



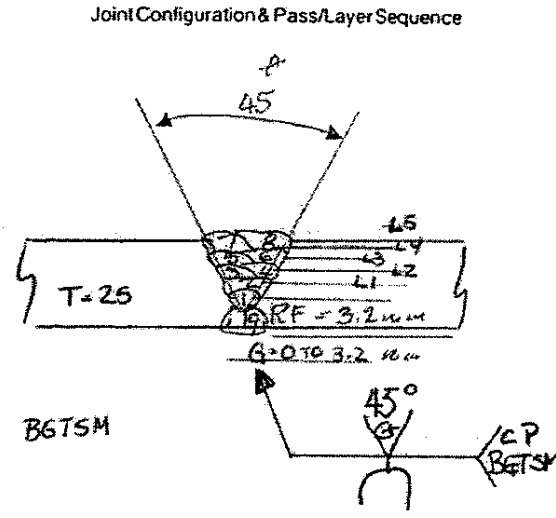
WELDING PROCEDURE DATA SHEET

WPDS NO.: S.S.#11
 DATE: 04/25/2008 Rev.: 0
MONTH DAY YEAR

Company Name: Stelcon Industrial Services Ltd
 Address: P.O. Box 3304 Smithers BC V0S-2W0

Ref. Standards: CSA W47.1 W59/03
 Ref. WPS: S.SMAW#1

Welding Processes:	1 SMAW Pulsed: Yes <input type="checkbox"/> No <input type="checkbox"/>	2 N/A Pulsed: Yes <input type="checkbox"/> No <input type="checkbox"/>
Shielding Gas Type:	N/A	
Positions:	FLAT	
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: N/A Thickness: _____	
Backgouging:	Yes <input checked="" type="checkbox"/> Method: AIR ARC CARBON No <input type="checkbox"/> Depth: TO SOUND METAL	
Electrode Extension:	N/A	
Nozzle Diameter(s):	N/A	
Flux Classification:	N/A	
Tungsten Electrode:	Type: N/A Diameter: _____	
Cleaning Procedures:	CHIPPING AND BRUSHING OR GRIND IF REQ	
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	AS PER GROUPS 1-2-3 OF W59 TBL 11-1	10 to 25mm	
II			

Identification of Filler Material				
Process	Trade Name	Classification	Group	Filler Treatment
SMAW	N/A	E1918	F4	AS PER CSA W59/03 REF

Welding Parameters													
Thick-ness ()	Weld Size/ETT	Layer	Pass Number	Welding Process	Dia. ()	Wire Feed Speed ()	Current A	Volt V	Current Polarity	Welding Speed (mm/M)	Burn-off Rate ()	Gas Flow Rate ()	Heat Input ()
10	10	1	1	SMAW	3.2	NA	120-135	20-25	DCEP+	75-90	NA	NA	NA
		2-3	2-4		4	NA	140-160	21-26	DCEP+	90-120	NA	NA	NA
20	20	1	1	SMAW	4	NA	140-160	21-26	DCEP+	90-120	NA	NA	NA
		2-5	2-10	SMAW	5	NA	180-210	21-26	DCEP+	100-130	NA	NA	NA
25	25	1	1	SMAW	4	NA	140-160	21-26	DCEP+	90-120	NA	NA	NA
		2-6	2-13	SMAW	5	NA	180-210	21-26	DCEP+	100-130	NA	NA	NA

Heat treatment Preheat min: <u>AS PER CSA W59/03</u> Interpass temp. max.: <u>N/A</u> <u>REF TBL 5-3</u> Interpass temp. min.: <u>N/A</u>	CWB Acceptance Valid only if welding consumables are certified by the CWB	Company Authorization
Remarks: <u>ALTERNATE SEQUENCE FROM SIDE TO SIDE SHOULD BE USED TO CONTROL DISTORTION</u>		
DATE: <u>04/25/2008</u> <small>MONTH DAY YEAR</small>		