

<b>CANADIAN WELDING BUREAU</b> DIVISION OF CWS GROUP - INDUSTRY SERVICES	<b>WELDING PROCEDURE DATA SHEET</b>	WPDS NO.: <u>S.F#3</u>	DATE: <u>04 25 2008</u>
		Rev.: <u>0</u>	MONTH DAY YEAR

Company Name: Skelcon Industrial Services Ltd      Ref. Standards: W471/W59/03  
 Address: P.O. Box 3304 Smithers B.C. V0J-2W0      Ref. WPS: S.FCAW#1

Welding Processes: <u>1</u>	<u>FCAW</u> Pulsed: Yes <input type="checkbox"/> No <input type="checkbox"/>	<u>2</u>	<u>N/A</u> Pulsed: Yes <input type="checkbox"/> No <input type="checkbox"/>
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Shielding Gas Type: <u>N/A</u>	Joint Configuration & Pass/Layer Sequence
Positions: <u>HORIZONTAL</u>	
Process Mode: Manual <input type="checkbox"/> Semi-Auto <input checked="" type="checkbox"/> Machine <input type="checkbox"/> Auto <input type="checkbox"/>	
Joint Type: Butt <input checked="" type="checkbox"/> Tee <input type="checkbox"/> Corner <input type="checkbox"/> Lap <input type="checkbox"/> Edge <input type="checkbox"/>	
Penetration: Complete <input checked="" type="checkbox"/> Partial (ETT#) <input type="checkbox"/> Fillet <input type="checkbox"/>	
Backing: Material: <u>STEEL</u> Thickness: <u>6mm</u>	
Backgouging: Yes <input type="checkbox"/> Method: _____ No <input checked="" type="checkbox"/> Depth: _____	
Electrode Extension: <u>32 mm</u>	
Nozzle Diameter(s): <u>16 mm</u>	
Flux Classification: <u>N/A</u>	
Tungsten Electrode: Type: <u>N/A</u> Diameter: _____	
Cleaning Procedure: <u>CHIPPING BRUSH OR GRIND WHEN REQ.</u>	
CSA W186 Rebar Splice Type: Direct Splice <input type="checkbox"/> Indirect Splice <input type="checkbox"/> Lap Splice <input type="checkbox"/> Rebar to Structural Member Only <input type="checkbox"/>	Ref: <u>B-4-ABFC of W59/03</u>

Identification of Base Material (for CSA W186 indicate carbon equivalent, max. phosphorus & sulphur content)			
Part	Specification & Grade	Thickness or Dia.	Special Requirements
I	<u>AS PER GROUPS 1-2-3 OF W59/03 TBL 11-1</u>	<u>20 mm</u>	
II			

Identification of Filler Material				
Process	Trade Name	Classification	Group	Filler Treatment
<u>FCAW</u>	<u>INNERSHIELD NR311</u>	<u>E492T-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	Gas Flow Rate	Heat Input
<u>10</u>	<u>10</u>	<u>1-3</u>	<u>1-6</u>	<u>FCAW</u>	<u>2.0</u>	<u>3.5</u>	<u>230/250</u>	<u>21-23</u>	<u>DCEN</u>	<u>270/300</u>			
<u>13</u>	<u>13</u>	<u>1-4</u>	<u>1-10</u>	<u>FCAW</u>	<u>2.0</u>	<u>3.6</u>	<u>240/260</u>	<u>21-23</u>	<u>DCEN</u>	<u>270/300</u>			
<u>20</u>	<u>20</u>	<u>1-6</u>	<u>1-15</u>	<u>FCAW</u>	<u>2.0</u>	<u>3.6</u>	<u>240/260</u>	<u>21-23</u>	<u>DCEN</u>	<u>300/390</u>			

<b>Heat treatment</b> Preheat min: <u>AS PER TBL 9.3</u> Interpass temp. max.: _____ <u>OF W59/03</u> Interpass temp. min.: _____ Remarks: _____ _____ _____ _____	<b>CWB Acceptance</b>  <div style="border: 1px solid black; padding: 5px; display: inline-block;"> <b>CWB Accepted</b>        Jun 17, 2008  <small>Valid only if welding consumables are certified by the CWB</small> </div>	<b>Company Authorization</b>    DATE: <u>04 25 2008</u> MONTH DAY YEAR
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