

Welding Engineer Forum Q&A - July 2021

Q: A note on approved WPDS format. CWB should send back separate WPDS (not all combined in one pdf).

A: Once accepted the WPDS are secured as a package, they can be printed and used independently.

Q: So +/- 25% on travel speed would not be accepted?

A: Welding parameters should reflect those reported on the PQR, depending on the situation a +/-25% seems reasonable, but in some cases, it is not permitted (i.e.: W47.2 or when impact test was conducted)

Q: What if you have multiple PQRs for one data sheet with mechanical testing, where the parameters are scattered? How do you consolidate that onto a data sheet if the parameter ranges, even after the +/- % has been applied, do not overlap? ex. Do you have to specify the parameters separately for (10 mm - 25 mm) and (>25mm)?

A: When multiple PQR are required to cover a thickness range, the corresponding revised WPDS should reflect the parameters used during testing for each thickness ranges. For complex procedure testing, it is worth reviewing with your clients how the test will be done to ensure they understand the purpose of the test and what it will qualify

Q: So, an ASME procedure test witnessed by the Regulatory Authority could be used to write a CSA W47.1 procedure, if mechanical testing is complete and has passed?

A: Yes, if the procedure tests were witnessed to the same extent as what CWB is witnessing, then it can be used to accept non-prequalified WPDS within the essential variables of CSA welding standards.

Q: For stainless steel pre-qualification does Annex K of CSA W47.1-2019 take precedence over AWS D1.6 (CSA W591-2018)? Annex K is more restrictive than AWS D1.6.

A: If Annex K is specifically listed on the data sheet, it takes precedence however, D1.6 requirements should also be met providing that it is also referenced on the data sheet. But if the referenced standards are W47.1, AWS D1.6 (without referencing Annex K), then D1.6 takes precedence.

Q: What is the extent of witnessing by an independent third party is required to have CWB accepting it

A: The extent of witnessing shall be the same as what CWB is witnessing, this means 100% of the welding of the test plates and the use of accredited laboratory for testing

Q: Can we get a certificate confirming our participation to this forum?

A: Yes, upon request, we can issue participation certificate for attending the welding engineer forum. Please forward your request directly to André Boulianne andre.boulianne@cwbgroup.org