



**CANADIAN WELDING BUREAU**  
DIVISION OF CWB GROUP - INDUSTRY SERVICES

**WELDING PROCEDURE DATA SHEET**

WPDS NO.: S.S.#13  
DATE: 04/25/2008 Rev.: 0  
MONTH DAY YEAR

Company Name: Selcon Industrial Services Ltd  
Address: P.O. Box 3304 Smithers BC V0J-2N0

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

Welding Processes: 1 SMAW Pulsed: Yes  No

Shielding Gas Type: N/A

Positions: OVERHEAD

Process Mode: Manual  Semi-Auto  Machine  Auto

Joint Type: Butt  Tee  Corner  Lap  Edge

Penetration: Complete  Partial (ETT = \_\_\_\_\_)  Fillet

Backing: Material: SAME AS BASE Thickness: 6 mm

Backgouging: Yes  Method: \_\_\_\_\_  
No  Depth: \_\_\_\_\_

Electrode Extension: N/A

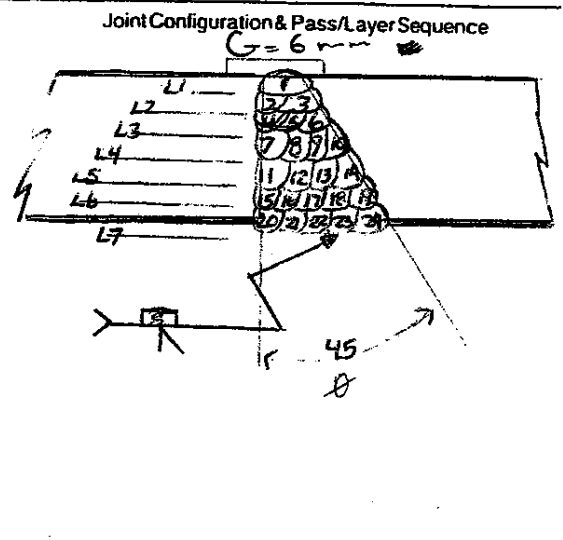
Nozzle Diameter(s): N/A

Flux Classification: N/A

Tungsten Electrode: Type: N/A Diameter: \_\_\_\_\_

Cleaning Procedures: REMOVE RUST SCALE PAINT AND OTHER CONTAMINANTS AS PER W59 CLASS 5.3.1

CSA W186 Rebar Splice Type: Direct Splice  Indirect Splice  Lap Splice   
Rebar to Structural Member Only



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 1-2-3 of W59 Table 11-1</u>	<u>6 to 25 mm</u>	
II			

Identification of Filler Material

Process	Trade Name	Classification	Group	Filler Treatment
<u>SMAW</u>	<u>N/A</u>	<u>E4913</u>	<u>F4</u>	<u>Ref CSA W59 CL5</u>

Welding Parameters

Thickness ( )	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>6</u>	<u>6</u>	<u>1-2</u>	<u>1-3</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-130</u>	<u>-</u>	<u>DCEP+</u>	<u>80-100</u>	<u>-</u>	<u>-</u>	<u>-</u>
<u>13</u>	<u>13</u>	<u>1-4</u>	<u>1-10</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-130</u>	<u>-</u>	<u>DCEP+</u>	<u>80-110</u>	<u>-</u>	<u>-</u>	<u>-</u>
<u>20</u>	<u>20</u>	<u>1-6</u>	<u>1-14</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-130</u>	<u>-</u>	<u>DCEP+</u>	<u>80-110</u>	<u>-</u>	<u>-</u>	<u>-</u>
<u>25</u>	<u>25</u>	<u>1-7</u>	<u>1-24</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>115-135</u>	<u>-</u>	<u>DCEP+</u>	<u>80-110</u>	<u>-</u>	<u>-</u>	<u>-</u>

Heat treatment  
Preheat min: As per CSA W59 Interpass temp. max.: NA  
TABLE 5-3 Interpass temp. min.: NA

CWB Acceptance

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.S.1. CSA 47.1)

Company Authorization

Remarks:

DATE: 04/25/2008  
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