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

Base Metal:
CSA W59, Table 11.1: GROUPS 1, 2, 3 welded to:
CSA G30.18: Grade 400W (C.E. < 0.50, see remarks below)

process:
SMAW

Shielding: N/A
Gas Flow Rate: N/A
Metal Transfer Mode: N/A
Process Mode: MANUAL
Position: FLAT, HORIZONTAL
Joint Type: FLARE BEVEL TEE
Weld Type: FILLET WELD
Penetration: N/A
Electrode Stickout: N/A
Eff. Throat Thickness: 0.7S
Min. preheating Temp.: Table 11.1: Groups 1, 2, 3
CSA G30.18: 400W
10°C & Table 5.3, W59
* If the steel temperature is below 0°C (32°F), a preheat and interpass temperature of 50°C (122°F) shall be used.
Max. Interpass Temp.: Table 11.1: Groups 1, 2, 3
CSA G30.18: 400W
260°C (500°F)
Backgouging Method: N/A
Backgouging Depth: N/A
Backing Material: N/A
Backing Thickness: N/A

Material to be welded Member # Thickness Range
Table 11.1: Groups 1, 2, 3 T1 40mm (1-1/2")
CSA G30.18: 400W T2 (rebar) 10mm (3/8") to 20mm (3/4")

Welding Parameters:

<table>
<thead>
<tr>
<th>Weld size, S</th>
<th>Side</th>
<th>Layer</th>
<th>Pass</th>
<th>Electrode Diameter</th>
<th>Current Polarity</th>
<th>Amperes Min</th>
<th>Amperes Max</th>
<th>WFS Min</th>
<th>WFS Max</th>
<th>Volts Min</th>
<th>Volts Max</th>
<th>Arc Travel Min</th>
<th>Arc Travel Max</th>
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Remarks:
This document shall not be used to join rebar to rebar in concrete structures or weldments under CSA W186 certification.

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