



CANADIAN WELDING BUREAU
DIVISION OF CWB GROUP - INDUSTRY SERVICES

WELDING PROCEDURE DATA SHEET

WPDS NO.: S. 5 #7
DATE: 04 25 2008 Rev.: 1
MONTH DAY YEAR

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

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

Welding Processes: 1 SMAW Pulsed: Yes No 2 NA Pulsed: Yes No

Shielding Gas Type: 1 N/A 2 NA

Positions: OVERHEAD - FLAT

Process Mode: Manual Semi-Auto Machine Auto

Joint Type: Butt Tee Corner Lap Edge

Penetration: Complete Partial (ETT =) Fillet

Backing: Material: NA Thickness:

Backgouging: Yes Method: CARBON ARC No Depth: TO SOUND METAL

Electrode Extension: NA

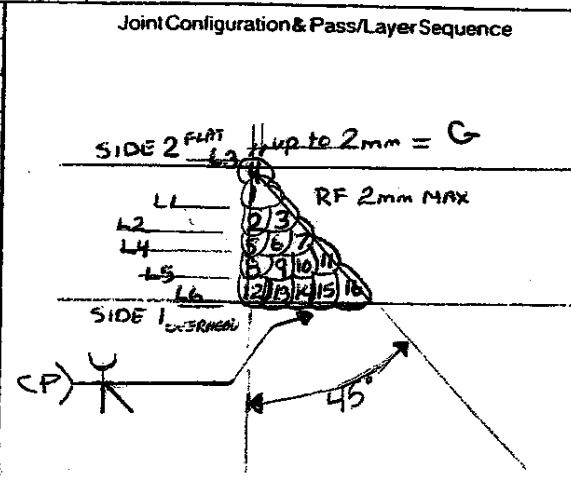
Nozzle Diameter(s): NA

Flux Classification: NA

Tungsten Electrode: Type: NA Diameter:

Cleaning Procedures: Remove rust, scale, paint and other contaminants as per W59 cl. 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>10 TO 25 mm</u>	
II			

Identification of Filler Material

Process	Trade Name	Classification	Group	Filler Treatment
<u>SMAW</u>	<u>N/A</u>	<u>E4918</u>	<u>F4</u>	<u>As per W59 cl. 5</u>

Welding Parameters

Thickness (mm)	Weld Size/ETT	Layer	Pass Number	Welding Process	Dia. (mm)	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>1-3</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-135</u>	<u>-</u>	<u>DCSP+</u>	<u>80-100</u>	<u>-</u>	<u>-</u>	<u>-</u>
<u>SIDE 2</u>	<u>11</u>	<u>3</u>	<u>4</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-135</u>	<u>-</u>	<u>DCSP+</u>	<u>80-100</u>	<u>-</u>	<u>-</u>	<u>-</u>
<u>13</u>	<u>13</u>	<u>1-2-4</u>	<u>1-7</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-135</u>	<u>-</u>	<u>DCSP+</u>	<u>75-90</u>	<u>-</u>	<u>-</u>	<u>-</u>
<u>SIDE 2</u>	<u>11</u>	<u>3</u>	<u>4</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-135</u>	<u>-</u>	<u>DCSP+</u>	<u>75-90</u>	<u>-</u>	<u>-</u>	<u>-</u>
<u>20</u>	<u>20</u>	<u>1-2-4-5</u>	<u>1-11</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-135</u>	<u>-</u>	<u>DCSP+</u>	<u>75-90</u>	<u>-</u>	<u>-</u>	<u>-</u>
<u>SIDE 2</u>	<u>11</u>	<u>3</u>	<u>4</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-135</u>	<u>-</u>	<u>DCSP+</u>	<u>75-90</u>	<u>-</u>	<u>-</u>	<u>-</u>
<u>25</u>	<u>25</u>	<u>1-2-6-8</u>	<u>1-17</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-135</u>	<u>-</u>	<u>DCSP+</u>	<u>75-100</u>	<u>-</u>	<u>-</u>	<u>-</u>
<u>SIDE 2</u>	<u>11</u>	<u>3</u>	<u>4</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-135</u>	<u>-</u>	<u>DCSP+</u>	<u>75-100</u>	<u>-</u>	<u>-</u>	<u>-</u>

Heat treatment: Preheat min: TABLE S.3 Interpass temp. max.: NA
W59 Interpass temp. min.: NA

Remarks: Sequence to be followed when distortion is of concern.

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.3. (Cl. 11.8.1, CSA 47.1)

Company Authorization

DATE: 04 25 2008
MONTH DAY YEAR