

Stelcon Industrial Services Ltd.
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V0J 2N0

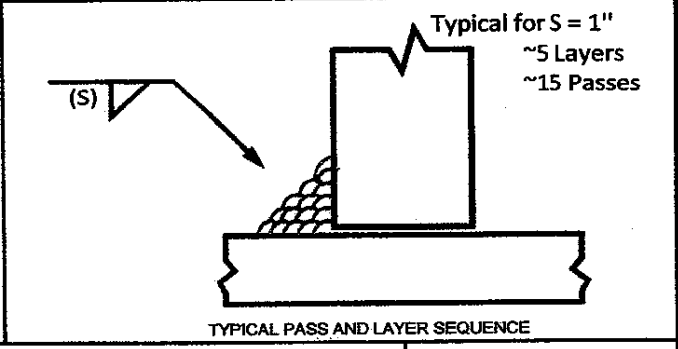
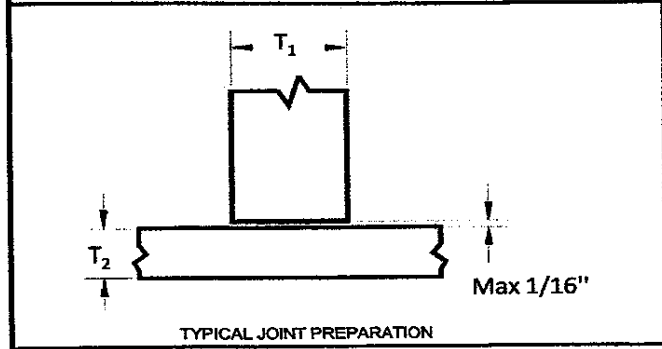
Wldg. Procedure Specification No. **FCAW 1**
 Applicable Standard(s) **CSA W47.1 & CSA W59**

CHECK TYPE OF WELDING PROCESS: Manual (SMAW) Submerged-Arc (SAW) Flux-Core (FCAW) Solid Wire (GMAW)

Welding Position: **FLAT/HOR.** Electrode (Wire) Classification: **E491T-9M-H16**

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**



- | | | | |
|--|---|--|---|
| COMPLETE JOINT PENETRATION GROOVE
<input type="checkbox"/> Back-gouged to sound metal
<input 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 checked="" type="checkbox"/> Minimum as per W59 | JOINT TYPE as per CSA W59
<input type="checkbox"/> BUTT <input checked="" type="checkbox"/> TEE
<input checked="" type="checkbox"/> CORNER <input type="checkbox"/> EDGE
<input checked="" type="checkbox"/> LAP | Semi-Automatic
Electrical Stickout: 5/8"-3/4"
Shielding Gas: 40-50 Cfph
75% Ar, 25%CO₂ |
|--|---|--|---|

Fillet Size S	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	
1"	1	1	1	0.045	DC+	200-230	325-400	27-28	14-17	
	1	2	2-3	0.045	DC+	200-230	325-400	27-28	14-17	
	1	3	4-6	0.045	DC+	200-230	325-400	27-28	14-17	
	1	4	7-10	0.045	DC+	200-230	325-400	27-28	14-17	
	1	5	11-15	0.045	DC+	200-230	325-400	27-28	14-17	
1-7/16"	1	1	1	0.045	DC+	200-230	325-400	27-28	14-17	
	1	2	2-3	0.045	DC+	200-230	325-400	27-28	14-17	
	1	3	4-6	0.045	DC+	200-230	325-400	27-28	14-17	
	1	4	7-10	0.045	DC+	200-230	325-400	27-28	14-17	
	1	5	11-15	0.045	DC+	200-230	325-400	27-28	14-17	
	1	6	16-21	0.045	DC+	200-230	325-400	27-28	14-17	
	1	7	22-28	0.045	DC+	200-230	325-400	27-28	14-17	

Revision Date	Explanation	CWB Approval	Engineer's Stamp*
		<p>Valid only if welding consumables are certified by the CWB</p>	<p>* Div. 2-Engineer's Stamp Div. 3-Welding Supervisor</p>
WO # 2758	Prepared by:		
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