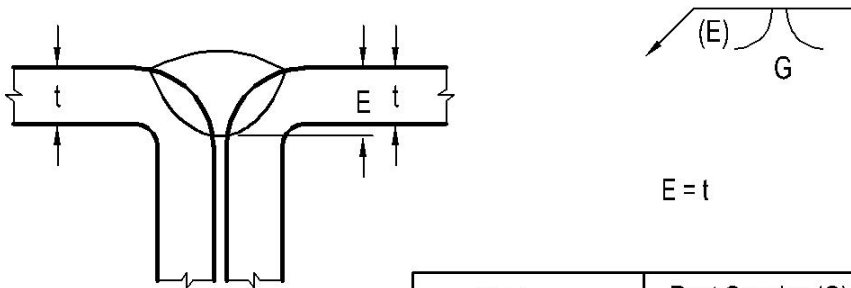


Prepared By: WeldCanada.com, Inc.		PREQUALIFIED WELDING PROCEDURE DATA SHEET		WPDS No.	DEMO
				Ref. WPS	FCAW-CS
Company Name: <i>www.WeldCanada.com</i> Address: <i>info@WeldCanada.com, Toll Free: 1 (877) WPS-WELD</i>				Ref. Standards	AWS D1.3/ CSA W47.1
Process	FCAW	Process Mode	Semi-Automatic	Position	F, H, V (up), OH
Base Materials	A653SQ (Galvanized), A1011 SS, A606, A1011 HSLAS, A611; Matching Grades of Table 1.1-AWS D1.3				
Wire Class. (CSA W48)	E491T-11-H8, E491T-11-H16 (FCAW-S)				
AWS Classification	A5.20, E71T-11, E71T-11 H16 (FCAW-S)				
Shielding Gas (Flux for SAW)	Self-Shielded (FCAW-S)			Flow Rate	N/A
				Nozzle Dia.	5/8 in
Weld Type	Partial Joint Penetration Groove Weld			Current/ Polarity	DCEN
Electrical Stick Out ESO (in)	1/2 to 3/4		Preheat/ Interpass Temp., Min		0 C (32F), Clause 5.1-AWS D1.3 Surfaces free from moisture

Joint Configuration/ Joint Details:



Thickness	Root Opening (G)
7 Ga. (max)	0 (min)
18 Ga. (min)	t / 2 (max)

Figure 3.3 C

Welding Parameters:

Thickness (T) mm (in)	Weld Size ETT (E)	Side	Weld Layers	Pass Numbers	Filler Dia. mm (in)	Current Amps	Volts V	Wire Feed Speed (IPM)	Travel Speed (IPM)
18 Ga. to 7 Ga. 11Ga. to 7 Ga.	T	1	1 to 2	1 to 2	1.1/ 1.2 mm (0.045)	120	15	70	10 to 25
						140	16	90	
						160	17	110	
						170	18	130	

Notes or Code Guidance:

- A570 replaced with new A1011 SS, and A607 replaced with A1011 HSLAS
- Depending upon welding position, weld type, surface condition or other factors, voltage and/or wire feed speed may need to be adjusted.
- Thicker sheets like 7 Ga., if used, may need more than 1 layer and pass.

Welding Supervisor or Welding Engineer

CWB Acceptance

