PROBATIONARY WELDER QUALIFICATION
(CSA W47.1 clause 8.2.3)

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

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

Position: Flat, Hor., V-up, Over Head
Joint Type: LAP, CORNER, TEE
Weld Type: FILLET
Eff. Throat Thickness: ETT = 0.7S
Preheating Temp.: 10°C & Table 5.3 W59
Interpass Temp.: 260°C (500°F) MAX

Process: SMAW

Shielding Gas: N.A.
Gas Flow Rate: N.A.
Electrode Stick out: N.A.

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.

Reference: CSA W47.1, figure 6

Graphical representation of test plate and specimen

Stop and restart arc in the center portion of the first pass

Welding Parameters:

<table>
<thead>
<tr>
<th>Weld Size, S (mm)</th>
<th>Side</th>
<th>Layer</th>
<th>Pass</th>
<th>Electrode Diameter (inch)</th>
<th>Current Polarity</th>
<th>Amperes (Min, Max)</th>
<th>WFS in / min. (Min, Max)</th>
<th>Volts (Min, Max)</th>
<th>Arc Travel in / min (Min, Max)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>I</td>
<td>1/8</td>
<td></td>
<td>DCRP</td>
<td></td>
<td>90 - 160</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>I</td>
<td>5/32</td>
<td></td>
<td>DCRP</td>
<td></td>
<td>110 - 220</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

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:

Questions or Tech. support? email: raycormier@rogers.com