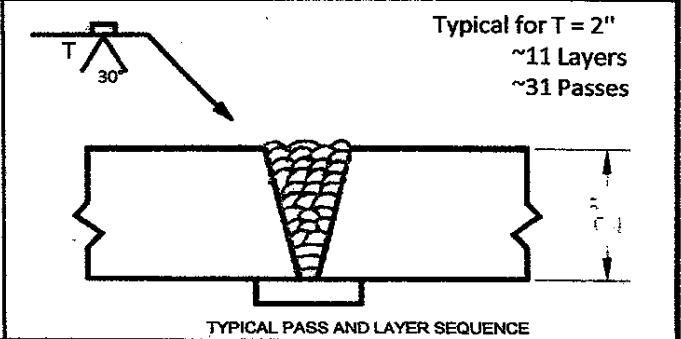
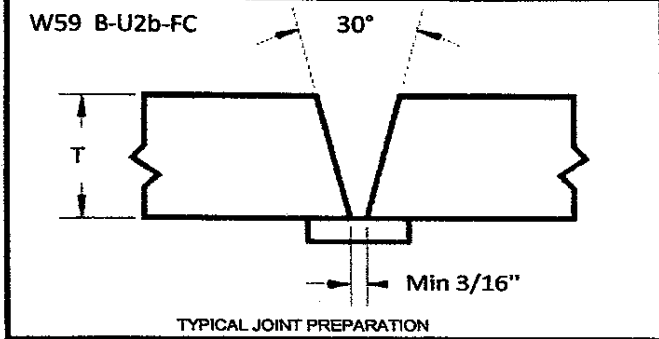


Stelcon Industrial Services Ltd. PO Box 3304 Smithers BC V0J 2N0	Wldg. Procedure Specification No. FCAW 1 Applicable Standard(s) CSA W47.1 & CSA W59
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CHECK TYPE OF WELDING PROCESS <input type="checkbox"/> Manual (SMAW) <input type="checkbox"/> Submerged-Arc (SAW) <input checked="" type="checkbox"/> Flux-Cored (FCAW) <input type="checkbox"/> Solid Wire (GMAW)	Welding Position FLAT	Electrode (Wire) Classification E491T-9M-H16
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Material Designations CSA W59 Groups 1, 2 & 3 (Table 11.1 & 12.1)	PREHEAT MINIMUM as per CSA W59 Table 5.3	MINIMUM Interpass Temperature Table 5.3	MAXIMUM Interpass Temperature N/A
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COMPLETE JOINT PENETRATION GROOVE <input type="checkbox"/> Back-gouged to sound metal <input checked="" type="checkbox"/> Welded onto steel backing <input type="checkbox"/> Welded from one side without backing <input type="checkbox"/> Welded both sides without back gouging <input type="checkbox"/> Welded onto other than steel backing	GROOVE WELD PARTIAL JOINT PENETRATION <input type="checkbox"/> Minimum as per CSA W59 <input type="checkbox"/> Other FILLET WELD <input type="checkbox"/> Minimum as per W59	JOINT TYPE as per CSA W59 <input checked="" type="checkbox"/> BUTT <input type="checkbox"/> TEE <input type="checkbox"/> CORNER <input type="checkbox"/> EDGE <input type="checkbox"/> LAP <input type="checkbox"/> EDGE	Semi-Automatic Electrical Stickout 5/8"-3/4" Shielding Gas: 40-50 Cfph 75% Ar, 25%CO₂
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Size T	Side No.	Layer Number	Pass Number	Electrode Size	Current Polarity	Amperes	Wire Feed Speed	Volts	Arc Travel Speed	Heat Input
inches				inches			inches/min		inches/min	
2"	1	1	1	0.045	DC+	200-230	325-400	27-28	14-17	
	1	2	2	0.045	DC+	200-230	325-400	27-28	14-17	
	1	3	3	0.045	DC+	200-230	325-400	27-28	14-17	
	1	4	4-5	0.045	DC+	200-230	325-400	27-28	14-17	
	1	5	6-8	0.045	DC+	200-230	325-400	27-28	14-17	
	1	6	9-11	0.045	DC+	200-230	325-400	27-28	14-17	
	1	7	12-14	0.045	DC+	200-230	325-400	27-28	14-17	
	1	8	15-17	0.045	DC+	200-230	325-400	27-28	14-17	
	1	9	18-21	0.045	DC+	200-230	325-400	27-28	14-17	
	1	10	22-25	0.045	DC+	200-230	325-400	27-28	14-17	
	1	11	26-31	0.045	DC+	200-230	325-400	27-28	14-17	

Revision Date	Explanation	CWB Approval	Engineer's Stamp*
		CWB Accepted February 14, 2012 <small>Valid only if welding consumables are certified by the CWB</small>	 * Div. 2-Engineer's Stamp Div. 3-Welding Supervisor
WO # 2758 Prepared by: SKC ENGINEERING LTD. WELDING & MANUFACTURING CONSULTANTS Tel (604) 882-1889 Fax (604) 882-1811			