

Company Name & Address WeldProc-Demo Calm Waters, Toronto, ON, A1B 2C3	WELDING PROCEDURE DATA SHEET (WPDS)	Date	09-Aug-2017
		WPDS No	GM-BVVG-FH6
		Rev	0
		WPS No	WPS-GMAW-CS
		PQR No	NA
		Ref. Std	W47.1 / W59

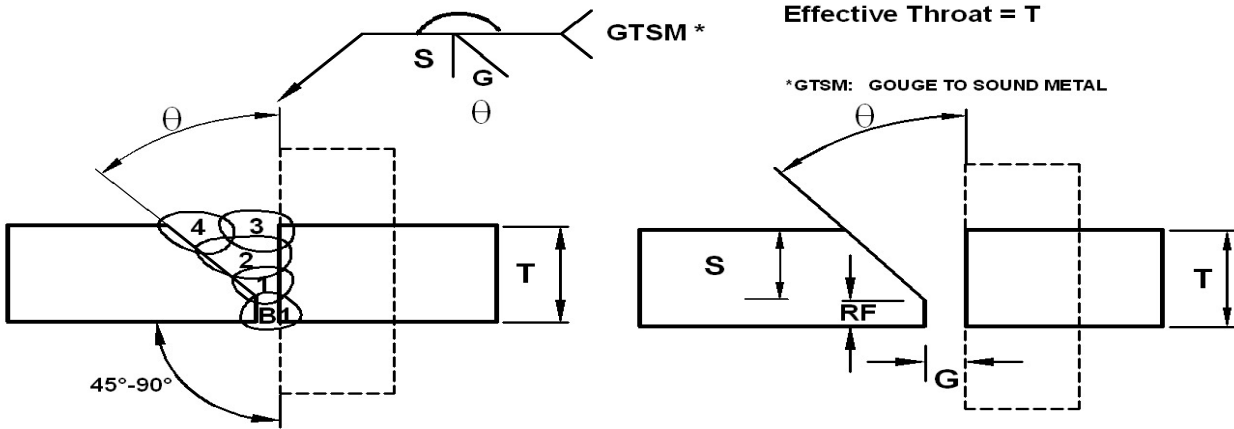
Process	GMAW	Mode	Semi-Automatic
Electrode/ Wire Classification	B-G 49A 3 C G6 (ER49S-6)	Polarity	DCEP
Shielding Gas	90 % Ar + 10% CO2	Nozzle Dia	1/2"-3/4" (12 mm-19 mm)
Flow Rate	35-45 CFH	Stickout	1/2"-5/8" (12 mm-16 mm)
Preheat Temp / Inter pass Temp	As per Table 5.3 of W59-13	Position	Flat/Horizontal

Base Material CSA G40.21: 38W,38WT,44W(HSS),44W,44WT,50W,50W(HSS),50WT,55W,55WT, ASTM: A36, A131 Grades A,B,CS,D,DS,E,AH32,DH32 and EH32, A515 Grades 55, 60, A516 Grades 55, 60, 65, 70, A529 Grades 50, 55, A537 Class 1, A 572 Grades 42, 50, 55, A573 Grades 58,65, A633 Grades A, C, D, A709 Grades 36, 50,50W, 50S, HPS 50W, A808, A913 Grade 50, A992, A1008 SS Grades 30,33 Type 1, 40 Type 1, A1008 HSLAS Grades 45 Class 1,2, 50 Class 1,2, 55 Class 1,2, A1008 HSLAS-F Grade 50, A1011 SS Grades 30, 33, 36 Type 1, 40, 45, 50, 55, A1011 HSLAS Grades 45 Class 1, 2, 50 Class 1,2, 55 Class 1,2, A1011 HSLAS-F Grade 50, A1018 SS Grades 33,36,40, A1018 HSLAS Grades 45 Class 1, 2, 50 Class 1,2, 55 Class 1,2, 60 Class 2, A1018 HSLAS-F Grades 50, 60 Class 2

Penetration	CJP	Weld Type	Complete Penetration Bevel Groove Weld, Welded From Both Sides With Backgouging
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Joint Preparation and Layer/Pass Sequence

Groove Angle (θ)	45	Root Gap (G)	1/8" (3mm) max	Root Face (RF)	1/16" (2 mm) min	Radius (R)	NA
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BUTT, TEE & CORNER JOINT

Thickness (T) in (mm)	Weld Size/ETT in (mm)	Side	Layer	Pass	Electrode /Wire Dia. in (mm)	Current (Amps)	WFS (IPM)	Voltage (V)	Travel Speed (IPM)	Heat Input (kJ/in)
3/8(10)	T	1	1-2	1-3	0.045(1.2)	220-250	250-300	26-29	16-20	
		2	B	B1	0.045(1.2)	220-250	250-300	26-29	10-12	
1/2(12)	T	1	1-3	1-4	0.045(1.2)	220-250	250-300	26-29	12-15	
		2	B	B1	0.045(1.2)	220-250	250-300	26-29	10-12	

Remarks: 1. The values given in the parentheses may not be exact equivalents and are included for information only. 2. Neither the depth nor the maximum width in the cross-section of weld metal deposited in each weld pass shall exceed the width of the face of the weld pass. 3. Electrode/Wire and Shielding Gas Combination Certified by CWB Shall be used. 4. Number of layers/passes shown above may vary within limits set in W59. Travel Speed shall be adjusted accordingly. 5. Deposit additional Pass as required to fill the gouged depth.	CWB Authorization	Company Authorization