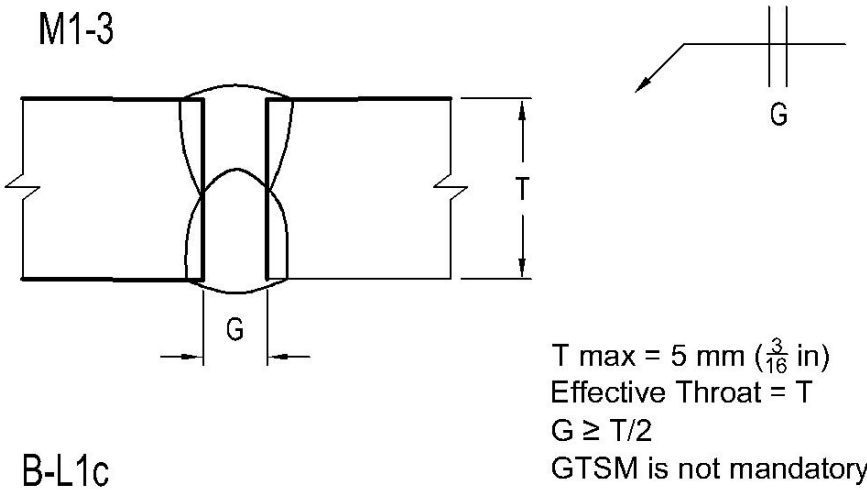


Prepared By: Your Company Name Shown Here		PREQUALIFIED WELDING PROCEDURE DATA SHEET		WPDS No.	DEMO for Service Package (B)
Company Name: Your Client's Company Name Here Address: Your Client's Company Address Here				Ref. WPS	SMAW-CS
Process	SMAW	Process Mode	Manual	Positions	F, H, V (up), OH
Base Materials	Steels in Groups 1, 2 & 3 of Table 11.1/12.1 of CSA W59-03 (Excluding weathering steels)				
Electrode (CSA W48)	E4918, E4918-H4, E4918-H8 (Or) E4918-1, E4918-1-H4, E4918-1-H8				
AWS Classification	A5.1, E7018, E7018 H4 or H4R, E7018 H8; E7018-1, E7018-1 H4 or H4R, E7018-1 H8				
Weld Type	Complete Joint Penetration Groove Weld			Polarity	DCEP or AC
Cleaning Procedure	Chip, File, Brush and/ or Grind				
Interpass Temp., Max				Preheat/ Interpass Temp., Min	Up to 20 mm (3/4): 0 °C (32 °F); Table 5.3-CSA W59 for more

Joint Configuration/ Joint Details:



Welding Parameters:

Thickness (T) mm (in)	Weld Size ETT (E)	Side	Weld Layers	Pass Numbers	Filler Dia. mm (in)	Current Amps	Alternate Filler Size mm (in)	Current Amps
T ≤ 5 mm (3/16)	T	1 and 2	Root, Fill, Cap	As Required, see notes	3.2 mm (1/8)	110-150	2.4 mm (3/32)	75-110

Notes or Code Guidance:

- Number of passes varies based on joint configuration, position, electrode size, travel speed, and weld technique.
- First pass should be large enough to minimize the possibility of cracking.
- F=Flat, H=Horizontal, V=Vertical, OH=Overhead
- Maximum thickness of layers is 6 mm (1/4) for root pass and 5 mm (3/16) for subsequent layers.
- The groove in a joint may be reversed where more practical or necessary.
- Larger size electrodes may be used for fill and/ or cap passes of the thicker material.
- Smaller size electrodes usually applicable for root passes and/ or for thinner material.

John Smith, Welding Engineer

CWB Acceptance

Caution Note: Use of prequalified joint is not intended as a substitute for engineering judgment in the suitability of application to a welded assembly or connection.