CWB Form 1605/99-1

CANADIAN WELDING BUREAU
DIVISION OF CWB GROUP - INDUSTRY SERVICES

WELDING PROCEDURE DATA SHEET

WPDS NO.: S. SMAW #4

DATE: 04 (MONTH) 25 (DAY) 2008 (YEAR) Rev.: 0

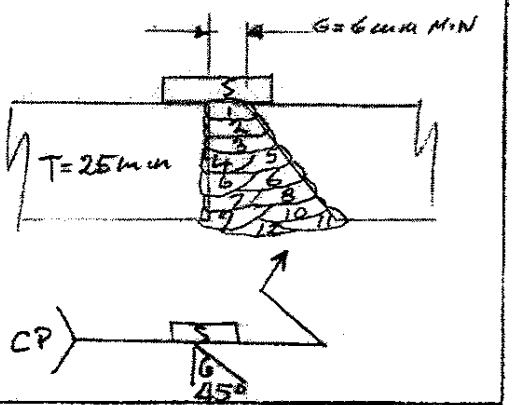
Company Name: Stelcon Industrial Services Ltd.
Address: P.O Box 3304 Smithers B.C V0J-2N0

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

Welding Processes:	1	SMAW Pulsed: Yes ☐ No ☐	2	N/A Pulsed: Yes ☐ No ☐
Shielding Gas Type:		N/A		

Positions	VERTICAL
Process Mode	Manual ☒ Semi-Auto ☐ Machine ☐ Auto ☐
Joint Type	Butt ☒ Tee ☐ Corner ☐ Lap ☐ Edge ☐
Penetration	Complete ☒ Partial (ETT =) ☐ Fillet ☐
Backing	Material: Thickness:
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	CHIPPING BRUSHING OR GRIND WHEN REQ
CSA W186 Rebar Splice Type	Direct Splice ☐ Indirect Splice ☐ Lap Splice ☐ Refer 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	AS PER GROUPS 1-2-3 OF W59/03 TBL 11-1	10 to 25mm	
II			

Identification of Filler Material

Process	Trade Name	Classification	Group	Filler Treatment
SMAW	N/A	E4918	F4	AS PER CL 5 OF W59/03

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 ( )
10	10	1-4	1-5	SMAW	3.2	—	125/135	25-27	DCEP+	75/90			
20	20	1-2	1-2	SMAW	3.2	—	125/135	25/27	DCEP+	75/90			
"	"	3-5	3-5	"	4.0	—	135/145	25/27	DCEP+	80/100			
25	25	1	1	SMAW	3.2	—	125/135	25-27	DCEP+	75/85			
"	"	2-8	2-12	"	4.0	—	135/150	25-27	DCEP+	75/100			

Heat treatment

Preheat min: AS PER TBL 5-3 Interpass temp. max: _____
CF W59/03 Interpass temp. min.: _____

Remarks:

CWB Acceptance

CWB Accepted
Jun 17, 2008
Valid only if welding consumables are certified by the CWB

Company Authorization

Bernard Lott

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