



CANADIAN WELDING BUREAU  
DIVISION OF CWB GROUP - INDUSTRY SERVICES

WELDING PROCEDURE  
DATA SHEET

WPDS NO.: S. F#1

DATE 04 25 2008  
MONTH DAY YEAR

Rev.: 0

Company Name Skelton Industrial Services Ltd.  
Address P.O. Box 3304 Smithers B.C. V0S-2N0

Ref. Standards: W47.1 W59/03

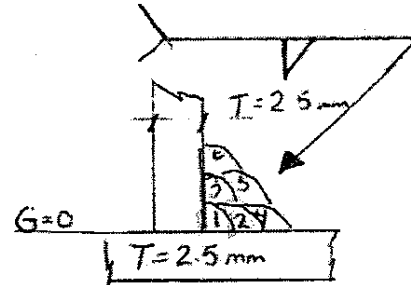
Ref. WPS: S. FCAW#1

Welding Processes: 1 FCAW Pulsed: Yes  No   
Shielding Gas Type: NA

2 N/A Pulsed: Yes  No

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

Joint Configuration & Pass/Layer Sequence



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

Part	Specification & Grade	Thickness or Dia.	Special Requirements
I	GROUPS 1-2-3 of Table 11-1 W59	6 to 25 mm	
II			

Identification of Filler Material

Process	Trade Name	Classification	Group	Filler Treatment
FCAW	INVERSHELD NR 311	E492T-7	N/A	AS PER W59/03

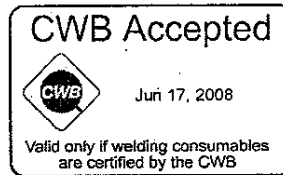
Welding Parameters

Thick-ness (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)
6	6	1	1	FCAW	2.0	3.5	240-250	21-23	DCEN-	300-320	-	-	-
10	8	1	1	FCAW	2.0	3.5	240-260	21-23	DCEN-	250-270	-	-	-
20	10	1-2	1-3	FCAW	2.0	3.5	240-260	21-23	DCEN-	270-300	-	-	-
25	13	1-3	1-6	FCAW	2.0	3.5	240-260	21-23	DCEN-	250-300	-	-	-

Heat treatment

Preheat min: AS PER W59/03 Interpasstemp. max.: NA  
TABLE 5.3 Interpasstemp. min.: NA  
Remarks:

CWB Acceptance



Company Authorization

*[Signature]*

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