



CANADIAN WELDING BUREAU
DIVISION OF CWB GROUP - INDUSTRY SERVICES

WELDING PROCEDURE DATA SHEET

WPDS NO.: S.S.#2

DATE: 04/25/2008
MONTH DAY YEAR

Rev.: 1

Company Name: Skolon Industrial Services Ltd

Ref. Standards: W47.1/W59

Address: P.O. Box 3304 Smithers B.C V0J-2W0

Ref. WPS: S.S.MAW #1

Welding Processes: 1 SMAW Pulsed: Yes No 2 N/A Pulsed: Yes No

Shielding Gas Type: N/A

Positions: VERTICAL UP

Process Mode: Manual Semi-Auto Machine Auto

Joint Type: Butt Tee Corner Lap Edge

Penetration: Complete Partial (ETT = _____) Fillet

Backing: Material: SAME AS BASE METAL Thickness: _____

Backgouging: Yes Method: _____
No Depth: _____

Electrode Extension: N/A

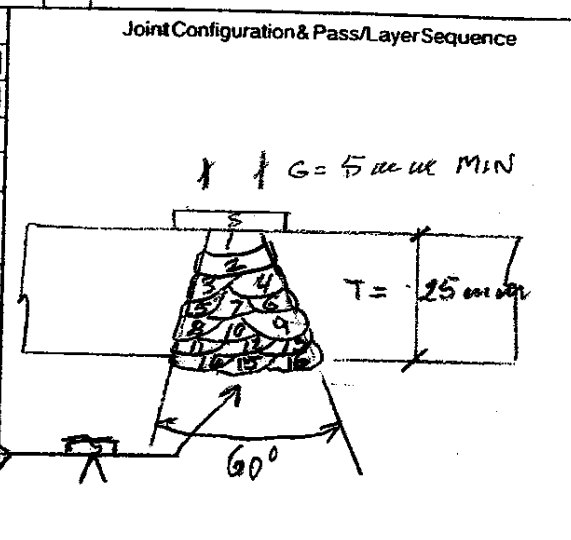
Nozzle Diameter(s): N/A

Flux Classification: N/A

Tungsten Electrode: Type: N/A Diameter: _____

Cleaning Procedures: Remove Rust, Scale PAINT etc as per CSA W59

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</u>	<u>6 to 25 mm</u>	
II			

Identification of Filler Material

Process	Trade Name	Classification	Group	Filler Treatment
<u>SMAW</u>	<u>NA</u>	<u>E4918</u>	<u>F4</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>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>12</u>	<u>12</u>	<u>1-4</u>	<u>1-6</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>115-130</u>		<u>U U</u>				
<u>20</u>	<u>20</u>	<u>1-5</u>	<u>1-13</u>	<u>SMAW</u>	<u>3.2</u>		<u>115-135</u>		<u>U U</u>				
<u>25</u>	<u>25</u>	<u>1-7</u>	<u>1-18</u>	<u>SMAW</u>	<u>3.2</u>		<u>115-135</u>		<u>U U</u>				

Heat treatment: Preheat min: As per W59 Table 5-3 Interpass temp. max.: N/A Interpass temp. min.: N/A

Remarks:

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. 11.8.1. CSA 47.1)

Company Authorization

[Signature]

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