

	CANADIAN WELDING BUREAU DIVISION OF CWB GROUP - INDUSTRY SERVICES	WELDING PROCEDURE DATA SHEET	WPDS NO.: <u>S. 5#8</u>
			DATE: <u>04/25/2008</u> Rev.: <u>1</u> <small>MONTH DAY YEAR</small>

Company Name: Sekon Industrial Services Ltd Ref. Standards: W 47.1 / W 59-
 Address: P.O. Box 3304 Smithers B.C. V0J-2W0 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>VERTICAL UP</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 type="checkbox"/> Partial (ETT = _____) <input type="checkbox"/> Fillet <input type="checkbox"/>	
Backing	Material: <u>N/A</u> Thickness: _____	
Backgouging	Yes <input checked="" type="checkbox"/> Method: <u>CARBON ARC</u> No <input type="checkbox"/> Depth: <u>TO SOUND METAL</u>	
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, scale, paint and other contaminants as per W59 clause 5</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"/>	

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	<u>Group 1-2-3 of CSA W59 Table 11-1</u>	<u>10 TO 25 mm dia</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 W59/03 CL</u>

Welding Parameters													
Thick-ness ()	Weld Size/ETT	Layer	Pass Number	Welding Process	Dia. ()	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>1-2</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-130</u>	<u>-</u>	<u>DEEP+</u>	<u>65-80</u>	<u>-</u>	<u>-</u>	<u>-</u>
<u>SIDE 2</u>	<u>10</u>	<u>3</u>	<u>3</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-130</u>	<u>-</u>	<u>DEEP+</u>	<u>70-100</u>			
<u>13</u>	<u>13</u>	<u>1-2-4</u>	<u>1-2-4</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-130</u>	<u>-</u>	<u>DEEP+</u>	<u>70-80</u>			
<u>SIDE 2</u>	<u>13</u>	<u>3</u>	<u>3</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-130</u>	<u>-</u>	<u>DEEP+</u>	<u>70-100</u>			
<u>20</u>	<u>20</u>		<u>1-</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-130</u>	<u>-</u>	<u>DEEP+</u>	<u>70-90</u>			
<u>SIDE 2</u>	<u>20</u>	<u>3</u>	<u>3</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-130</u>	<u>-</u>	<u>DEEP+</u>	<u>70-100</u>			
<u>25</u>	<u>25</u>	<u>1-6</u>	<u>1-8</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-130</u>	<u>-</u>	<u>DEEP+</u>	<u>70-90</u>			
<u>SIDE 2</u>	<u>25</u>	<u>3</u>	<u>3</u>	<u>SMAW</u>	<u>3.2</u>	<u>-</u>	<u>110-130</u>	<u>-</u>	<u>DEEP+</u>	<u>70-100</u>			

Heat treatment Preheat min: <u>As per Table 5.3</u> Interpass temp. max.: <u>NA</u> <u>or W59</u> Interpass temp. min.: <u>NA</u>	CWB Acceptance <div style="border: 1px solid black; padding: 5px; margin: 5px auto; width: 80%;"> Welding Procedure Data Sheet CWB Accepted to CSA W47.1 MAY 12 2008 Acceptance valid on: Consumables cert.: _____ (Cl. 11.8.1. CSA 47.1) </div>	Company Authorization
Remarks: <u>sequence to be followed when distortion is a concern</u>		
DATE: <u>04/23/08</u> <small>MONTH DAY YEAR</small>		