



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

**WELDING PROCEDURE DATA SHEET**

WPDS NO.: S. RD#2  
DATE: 04/25/2008 Rev.: 0  
MONTH DAY YEAR

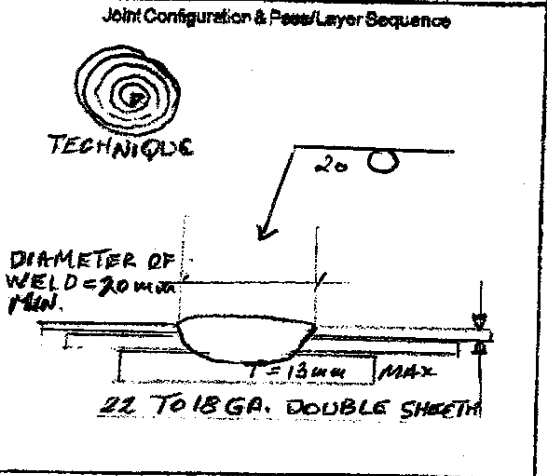
Company Name: Stelcon Industrial Services Ltd.  
Address: P.O. Box 3304 Smithers B.C. V0G-2W0

Ref. Standards: W47.1/AWS D1.3  
Ref. WPS: S. SMAW #2

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

2 Pulsed: Yes  No

Positions: FLAT  
Process Mode: Manual  Semi-Auto  Machine  Auto   
Joint Type: Butt  Yes  Corner  Lap  Edge   
Penetration: Complete  Partial (ETT = 2")  Fillet   
Backing: Material: STEEL 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 Procedure: CHIPPING BRUSHING  
CSA W188 Rebar Splice Type: Direct Splice  Indirect Splice  Lap Splice   
Rebar to Structural Member Only



Identification of Base Material (for CSA W188 indicate carbon equivalent, max. phosphorus & sulphur content)

Part	Specification & Grade	Thickness or Dia.	Special Requirements
I	<u>ASTM A416</u>	<u>22 to 18 GA.</u>	
II	<u>Group 1, 2, 3 of Table 11-1 W59</u>	<u>13 mm</u>	

Identification of Filler Material

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

Welding Parameters

Thick-ness (GA)	Weld Size ETT	Layer	Pass Number	Welding Process	Dia. (Pa. In.)	Wire Feed Speed	Current A	Volt V	Current Polarity	Welding Speed	Burn-off Rate (mm/hr)	Gas Flow Rate	Heat Input
<u>22</u>		<u>1</u>	<u>1</u>	<u>SMAW</u>	<u>4.0</u>	<u>—</u>	<u>125/130</u>	<u>23/27</u>	<u>DCEP</u>	<u>—</u>	<u>207</u>		
<u>20</u>		<u>1</u>	<u>1</u>	<u>SMAW</u>	<u>4.0</u>	<u>—</u>	<u>130/140</u>	<u>23/27</u>	<u>DCEP</u>	<u>—</u>	<u>220</u>		
<u>18</u>		<u>1</u>	<u>1</u>	<u>SMAW</u>	<u>4.0</u>	<u>—</u>	<u>140/150</u>	<u>23/27</u>	<u>DCEP</u>	<u>—</u>	<u>210</u>		

Heat treatment	CWB Acceptance	Company Authorization
Preheat min: _____ interpass temp. max.: _____ interpass temp. min.: _____	Welding Procedure Data Sheet CWB Accepted to CSA W47.1  MAY 12 2008 Acceptance valid only when Welding Consumables certified by C.W.B. (C. 11.8.1. CSA 47.1)	
Remarks: _____ _____		DATE: <u>04/25/2008</u> MONTH DAY YEAR