



The Welding Specialists

- * Pre-Employment Courses
- * Journeyman Welder Upgrading
- * CWB/ASME Training & Testing
- * SMAW/FCAW/GTAW/GMAW

CWB Test Information

Rules & Regulations

1. **Reservation Policy:** All reservations must be held with a valid credit card. Reservations can be cancelled up to 24 hours prior to the test date with no charge. If they are cancelled within 24 hours of the test date then the full test cost will be charged to the credit card given.
2. All materials including electrodes, coupons, welding shields, chipping hammers etc are supplied by test centre.
3. Electrode size: E7018 – 1/8” (3.2 mm) or larger diameter.
4. NO GRINDERS, SAW BLADES, FILES OR METHODS THAT REMOVE DEPOSITED METAL OR ALTER WELD BEAD PROFILE ARE PERMITTED.
5. All coupons will be cut and bent on site. Ready Arc Training and Testing will cut and bend coupons for an additional charge of \$35 per coupon
6. Test is comprised of four (4) positions: flat, horizontal, vertical & overhead – refer to attached diagrams.
7. All coupons have a backing strip attached – refer to attached diagrams.
8. ¾ hour is allowed per coupon.
9. Upon successful completion of the welder’s test, the CWB will issue a “Welder Identification Card” to the individual with the test facility name indicated on it. NOTE: The “Welder Identification Card” is only valid while the welder is employed by a CWB certified company.
10. If a welder wishes to retest on any failed position(s), he/she should contact Ready Arc Training and Testing for further test dates.

Phone: (506)696-8336

Email: info@readyarc.ca

Web: readyarc.ca

Facebook: Ready Arc Training and Testing

Shipping/ Mailing Address:

70 McIlveen Dr.

Saint John, NB

E2J 4Y7



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TECHNIQUES TO AID IN PASSING CWB TESTS

- Tack only in outer perimeters of the plate
- No chipping hammer marks or stray arcs on plate
- Use as much heat as you can “handle” on the first two passes
- Fill in the craters at the ends of the welds to the full cross section of the groove
- Do not build weld up more than 3 mm (1/8”) above the surface of the plates
- No more than 0.8mm (1/32”) undercut
- No grinders, saw blades, files or tools for metal removal are allowed
- Ensure that you are never weaving up against the square cut plate- always point to the square cut plate when welding to it.
- You are required to make stop-starts as directed by the CWB representative. They will ask for them on the first pass (fillet weld) and on the second pass as the opposite end of the test coupon. Do not make any other stop-starts close to the one that you have made for the CWB representative. Keep them as far apart as possible. When the coupon is welded properly there should never be any stop-starts other than what is required by the CWB rep.
- Always restart the arc ahead of the crater where you stopped. Then move back into the crater, fill it and continue to weld.
- The second pass must touch the bevel plate.
- Technique for the fill passes is up to the welder, but it is generally considered easier and there is less chance of leaving a defect in the weld if the stringer passes are used. The vertical position may be an exception.
- The legs of the fillet weld must not vary in size by more than 1.5mm (1/16”)
- Fillet weld size is 8mm (5/16”) maximum (this means that you can put on a 5mm, 6mm or 8mm fillet weld)
- If attempting three passes in the root area, make sure enough room is left to fuse the third pass to the backing strip.

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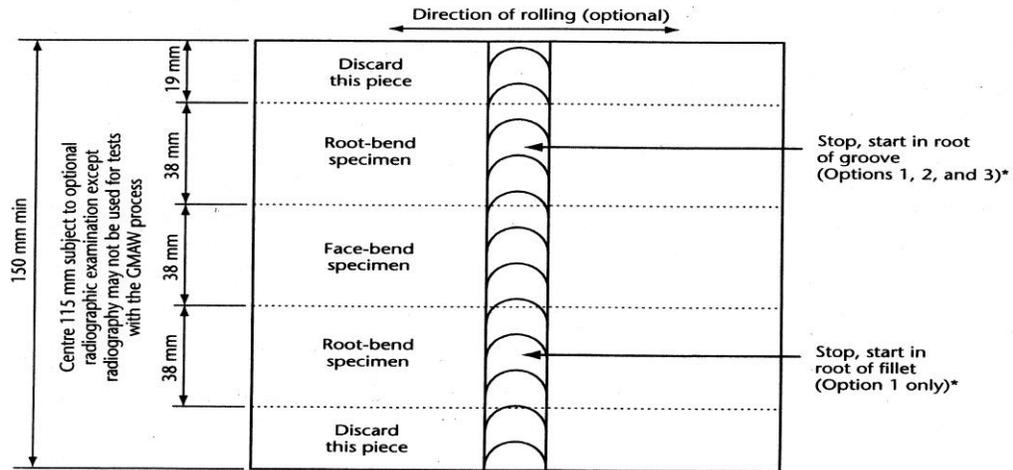
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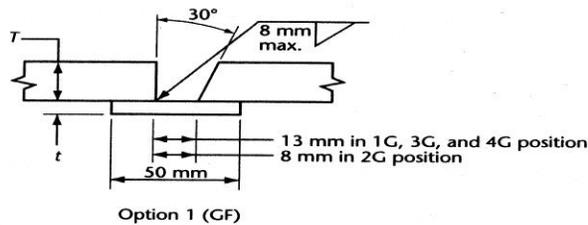
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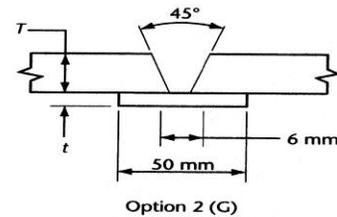


*Use techniques adopted by the company.

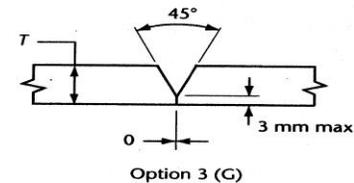
2 plates 150 mm x 75 mm min



Option 1 (GF)



Option 2 (G)



Option 3 (G)

Notes:

- (1) For Option 1 for 1G, 3G, and 4G positions, the fillet weld shall be 8 mm max and shall be visually inspected for leg size, undercut, and profile.
- (2) Options 2 and 3 also require the welder or welding operator to qualify for a fillet weld (see Figure 6 and Table 2).
- (3) $T = 10$ mm, except $T = 6$ mm for GTAW process and GMAW process short circuiting.
- (4) $t = 5$ to 8 mm; 6 mm is recommended.

Figure 8
Plate test assembly for S classification for SMAW, GMAW, and GTAW processes

(See Clauses 8.5.1, 8.5.6, 9.4.1.1, 9.4.3.3, 9.4.3.4, 9.9.8, 9.11.2, 9.14.2.1.1, 9.14.2.2, and 9.14.2.3.1, Tables 2 and 7, and Figure 2.)