

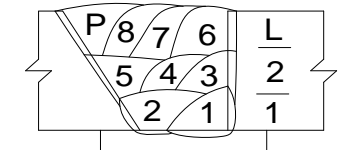
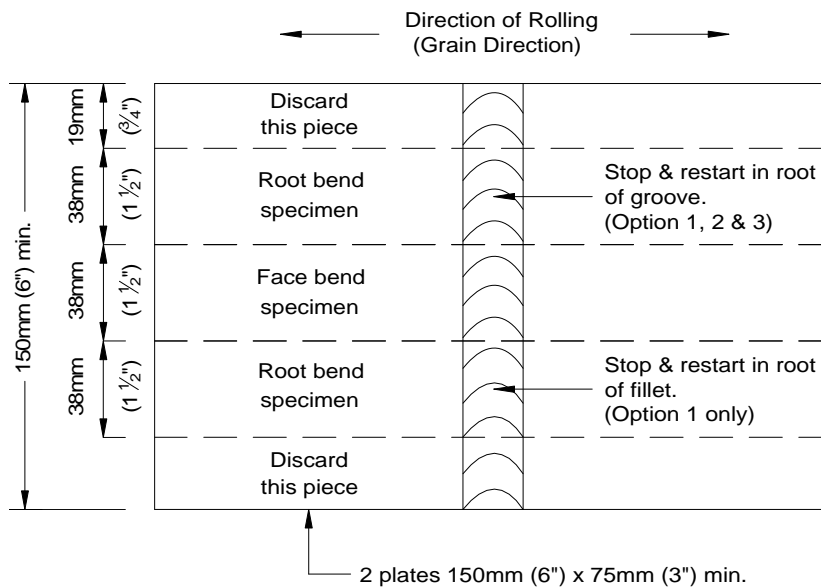
<b>PROBATIONARY WELDER QUALIFICATION</b> <b>(CSA W47.1 clause 8.2.3)</b>	PWQ No.:	<b>PWQ - S - 01</b>
	Date:	July 10, 2019
	Ref. WPS:	SMAW-CS
	Ref. Standards:	CSA W47.1 CSA W59

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

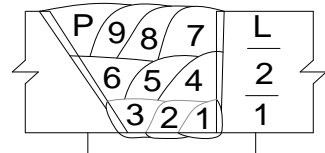
<b>Base Metal:</b> CSA W59, Table 11.1, G40.21: 300W (44W) Yield strength: 345 MPa and under	<b>Filler Metal / Classification</b> <b>CSA W48:</b> E4918-H8 or -H4, E4918-1-H8 or -H4, <b>AWS A5.1:</b> E7018-H8 or -H4, E7018-1-H8 or -H4
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<b>Test Plate Thickness:</b> 10mm (3/8")	<b>Process:</b> <b>SMAW</b>
<b>Position:</b> Flat, Hor., V-up, Over Head	<b>Backing Thickness:</b> 6mm (1/4")
<b>Joint Type:</b> BUTT	<b>Backgouging Method:</b> N.A.
<b>Weld Type:</b> SINGLE BEVEL GROOVE	<b>Backgouging Depth:</b> N.A.
<b>Eff. Throat Thickness:</b> ETT = T	<b>Shielding Gas:</b> N.A.
<b>Preheating Temp.:</b> 10°C & Table 5.3 W59	<b>Gas Flow Rate:</b> N.A.
<b>Interpass Temp.:</b> 260°C (500°F) MAX	<b>Electrode Stick out:</b> N.A.

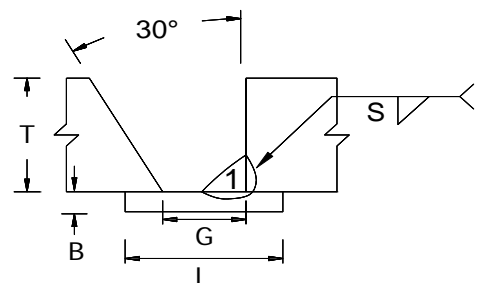
Reference: CSA W47.1, figure 8, Option 1.



Option 1 (GF)



Flat, V-up, and OH could have 2 or 3 Passes on Layer #1. The max. fillet size is 8mm (5/16") for Pass #1.



T = Thickness = 10mm (3/8")  
B = 6mm (1/4")  
L = 50mm (2")  
G = 13mm (1/2") for Flat, V-up & OH Positions  
G = 8mm (5/16") for Hor. Position  
S = fillet size = 8mm (5/16") max.

## Option 1

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

<b>Welder's Name:</b>	<b>Positions tested and accepted by the CWB welding supervisor:</b>
<b>Test Date:</b>	<b>CWB Welding Supervisor's name:</b>
<b>Method of testing:</b> 2 ROOT BENDS & 1 FACE BEND	<b>CWB Welding Supervisor's signature:</b>