

Welding Engineer Forum Q&A - July 2021

A: Welding parameter hold effect on the PQR, depending on the variation $\pm 25\%$ is permissible, but in some cases, it is not permitted (i.e.: W47.2 on thin materials are considered)

A: When multiple PQRs are required to cover a thickness range, the corresponding welded WPDS hold effect parameter is determined for each thickness range. For compliance testing, it is the welding procedure that the weld will be done on that the thickness and the location of the weld and the material

A: Yes, if the procedure is defined on the parameter and a CWB is involved, then it can be used to accept non-certified WPDS within the essential table of CSA welding standards.

A: If Annex K is specifically listed on the data sheet, it takes precedence over D1.6. The item hold also be modifying the material reference on the data sheet. But if the referenced standard is W47.1, AWS D1.6 (including Annex K),