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

Base Metal:
CSA W59, Table 11.1, GROUPS 1, 2, 3

Thickness: 6 mm (1/4") to UNLIMITED
Shielding: Argon + 10% CO2
Gas Flow Rate: 30 - 40 CFH
Metal Transfer Mode: SPRAY
Process Mode: SEMI-AUTOMATIC
Position: FLAT
Joint Type: LAP
Weld Type: PLUG
Penetration: COMPLETE
Electrode Stickout: 19 mm (3/4")
Effective Area: AREA OF HOLE
Preheating Temp.: 10°C & Table 5.3 W59
Interpass Temp.: 260°C (500°F) MAX
Backgouging Method: N/A
Backgouging Depth: N/A
Backing Material: See base metal above
Backing Thickness: 6 mm (1/4") minimum

Weld Technique:
Continuous pass shall be deposited around the root of the joint and then continue along a spiral path to the center of the hole, fusing a layer of weld at the root and bottom of the joint. Remove silicon islands, check for fusion. Check maximum interpass temperature. Repeat, fusing successive layers to fill the hole to the required depth. Maximum layer thickness 6 mm (1/4").

Welding Parameters:

<table>
<thead>
<tr>
<th>T1</th>
<th>Plug Weld Depth mm</th>
<th>Side</th>
<th>Layer</th>
<th>Pass</th>
<th>Electrode Diameter mm</th>
<th>Current Amperes</th>
<th>WFS inch/min</th>
<th>Volts</th>
<th>Arc Travel in/min</th>
</tr>
</thead>
<tbody>
<tr>
<td>12</td>
<td>12</td>
<td>1</td>
<td>1-2</td>
<td>1-2</td>
<td>0.045</td>
<td>DCRP</td>
<td>250</td>
<td>340</td>
<td>29</td>
</tr>
<tr>
<td>16</td>
<td>16</td>
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<td>1-3</td>
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</tr>
</tbody>
</table>

Remarks:
Mis-located holes may be repaired by welding only with the approval of contractor’s engineer.

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