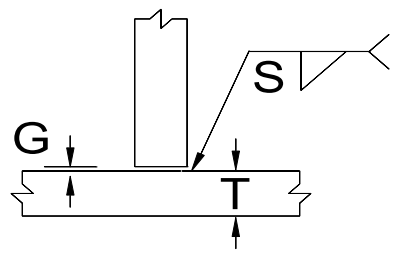
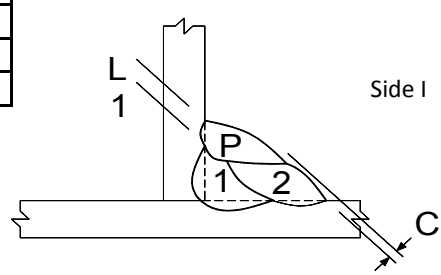


WELDING PROCEDURE DATA SHEET (WPDS)		WPDS No.:	SMAW - F1																								
		Rev:	0																								
RC Technical Services 512 MacDougall Road MacDougall Settlement, N.B.		Date:	July 09, 2019																								
		Ref. WPS:	SMAW-CS																								
		Ref. Standards:	CSA W47.1, CSA W59																								
		Prequalified joint no. / PQR no.:	CSA W59, clause 10.1.3.3																								
Base Metal:		Filler Metal / Classification																									
CSA W59, Table 11.1, GROUPS 1, 2, 3		CSA W48: E4918-H8 or -H4, E4918-1-H8 or -H4, AWS A5.1: E7018-H8 or -H4, E7018-1-H8 or -H4																									
Thickness: 3mm (1/8") to Unlimited		Process: SMAW																									
Shielding:	N/A	<table border="1" style="margin: auto;"> <tr><th colspan="2">Min. Single Pass Fillet Size</th></tr> <tr><td>T mm</td><td>S minimum</td></tr> <tr><td>T ≤ 6</td><td>3mm (1/8")</td></tr> <tr><td>6 < T ≤ 12</td><td>5mm (3/16")</td></tr> <tr><td>12 < T ≤ 20</td><td>6mm (1/4")</td></tr> <tr><td>20 < T</td><td>8mm (5/16")</td></tr> </table> <table border="1" style="margin: auto;"> <tr><th colspan="2">Max. Single Pass Fillet Size</th></tr> <tr><td>Position</td><td>S Max.</td></tr> <tr><td>Flat</td><td>10mm (3/8")</td></tr> <tr><td>Horizontal</td><td>8mm (5/16")</td></tr> <tr><td>Vertical - up</td><td>12mm (1/2")</td></tr> <tr><td>Overhead</td><td>8mm (5/16")</td></tr> </table>   <p> G = 0 to 1mm C = as per CSA W59 L = add more weld layers as required. P = add more weld passes as required. See CSA W59 table 4.4 for min. single pass fillet size. See CSA W59 table 10.1 for maximum criteria. </p>		Min. Single Pass Fillet Size		T mm	S minimum	T ≤ 6	3mm (1/8")	6 < T ≤ 12	5mm (3/16")	12 < T ≤ 20	6mm (1/4")	20 < T	8mm (5/16")	Max. Single Pass Fillet Size		Position	S Max.	Flat	10mm (3/8")	Horizontal	8mm (5/16")	Vertical - up	12mm (1/2")	Overhead	8mm (5/16")
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Gas Flow Rate:	N/A																										
Metal Transfer Mode:	N/A																										
Process Mode:	MANUAL																										
Position:	F, H, V-up, OH																										
Joint Type:	LAP, CORNER, TEE																										
Weld Type:	FILLET																										
Penetration:	N/A																										
Electrode Stickout:	N/A																										
Eff. Throat Thickness:	ETT = .7S																										
Preheating Temp.	10°C & Table 5.3 W59																										
Interpass Temp.:	260°C (500°F) MAX																										
Backgouging Method:	N/A																										
Backgouging Depth:	N/A																										
Backing Material:	N/A																										
Backing Thickness:	N/A																										

Welding Parameters:													
Weld Size, S mm in	Side	Layer	Pass	Electrode Diameter inch	Current Polarity	Amperes		WFS inch / min.		Volts		Arc Travel in/min	
						Min	Max	Min	Max	Min	Max	Min	Max
5 3/16	I	1	1	1/8	DCRP	90	- 160						
6 1/4	I	1	1	1/8	DCRP	90	- 160						
8 5/16	I	1 - 2	1 - 3	1/8	DCRP	90	- 160						
Unlimited	I	1 - L	1 - P	5/32	DCRP	110	- 200						

Remarks:	CWB Approval:	Company's Approval: