



CANADIAN WELDING BUREAU
DIVISION OF CWB GROUP - INDUSTRY SERVICES

WELDING PROCEDURE DATA SHEET

WPDS NO.: S. S#16

DATE: 04 / 25 / 2008
MONTH DAY YEAR

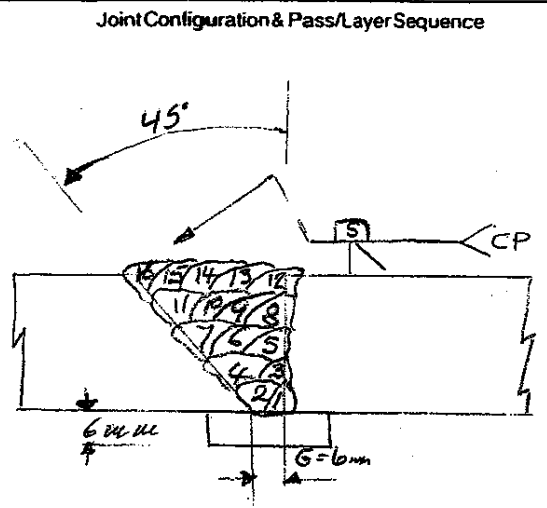
Rev.: 0

Company Name: Stelcon Industrial Services Ltd.
Address: P.O. Box 3304 Smithers B.C. V0J-2N0

Ref. Standards: W47.1/W59

Ref. WPS: S. SMAW#1

Welding Processes:	1 <u>SMAW</u> Pulsed: Yes <input type="checkbox"/> No <input type="checkbox"/>	2 <u>N/A</u> Pulsed: Yes <input type="checkbox"/> No <input type="checkbox"/>
Shielding Gas Type:	<u>N/A</u>	
Positions:	<u>FLAT</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 type="checkbox"/> Depth: _____	
Electrode Extension:	<u>NA</u>	
Nozzle Diameter(s):	<u>NA</u>	
Flux Classification:	<u>NA</u>	
Tungsten Electrode:	Type: <u>NA</u>	Diameter: _____
Cleaning Procedures:	<u>Remove rust scale paint and other contaminants Ref C1.5.2.1 of 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"/>	



Part	Specification & Grade	Thickness or Dia.	Special Requirements
I	<u>Groups 1-2-3 of W59 Table 11.1</u>	<u>10-25 mm</u>	
II			

Process	Trade Name	Classification	Group	Filler Treatment
<u>SMAW</u>	<u>N/A</u>	<u>E4918</u>	<u>F4</u>	<u>Ref. WPS W59 C1.5.2.2.4</u>

Thick-ness ()	Weld Size/ETT	Layer	Pass Number	Welding Process	Dia. ()	Wire Feed Speed ()	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>1-2</u>	<u>1-4</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>115-135</u>	<u>-</u>	<u>DCEP+</u>	<u>75-90</u>	<u>-</u>	<u>-</u>	<u>-</u>
<u>13</u>	<u>13</u>	<u>1-3</u>	<u>1-7</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>115-135</u>	<u>-</u>	<u>DCEP+</u>	<u>75-90</u>	<u>-</u>	<u>-</u>	<u>-</u>
<u>20</u>	<u>20</u>	<u>1-2</u>	<u>1-4</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>115-135</u>	<u>-</u>	<u>DCEP+</u>	<u>75-90</u>	<u>-</u>	<u>-</u>	<u>-</u>
		<u>3-4</u>	<u>5-11</u>	<u>SMAW</u>	<u>4.</u>	<u>-</u>	<u>145-165</u>	<u>-</u>	<u>DCEP+</u>	<u>80-100</u>	<u>-</u>	<u>-</u>	<u>-</u>
<u>25</u>	<u>25</u>	<u>1-2</u>	<u>1-4</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>115-135</u>	<u>-</u>	<u>DCEP+</u>	<u>75-90</u>	<u>-</u>	<u>-</u>	<u>-</u>
		<u>3-5</u>	<u>5-16</u>	<u>SMAW</u>	<u>4.</u>	<u>-</u>	<u>145-165</u>	<u>-</u>	<u>DCEP+</u>	<u>80-100</u>	<u>-</u>	<u>-</u>	<u>-</u>

Heat treatment

Preheat min: As per Table 5.3 Interpasstemp. max.: NA
or W59 Interpasstemp. min.: NA

Remarks:

CWB Acceptance

Company Authorization

Welding Procedure Data Sheet
CWB Accepted to CSA W47.1

MAY 12 2008

Acceptance valid only when Welding
Certificate is certified by C.W.
(C... CSA 47.1)

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