| WELDING PROCEDURE DATA SHEET (WPDS) | | | | | | WPDS No.: FCAW - PLUG1 | | | | |
|-------------------------------------|------|---------------------|-----------------|--|--|------------------------|-----------------------|-------------------------|-------------------|--|
| | | | | | | Rev: | | | 0 | |
| RC Technical Services | | | | | | Date: | e: July 28, 2019 | | | |
| 512 MacDougall Road | | | | | | Ref. WPS: | FCAW-CS | | | |
| MacDougall Settlement, N.B. | | | | | | Ref. Standards: | | | 7.1, CSA W59 | |
| | | | | | | Prequalified joint n | o.: CSA | 4 W47.1 Claι | ıse 11.2.2. b) ii | |
| Base Metal: | | | | | | Filler Metal / Classi | fication | | | |
| | | | | CSA W48 : E491T-9-H8 | | | | | | |
| CSA W59, Table 11.1, GROUPS 1, 2, 3 | | | | | | aws a5.20: E71T-9-H8 | | | | |
| | | | | | | | | | | |
| | | | | | | | E | CAW | | |
| Thickness: SEE SKETCH | | | | | Process: | | CAN | | | |
| Shielding: | _ | | | | - | | | | | |
| Gas Flow Rate: | | | | | | | | | | |
| Metal Transfer Mode: SPRA | | | | | \neg | | | | | |
| | | EMI-AUTOMATIC | | | | | | | | |
| Position: | | | | | | | | | | |
| Joint Type: TEE | | | | Weld Te | echnique | | | | | |
| | | LUG | | | | | | | \rightarrow | |
| | | ARTIAL | | $2 \min 9 = -$ | | | | | | |
| | | 1/2" to 3/4" | | $\frac{5\text{mm}(3_{16}^{"})}{5} \rightarrow \frac{1}{16}$ Fill flush Side I | | | | | | |
| | | AREA OF HOLE | | $10 \text{mm} \left(\frac{3}{8}^{"}\right) \leftarrow 1 \qquad 1 \qquad \text{Layer}$ | | | | - Laver | | |
| | | 0°C & Table 5.3 W59 | | | | | | | | |
| | | 260°C (500°F) MAX | | 1 | | Ť | | | | |
| Backgouging Method: N/A | | | | 1 | | - | | – 19mm Ø (³ | 4 ") | |
| Backgouging Depth: N/A | | | | | | | | Ladder Ru | ng | |
| | | | | Hole diameter = 21mm (13/16") | | | | | | |
| Backing Thickness: | | SEE SKETCH | | Ladder rung diameter = 19mm (3/4") | | | | | | |
| | | | | Fill thickness | s = 5mm (3/ | 16") | \bigcirc \bigcirc | | | |
| ↓ | | | | 4 | Wald to sha invest | | | | | |
| | | | Weld technique: | | | | | | | |
| | | | | | Continuous pass shall be deposited around the root of the joint and then deposited | | | | | |
| | | | | along a spiral path to the center of the hole. If the arc is broken or the slag is allowed to cool, remove the slag completely before restarting the weld. | | | | | | |
| | | | | allowed to c | ool, remove | the slag complete | ely before restart | ing the weld. | | |
| | | | | | | | | | | |
| Welding Parameters: | 0.1 | | 5 | | <u> </u> | | 14/50 | N/ 14 | • - - | |
| Fill Thickness | Side | Layer | Pass | Electrode | Current | Amperes | WFS | Volts | Arc Travel | |
| mm in | | | | Diameter | Polarity | (() == () | inch / min. | ((== () | in/min | |
| | | | | inch | | (+/-10%) | (+/-10%) | (+/-7%) | (+/-15%) | |
| 5 3/16 | | 1 | 1 | 1/16 | DCRP | 325 | 300 | 27 | 20 | |
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| Domortoo | | | | | | | ^ | | | |
| Remarks: | | | | CWB Approval: | | | Company's Approval: | | | |
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