



**CANADIAN WELDING BUREAU**  
DIVISION OF CWB GROUP - INDUSTRY SERVICES

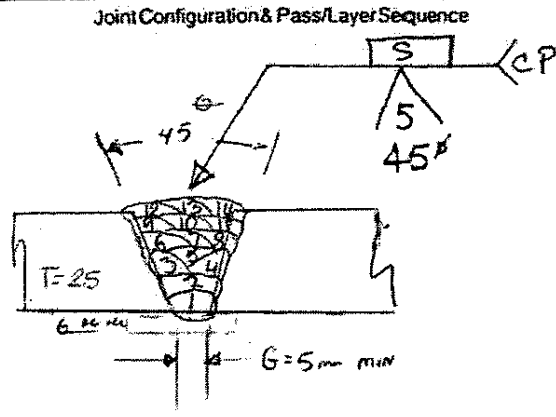
**WELDING PROCEDURE  
DATA SHEET**

WPDS NO: S.F.#2  
DATE: 04/25/2008 Rev.: 0  
MONTH DAY YEAR

Company Name: Selcon Industrial Services Lt Ref. Standards: W47.1/W59-03  
Address: P.O. Box 3304 Smithers BC V0J-2W0 Ref. WPS: S.FCAW#1

Welding Processes: 1 FCAW Pulsed: Yes  No  2 N/A Pulsed: Yes  No   
Shielding Gas Type: N/A

Positions: FLAT  
Process Mode: Manual  Semi-Auto  Machine  Auto   
Joint Type: But  Tee  Corner  Lap  Edge   
Penetration: Complete  Partial (ETT = \_\_\_\_\_)  Fillet   
Backing: Material: STEEL Thickness: 6.4 mm  
Backgouging: Yes  Method: \_\_\_\_\_  
No  Depth: \_\_\_\_\_  
Electrode Extension: 32 mm  
Nozzle Diameter(s): 16 mm  
Flux Classification: NA  
Tungsten Electrode: Type: N/A Diameter: \_\_\_\_\_  
Cleaning Procedures: CHIP BRUSH OR GRIND WHEN REQUIRED  
CSA W186 Rebar Splice Type: Direct Splice  Indirect Splice  Lap Splice   
Rebar to Structural Member Only



Ref Joint # BUZBFC of W59/03

**Identification of Base Material (for CSA W186 indicate carbon equivalent, max. phosphorus & sulphur content)**

Part	Specification & Grade	Thickness or Dia.	Special Requirements
I	<u>GROUPS 1-3 TABLE 11.1 OF W59</u>	<u>10-25 mm</u>	
II			

**Identification of Filler Material**

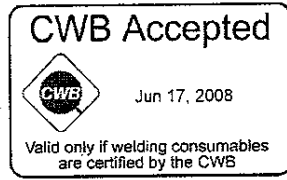
Process	Trade Name	Classification	Group	Filler Treatment
<u>FCAW</u>	<u>WINNERSHIELD NR 311</u>	<u>E 492T-7</u>	<u>N/A</u>	<u>AS PER W59/03</u>

**Welding Parameters**

Thickness (mm)	Weld Size/ETT	Layer	Pass Number	Welding Process	Dia. (mm)	Wire Feed Speed (MPM)	Current A	Volt V	Current Polarity	Welding Speed (mm/min)	Burn-off Rate (mm)	Gas Flow Rate (l/min)	Heat Input (kJ/mm)
<u>10</u>	<u>10</u>	<u>1-3</u>	<u>1-5</u>	<u>FCAW</u>	<u>2.0</u>	<u>3.8</u>	<u>260/280</u>	<u>22/24</u>	<u>DCEN</u>	<u>300/320</u>	<u>NA</u>	<u>NA</u>	<u>NA</u>
<u>13</u>	<u>13</u>	<u>1-4</u>	<u>1-8</u>	<u>FCAW</u>	<u>2.0</u>	<u>3.8</u>	<u>260/280</u>	<u>22/24</u>	<u>DCEN</u>	<u>280/320</u>	<u>NA</u>	<u>NA</u>	<u>NA</u>
<u>25</u>	<u>25</u>	<u>1-6</u>	<u>1-14</u>	<u>FCAW</u>	<u>2.0</u>	<u>3.8</u>	<u>260/280</u>	<u>22/24</u>	<u>DCEN</u>	<u>280/360</u>	<u>NA</u>	<u>NA</u>	

**Heat treatment** CWB Acceptance Company Authorization

Preheat min: AS PER TABLE 5-3 Interpass temp. max.: NA  
CF W59 interpass temp. min.: NA  
Remarks:  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_



*[Handwritten Signature]*

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