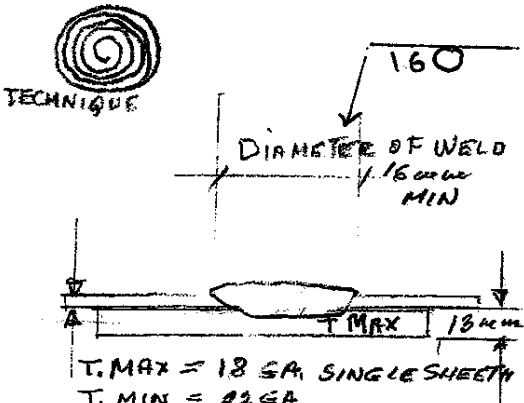


CANADIAN WELDING BUREAU DIVISION OF CWB GROUP - INDUSTRY SERVICES	WELDING PROCEDURE DATA SHEET	WPS NO.: <u>S. RD#1</u>	
		DATE: <u>04/25/2008</u>	Rev.: <u>0</u>

Company Name: Splon Industrial Services Ltd Ref. Standards: W47.1/AWS D1.3
 Address: P.O. Box 3304 Smithers B.C V0J-2W0 Ref. WPS: SMAW#2

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: <u>FLAT</u> Process Mode: Manual <input checked="" type="checkbox"/> Semi-Auto <input type="checkbox"/> Machine <input type="checkbox"/> Auto <input type="checkbox"/> Joint Type: But <input type="checkbox"/> Yes <input type="checkbox"/> Corner <input type="checkbox"/> Lap <input checked="" type="checkbox"/> Edge <input type="checkbox"/> Penetration: Complete <input type="checkbox"/> Partial (ETT = <u>7"</u>) <input type="checkbox"/> Fillet <input type="checkbox"/> Backing: Material: <u>STEEL</u> Thickness: Backgouging: Yes <input type="checkbox"/> Method: No <input checked="" type="checkbox"/> Depth: 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 Procedure: <u>CHIPPING BRUSHING</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  <p>TECHNIQUE</p> <p>DIAMETER OF WELD 160mm MIN</p> <p>T. MAX = 18 GA SINGLE SHEETH T. MIN = 22 GA</p>
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Identification of Base Material (for CSA W186 indicate carbon equivalent, max. phosphorus & sulphur content)			
Part	Specification & Grade	Thickness or Dia.	Special Requirements
I	<u>ASTM A 44C</u>	<u>22 to 18 GA</u>	
II	<u>Groups 1, 2, 3 of Table 11-1 W59</u>	<u>13 mm</u>	

Process	Trade Name	Classification	Group	Filler Treatment
<u>SMAW</u>	<u>N/A</u>	<u>E4311</u>	<u>F3</u>	<u>AS PER W59/03 CL5</u>

Welding Parameters													
Thick-ness (GA)	Weld Size ETT	Layer	Pass Number	Welding Process	Dia. (mm)	Wire Feed Speed	Current A	Volt V	Current Polarity	Welding Speed	Burn-off Rate (kg/hr)	Gas Flow Rate	Heat Input
<u>22 GA</u>	<u>22</u>	<u>1</u>	<u>1</u>	<u>SMAW</u>	<u>4.0</u>	<u>—</u>	<u>110/125</u>	<u>23/27</u>	<u>DCEP+</u>	<u>—</u>	<u>200</u>		
<u>20 GA</u>	<u>20</u>	<u>1</u>	<u>1</u>	<u>SMAW</u>	<u>4.0</u>	<u>—</u>	<u>110/125</u>	<u>23/27</u>	<u>DCEP+</u>	<u>—</u>	<u>192</u>		
<u>18 GA</u>	<u>18</u>	<u>1</u>	<u>1</u>	<u>SMAW</u>	<u>4.0</u>	<u>—</u>	<u>125/140</u>	<u>23/27</u>	<u>DCEP+</u>	<u>—</u>	<u>225</u>		

Heat treatment Preheat min: _____ interpass temp. max: _____ _____ interpass temp. min: _____	CWB Acceptance	Company Authorization
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Remarks: <div style="border: 1px solid black; padding: 5px; text-align: center; margin: 10px auto; width: fit-content;"> On the Basis of PREVIOUS TESTS ACCUMULATED BY THE CWB </div>	Welding Procedure Data Sheet CWB Accepted to CSA W47.1 <div style="text-align: center; margin: 10px auto;"> MAY 12 2008 </div> Acceptance valid only when Welding Consumables certified by C.W.B. (Cl. 11.8.1. CSA 47.1)	<div style="text-align: right; margin-top: 10px;"> DATE: <u>04/25/2008</u> <small>MONTH DAY YEAR</small> </div>
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