



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

**WELDING PROCEDURE DATA SHEET**

WPDS NO.: S. 5710

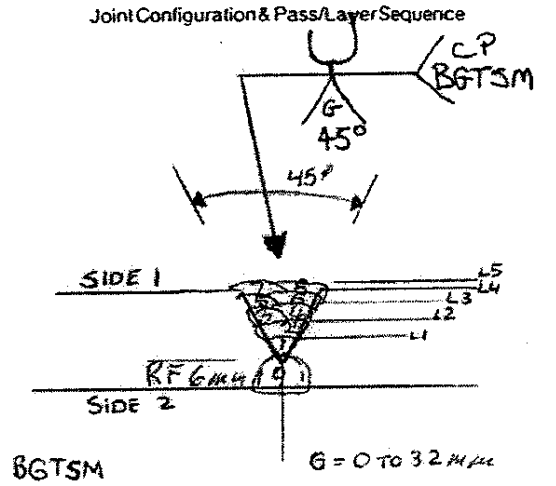
DATE: 04/23/2008  
MONTH DAY YEAR

Rev.: 0

Company Name: Stelcon Industrial Services Ltd  
Address: P.O. Box 3304 Smithers B.C. V0J-2W0

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

Welding Processes:	1 SMAW Pulsed: Yes <input type="checkbox"/> No <input type="checkbox"/>	2 N/A Pulsed: Yes <input type="checkbox"/> No <input type="checkbox"/>
Shielding Gas Type:	N/A	
Positions:	VERTICAL	
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: N/A Thickness: _____	
Backgouging:	Yes <input checked="" type="checkbox"/> Method: AIR ARC CARBON No <input type="checkbox"/> Depth: TO SOUND METAL	
Electrode Extension:	N/A	
Nozzle Diameter(s):	N/A	
Flux Classification:	N/A	
Tungsten Electrode:	Type: N/A Diameter: _____	
Cleaning Procedures:	CHIPPING - BRUSHING - GRINDING WHEN NECESSARY	
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"/>	



Part	Specification & Grade	Thickness or Dia.	Special Requirements
I	AS PER GROUPS 1-2-3 TBL III OF W59/03	10 to 25 mm	
II	EXCLUDING WEATHERING STEELS		

Process	Trade Name	Classification	Group	Filler Treatment
SMAW	N/A	E4918	F4	AS PER CSA W59/03 CL5

Thickness (mm)	Weld Size/ETT	Layer	Pass Number	Welding Process	Dia. (mm)	Wire Feed Speed (mm/min)	Current (A)	Volt (V)	Current Polarity	Welding Speed (mm/M)	Burn-off Rate (mm <sup>2</sup> /min)	Gas Flow Rate (L/min)	Heat Input (kJ/mm)
10	10	1-2	1-2	SMAW	3.2	N/A	115-130	20-25	DCEP4	80-110	N/A	N/A	N/A
13	13	1-3	1-3	SMAW	3.2	N/A	115-130	20-25	DCEP4	80-110	N/A	N/A	N/A
20	20	1-5	1-7	SMAW	3.2	N/A	115-130	20-25	DCEP4	80-110	N/A	N/A	N/A
25	25	1-6	1-9	SMAW	3.2	N/A	115-130	20-25	DCEP4	80-110	N/A	N/A	N/A

Heat treatment: Preheat min: AS PER TBL 3 OF W59/03 Interpass temp. max.: N/A  
Interpass temp. min.: N/A

Remarks: TO PREVENT DISTORTION WHEN A CONCERN ALTERNATE SEQUENCE SHOULD BE USED

CWB Acceptance

**CWB Accepted**

Jun 17, 2008

Valid only if welding consumables are certified by the CWB

Company Authorization

*[Signature]*

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