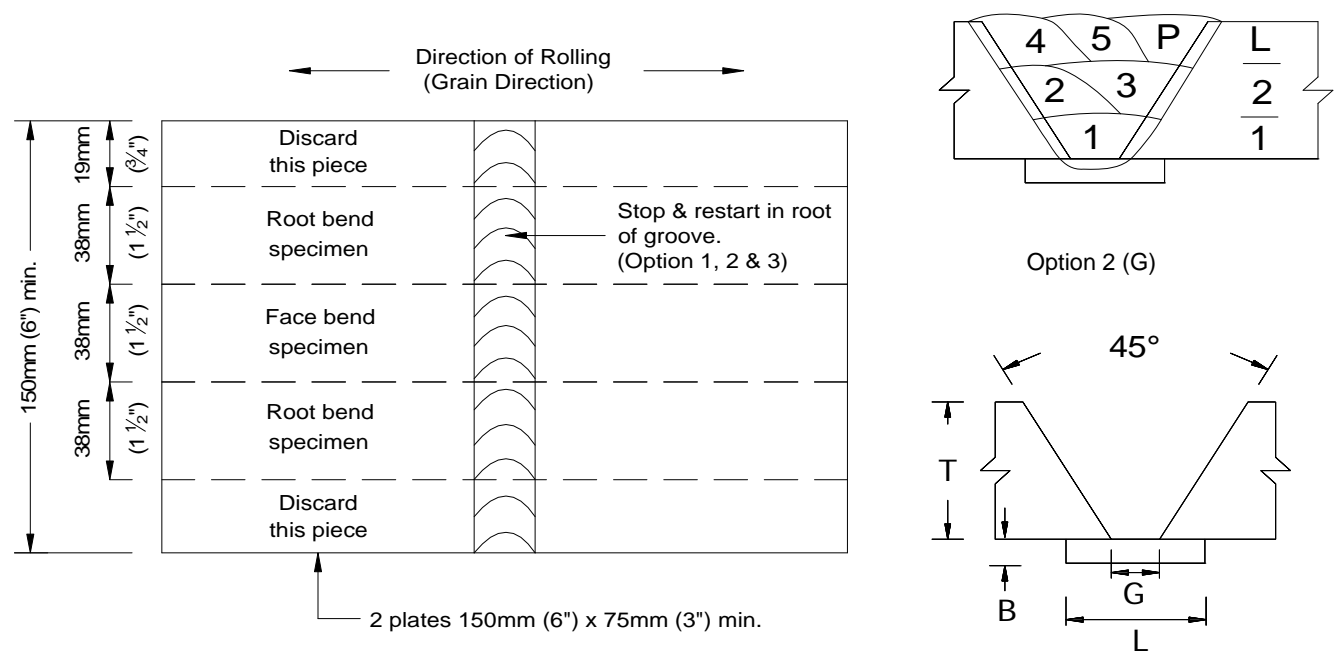


PROBATIONARY WELDER QUALIFICATION (CSA W47.1 clause 8.2.3)		PWQ No.:	PWQ - S - O2
		Date:	July 10, 2019
RC Technical Services 512 MacDougall Road MacDougall Settlement, N.B.		Ref. WPS:	SMAW-CS
		Ref. Standards:	CSA W47.1 CSA W59
Base Metal: CSA W59, Table 11.1, G40.21: 300W (44W) Yield strength: 345 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: 10mm (3/8")		SMAW	
Position:	Flat, Hor., V-up, Over Head	Backing Thickness:	6mm (1/4")
Joint Type:	BUTT	Backgouging Method:	N.A.
Weld Type:	SINGLE V GROOVE	Backgouging Depth:	N.A.
Eff. Throat Thickness:	ETT = T	Shielding Gas:	N.A.
Preheating Temp.:	10°C & Table 5.3 W59	Gas Flow Rate:	N.A.
Interpass Temp.:	260°C (500°F) MAX	Electrode Stick out:	N.A.

Reference: CSA W47.1, figure 8, Option 2.



T = Thickness = 10mm (3/8")
 B = 6mm (1/4")
 L = 50mm (2")
 G = 6mm (1/4")

Note: Option 2 also requires the welder to qualify a fillet weld test.

Option 2

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						

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