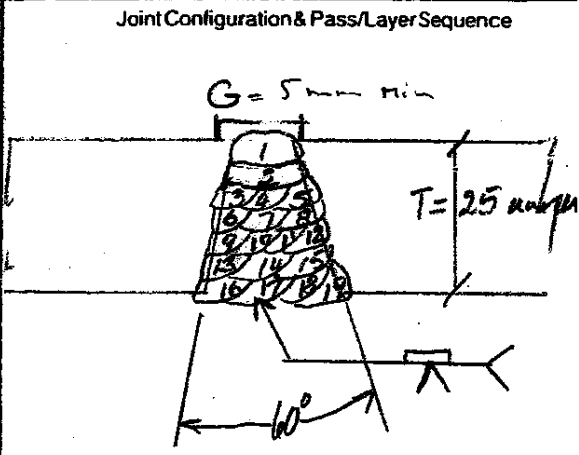


| | | | | | | | | | | |
|-------|--|---------------------------------|--|----|----|----|----|-------|-----|------|
| | CANADIAN WELDING BUREAU DIVISION OF CWB GROUP - INDUSTRY SERVICES | WELDING PROCEDURE DATA SHEET | WPDS NO.: <u>S. S-#3</u> | | | | | | | |
| | | | DATE: <table border="1" style="display: inline-table; border-collapse: collapse;"> <tr> <td style="width: 20px; text-align: center;">04</td> <td style="width: 20px; text-align: center;">25</td> <td style="width: 20px; text-align: center;">20</td> <td style="width: 20px; text-align: center;">09</td> </tr> <tr> <td style="font-size: 8px;">MONTH</td> <td style="font-size: 8px;">DAY</td> <td style="font-size: 8px;">YEAR</td> <td></td> </tr> </table> Rev.: <u>0</u> | 04 | 25 | 20 | 09 | MONTH | DAY | YEAR |
| 04 | 25 | 20 | 09 | | | | | | | |
| MONTH | DAY | YEAR | | | | | | | | |

Company Name: Sphor Industrial Services Ltd Ref. Standards: W47.1/W59
 Address: P.O. Box 3304 Smithers B.C. V0J-2A0 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>Overhead</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 Mat</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 mill scale as per CSA W59 CL. 5.3</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 1-2-3 of W59 table 11-1</u> | <u>6 to 25 mm</u> | |
| II | | | |

| Process | Trade Name | Classification | Group | Filler Treatment |
|-------------|------------|----------------|------------|--------------------|
| <u>SMAW</u> | <u>N/A</u> | <u>E4918</u> | <u>F54</u> | <u>Ref CSA W59</u> |

| Welding Parameters | | | | | | | | | | | | | |
|----------------------|---------------|------------|-------------|-----------------|------------|---------------------|----------------|----------|------------------|-----------------------|-------------------|-------------------|----------------|
| Thick-ness (K or in) | Weld Size/ETT | Layer | Pass Number | Welding Process | Dia. (mm) | Wire Feed Speed () | Current A | Volt V | Current Polarity | Welding Speed (m/min) | Burn-off Rate () | Gas Flow Rate () | Heat Input () |
| <u>6</u> | <u>6</u> | <u>1-2</u> | <u>1-2</u> | <u>SMAW</u> | <u>3.2</u> | <u>-</u> | <u>115-130</u> | <u>-</u> | <u>DCRP+</u> | <u>70-100</u> | | | |
| <u>12</u> | <u>12</u> | <u>1-4</u> | <u>1-8</u> | <u>SMAW</u> | <u>3.2</u> | <u>-</u> | <u>115-130</u> | | <u>u u</u> | <u>80-100</u> | | | |
| <u>20</u> | <u>20</u> | <u>1-6</u> | <u>1-12</u> | <u>SMAW</u> | <u>3.2</u> | <u>-</u> | <u>115-135</u> | | <u>u u</u> | <u>80-110</u> | | | |
| <u>25</u> | <u>25</u> | <u>1-7</u> | <u>1-19</u> | <u>SMAW</u> | <u>3.2</u> | <u>-</u> | <u>115-135</u> | | <u>u u</u> | <u>80-120</u> | | | |

| | | |
|--|---|---------------------------|
| Heat treatment Preheat min: <u>As per CSA W59</u> Interpass temp. max.: <u>N/A</u> <u>TAL 5-3</u> Interpass temp. min.: <u>N/A</u> | CWB Acceptance <div style="border: 1px solid black; padding: 5px; margin: 10px auto; width: 80%;"> 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> | Company Authorization |
| Remarks: | | |
| | | |
| | | |
| | | |

DATE:

| | | | |
|-------|-----|------|----|
| 04 | 25 | 20 | 09 |
| MONTH | DAY | YEAR | |