



**CANADIAN WELDING BUREAU**  
DIVISION OF CWB GROUP - INDUSTRY SERVICES

**WELDING PROCEDURE DATASHEET**

WPDS NO.: \_\_\_\_\_

DATE: 

MONTH	DAY	YEAR					

 Rev.: \_\_\_\_\_

Company Name \_\_\_\_\_ Ref. Standards: \_\_\_\_\_

Address \_\_\_\_\_ Ref. WPS: \_\_\_\_\_

Welding Processes:	1	Pulsed: Yes <input type="checkbox"/> No <input type="checkbox"/>	2	Pulsed: Yes <input type="checkbox"/> No <input type="checkbox"/>
Shielding Gas Type:				

Positions	Joint Configuration & Pass/Layer Sequence	
Process Mode	Manual <input type="checkbox"/> Semi-Auto <input type="checkbox"/> Machine <input type="checkbox"/> Auto <input type="checkbox"/>	
Joint Type	Butt <input type="checkbox"/> Tee <input type="checkbox"/> Corner <input type="checkbox"/> Lap <input type="checkbox"/> Edge <input type="checkbox"/>	
Penetration	Complete <input type="checkbox"/> Partial (ETT = _____) <input type="checkbox"/> Fillet <input type="checkbox"/>	
Backing	Material: _____	Thickness: _____
Backgouging	Yes <input type="checkbox"/> Method: _____ No <input type="checkbox"/> Depth: _____	
Electrode Extension		
Nozzle Diameter(s)		
Flux Classification		
Tungsten Electrode	Type: _____	Diameter: _____
Cleaning Procedures		
CSA W186 Rebar Splice Type	Direct Splice <input type="checkbox"/> Indirect Splice <input type="checkbox"/> Lap Splice <input type="checkbox"/> Rebar to Structural Member Only <input type="checkbox"/>	

**Identification of Base Material** (for CSA W186 indicate carbon equivalent, max. phosphorus & sulphur content)

Part	Specification & Grade	Thickness or Dia.	Special Requirements
1			
■			

**Identification of Filler Material**

Part	Specification & Grade	Thickness or Dia.	Special Requirements
■			
■			

**Welding Parameters**

Thick-ness ( )	Weld Size/ETT	Layer	Pass Number	Welding Process	Dia. ( )	Wire Feed Speed ( )	Current A	Volt V	Current Polarity	Welding Speed ( )	Burn-off Rate ( )	Gas Flow Rate ( )	Heat Input ( )

<b>Heat treatment</b>	<b>CWB Acceptance</b>	<b>Company Authorization</b>
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Preheat min: _____ Interpass temp. max.: _____ _____ Interpass temp. min.: _____		
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Remarks:		

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