CWB Form 160

CANADIAN WELDING BUREAU
DIVISION OF CWB GROUP - INDUSTRY SERVICES

WELDING PROCEDURE DATA SHEET

WPDS NO.: S.S#6

DATE: 04 (MONTH) 25 (DAY) 2008 (YEAR) Rev.: 1

Company Name: Skeena Industrial Services Ltd

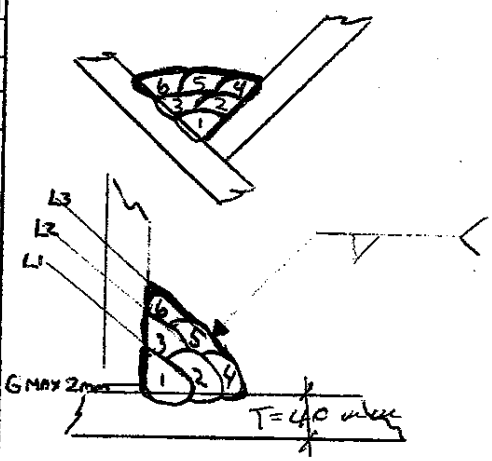
Address: P.O Box 3304 Smithers BC V0J-2N0

Ref. Standards: W47.1 and W5

Ref. WPS: S.SMAW # 1

Welding Processes:	1	SMAW	Pulsed: Yes ☐ No ☒	2	Pulsed: Yes ☐ No
Shielding Gas Type:		N/A			
Positions		FLAT / HORIZ.			
Process Mode		Manual ☑ Semi-Auto ☐ Machine ☐ Auto ☐			
Joint Type		Butt ☐ Tee ☑ Corner ☑ Lap ☑ Edge ☐			
Penetration		Complete ☐ Partial (ETT = _____) ☐ Fillet ☒			
Backing		Material: N/A Thickness:			
Backgouging		Yes ☐ Method: No ☒ Depth:			
Electrode Extension		NA			
Nozzle Diameter(s)		NA			
Flux Classification		NA			
Tungsten Electrode		Type: NA Diameter:			
Cleaning Procedures		REMOVE RUST SCALE PAINT AND OTHER CONTAMINENTS AS PER CL 5.3.1 OF W59			
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 W59 Table 11-1	6 to 40 mm	
II			

Identification of Filler Material

Process	Trade Name	Classification	Group	Filler Treatment
SMAW	N/A	E4918	F4	REF CSA W59 Cl. 5.2.2.

Welding Parameters

Thickness ( )	Weld Size/ ETT	Layer	Pass Number	Welding Process	Dia. ( )	Wire Feed Speed ( )	Current A	Volt V	Current Polarity	Welding Speed ( )	Burn-off Rate ( )	Gas Flow Rate ( )	Heat Input ( )
6	5	1	1	SMAW	3.2	—	100-130	-	DCEP	80-120	-	-	-
10	6	1	1	SMAW	4	—	145-165	-	DCEP	80-100	-	-	-
20	8	1	1	SMAW	4	—	145-165	-	DCEP	75-90	-	-	-
25	10	1	1-3	SMAW	4	—	145-165	-	DCEP	90-110	-	-	-
40	12	1-5	4-6	SMAW	4	—	145-165	-	DCEP	90-120	-	-	-

Heat treatment

Preheat min: PER TABLE 5.3 of W59 Interpass temp. max.: NA

Interpass temp. min.: NA

Remarks:

When gap is 2mm or greater increase fillet size equal to size of gap

CWB Acceptance

Welding Procedure Data Sheet
CWB Accepted to CSA W47.1

MAY 12 2008

Acceptance valid only when Welding Consumables certified by [illegible] (Cl. [illegible].1. CSA 47.1)

Company Authorization

DATE: 04 (MONTH) 25 (DAY) 2008 (YEAR)