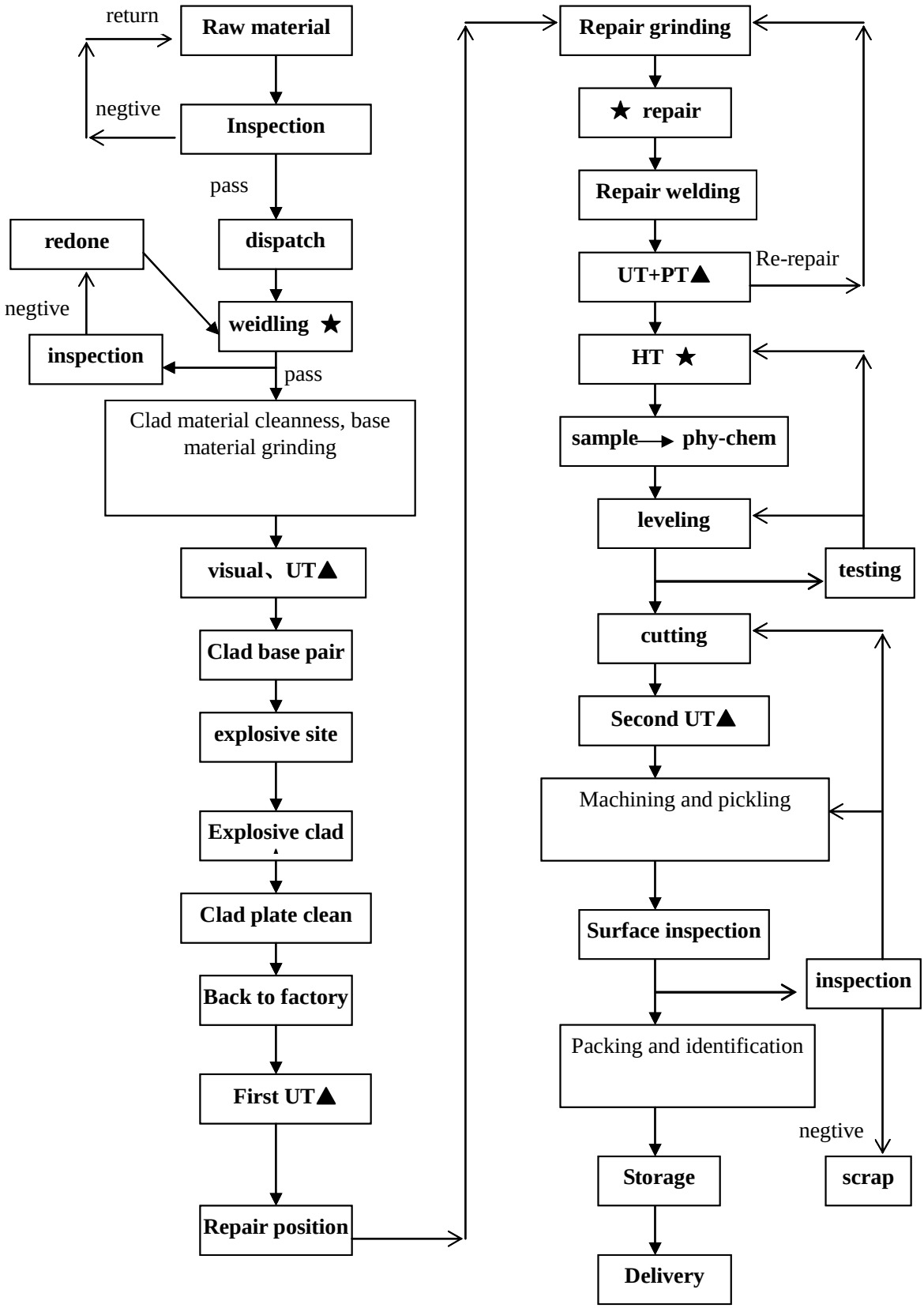
Clad plate process procedure



note: ★—special process，▲—key process