

CANADIAN WELDING BUREAU DIVISION OF CWB GROUP - INDUSTRY SERVICES	WELDING PROCEDURE DATA SHEET	WPDS NO.: <u>SrS#1</u>	Rev.: <u>0</u>
	DATE: <u>04</u> / <u>25</u> / <u>2008</u>		

Company Name: Skelton Industrial Services Ltd Ref. Standards: 47.1 / W59
 Address: P.O. Box 3304 Smithers B.C. V0J-2N0 Ref. WPS: S-SMAW 1

Welding Processes: <u>1 SMAW</u> Pulsed: Yes <input type="checkbox"/> No <input type="checkbox"/>	<u>2 N/A</u> Pulsed: Yes <input type="checkbox"/> No <input type="checkbox"/>	Joint Configuration & Pass/Layer Sequence
Shielding Gas Type: <u>N/A</u>		
Positions: <u>FIAT</u>		
Process Mode: Manual <input checked="" type="checkbox"/> Semi-Auto <input 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>Same as Base</u> Thickness: _____		
Backgouging: Yes <input type="checkbox"/> Method: _____ No <input checked="" type="checkbox"/> Depth: _____		
Electrode Extension: <u>N/A</u>		
Nozzle Diameter(s): <u>N/A</u>		
Flux Classification: <u>N/A</u>		
Tungsten Electrode: Type: <u>N/A</u> Diameter: _____		
Cleaning Procedures: <u>Remove Rust Scale PAINT etc AS PER CSA W59</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"/>		

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 1-23 of CSA W59 tbl 11-1</u>	<u>6-25 mm</u>	
II			

Identification of Filler Material				
Process	Trade Name	Classification	Group	Filter Treatment
<u>SMAW</u>	<u>N/A</u>	<u>E4918</u>	<u>F4</u>	

Welding Parameters													
Thick-ness (mm)	Weld Size/ETT	Layer	Pass Number	Welding Process	Dia. (mm)	Wire Feed Speed (mm/min)	Current (A)	Volt (V)	Current Polarity	Welding Speed (mm/min)	Burn-off Rate (mm²/min)	Gas Flow Rate (L/min)	Heat Input (kJ/mm)
<u>6</u>	<u>6</u>	<u>1-2</u>	<u>1-3</u>	<u>SMAW</u>	<u>3.2</u>	<u>—</u>	<u>115-135</u>	<u>—</u>	<u>DCEP+</u>	<u>1</u>			
<u>12</u>	<u>12</u>	<u>1-2</u>	<u>1-3</u>	<u>SMAW</u>	<u>3.2</u>	<u>—</u>	<u>115-135</u>	<u>—</u>	<u>DCEP+</u>				
<u>12</u>	<u>12</u>	<u>3-4</u>	<u>4-8</u>	<u>SMAW</u>	<u>3.2</u>	<u>—</u>	<u>145-165</u>	<u>—</u>	<u>DCEP+</u>				
<u>20</u>	<u>20</u>	<u>1-2</u>	<u>1-3</u>	<u>SMAW</u>	<u>3.2</u>	<u>—</u>	<u>115-135</u>	<u>—</u>	<u>DCEP+</u>				
<u>20</u>	<u>20</u>	<u>3-6</u>	<u>4-15</u>	<u>SMAW</u>	<u>4.0</u>	<u>—</u>	<u>145-165</u>	<u>—</u>	<u>u u</u>				
<u>25</u>	<u>25</u>	<u>1-2</u>	<u>1-3</u>	<u>SMAW</u>	<u>3.2</u>	<u>—</u>	<u>115-135</u>	<u>—</u>	<u>u u</u>				
<u>25</u>	<u>25</u>	<u>3-7</u>	<u>4-19</u>	<u>SMAW</u>	<u>4.0</u>	<u>—</u>	<u>145-165</u>	<u>—</u>	<u>u u</u>				

Heat treatment: Preheat min: <u>As per CSA W59</u> Interpass temp. max.: <u>N/A</u> <u>tbl 5-3</u> Interpass temp. min.: <u>N/A</u>	CWB Acceptance	Company Authorization
Remarks: _____ _____ _____	<div style="border: 1px solid black; padding: 5px; display: inline-block;"> Welding Procedure Data Sheet CWB Accepted to CSA W47.1 MAY 12 2008 Acceptance valid only when Welding Consumables certified by C.W.B. (CI. 11.8.1. CSA 47.1) </div>	
		DATE: <u>04</u> / <u>25</u> / <u>2008</u>