PROBATIONARY WELDER QUALIFICATION
(CSA W47.1 clause 8.2.3)

PWQ No.:	PWQ - S - Fillet
Date:	July 10, 2019
Ref. WPS:	SMAW-CS
Ref. Standards:	CSA W47.1 CSA W59

RC Technical Services
512 MacDougall Road
MacDougall Settlement, N.B.

Base Metal:
CSA W59, Table 11.1, G40.21: 300W (44W)
Yield strength: 345 MPa and under

Filler Metal / Classification
CSA W48: E4918-H8 or -H4, E4918-1-H8 or -H4,
AWS A5.1: E7018-H8 or -H4, E7018-1-H8 or -H4

Test Plate Thickness: 6mm (1/4") to 10mm (3/8")

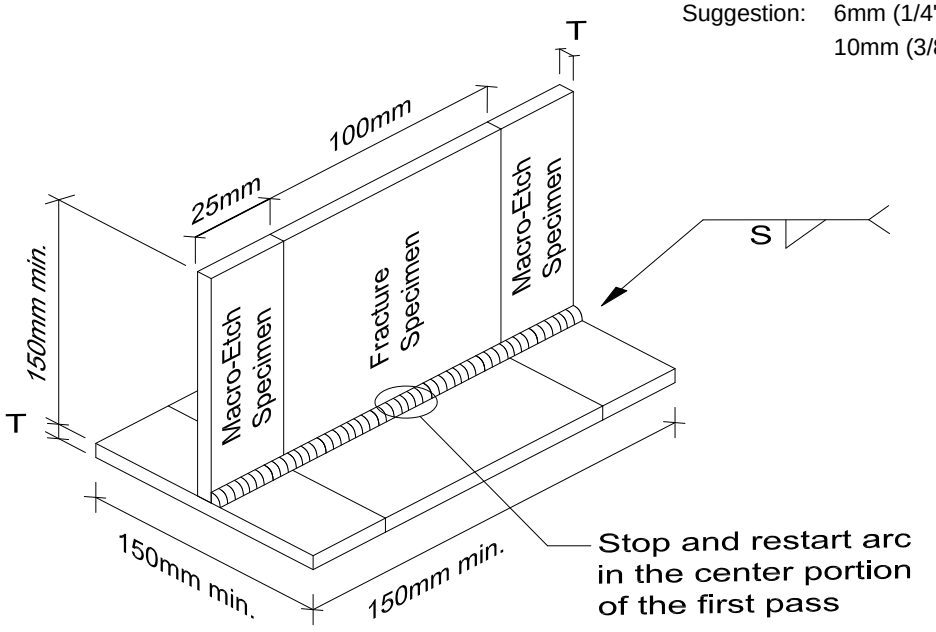
Process: **SMAW**

Position:	Flat, Hor., V-up, Over Head	**Backing Thickness:**	N.A.
Joint Type:	LAP, CORNER, TEE	**Backgouging Method:**	N.A.
Weld Type:	FILLET	**Backgouging Depth:**	N.A.
Eff. Throat Thickness:	ETT = 0.7S	**Shielding Gas:**	N.A.
Preheating Temp.:	10°C & Table 5.3 W59	**Gas Flow Rate:**	N.A.
Interpass Temp.:	260ºC (500ºF) MAX	**Electrode Stick out:**	N.A.

Reference: CSA W47.1, figure 6

Thickness = T = 6mm (1/4") ≤ T ≤ 10mm (3/8")
Suggestion: use 2 pieces of 6mm (1/4") or 10mm (3/8") plate

S = Fillet size = 2/3T ≤ S ≤ 10mm (3/8")
Suggestion: 6mm (1/4") plate, use a 5mm (3/16") fillet weld.
10mm (3/8") plate, use a 6mm (1/4") fillet weld.



Welding Parameters:

Weld Size, S mm	Weld Size, S in	Side	Layer	Pass	Electrode Diameter inch	Current Polarity	Amperes Min	Amperes Max	WFS in / min. Min	WFS in / min. Max	Volts Min	Volts Max	Arc Travel in / min Min	Arc Travel in / min Max
		I			1/8	DCRP	90	160						
		I			5/32	DCRP	110	220						

Welder`s Name:	**Positions tested and accepted by the CWB welding supervisor:**
Test Date:	**CWB Welding Supervisor`s name:**
Method of testing: 2 MACRO-ETCH & 1 FRACTURE	**CWB Welding Supervisor`s signature:**