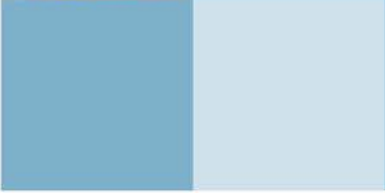
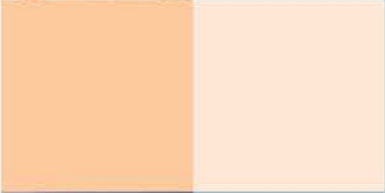
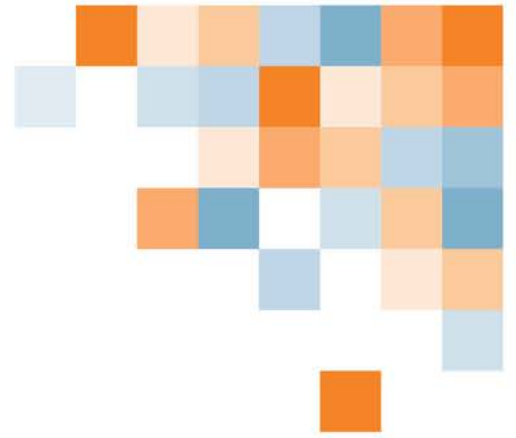


ita
YOUR TICKET.



PROGRAM OUTLINE

Welder Foundation



The latest version of this document is available in PDF format on the ITA website
www.itabc.ca

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WELDER FOUNDATION PROGRAM OUTLINE

**APPROVED BY INDUSTRY
AUGUST 2016**

**BASED ON
WELDER NOA 2013
AND
CCDA HARMONIZATION
RECOMMENDATIONS 2015**

**Developed by
Industry Training Authority
Province of British Columbia**



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Section 1

INTRODUCTION

Welder



Foreword

This Program Outline was developed to meet the needs of employers and other industry stakeholders.

It will be used as a guide for training providers delivering technical training for the Welder program and by apprentices and employers in planning the workplace training.

Safe working practices, though not always specified in each of the competencies and learning tasks, are an implied part of the program and should be stressed throughout the apprenticeship.

This document provides important information for a variety of audiences, including: training providers, employers/sponsors, apprentices and program challengers. Refer to "How to Use this Document" for information on how each section can be used by each intended audience.

Delivery of Technical Training:

The Welder Program has three levels of technical training. Practical demonstration and apprentice participation should be integrated with classroom sessions.

This program is competency-based with many options available for the delivery of technical training.

For example, the Welder Apprenticeship Program may be offered as a:

- Full-time day school program (including block release and continuous entry)
- Continuous entry competency-based model
- Some theory may be offered as interactive synchronistic "on-line" delivery

This program outline also includes:

- A list of recommended curriculum and reference textbooks
- Training Provider Requirements for Instructor Qualifications, Facilities (classroom and shop sizes), as well as the necessary Tools and Equipment
- Practical competencies as well as destructive and non-destructive testing
- Shop projects and weld destructive tests
- Pipe fabrication competencies
- Fabrication competencies

SAFETY ADVISORY

Be advised that references to the WorkSafeBC safety regulations contained within these materials do not/may not reflect the most recent Occupational Health and Safety Regulation (the current Standards and Regulation in BC can be obtained on the following website: <http://www.worksafebc.com>. Please note that it is always the responsibility of any person using these materials to inform him/herself about the Occupational Health and Safety Regulation pertaining to his/her work.



Acknowledgements

Welder Program Review and Revision 2014 – 2016:

In 2014, Subject Matter Experts were convened to review and revise the BC Program Outline with reference to changes identified in the Welder 2013 National Occupational Analysis (NOA). The following are the Subject Matter Experts who participated in this review:

- Stan Boehm, SS Stainless Inc
- James Hillerby, Whistler Resorts
- Mike Zenowski, Weldco-Beales
- Merv Kube, UA Piping Industry College of BC (UAPIC BC)
- Jim Carson, University of the Fraser Valley (UFV)
- Mark Flynn, British Columbia Institute of Technology (BCIT)

In 2015, Subject Matter Experts were convened to review and re-sequence the Welder trade as part of the Pan-Canadian Harmonization Initiative. The following are the Subject Matter Experts who participated in this review:

- Stan Boehm, SS Stainless Inc
- James Hillerby, Whistler Resorts
- Merv Kube, UA Piping Industry College of BC (UAPIC BC)
- Jim Carson, University of the Fraser Valley (UFV)
- Mark Flynn, British Columbia Institute of Technology (BCIT)
- Al Sumal, Kwantlen Polytechnic University (KPU)

In 2016, Subject Matter Experts were convened to review the BC Program Outline with respect to the Pan-Canadian Harmonization Initiative changes. The following are the Subject Matter Experts who participated in this review:

- Willem Swint, Victoria Shipyards
- Mark Karpinski, Vancouver Shipyards
- Willy Manson, Stinger Welding
- Chris Meikle, ADAM Integrated Industries
- Jason Card, Macro Industries
- Brad Harder, Penticton Fabrication
- Matt Suddaby, Jewel Holdings
- Mike Longo, Ideal Welders
- Gord Weel, Boilermakers 359
- Palmer Allen, Boilermakers 359
- Gene Vonn Matt, Teck, Elk Valley Operations
- Jackie Lundman, Independent
- Ed Hurd, Technical Safety BC

The Industry Training Authority would like to acknowledge the dedication and hard work of all the industry representatives appointed to identify the training requirements of the Welder occupation.

Committee members and consultation groups involved with prior editions of the BC Program Outline can be found in the Historical Program Review Participants in the appendix at the end of this document.



How to Use this Document

This Program Outline has been developed for the use of individuals from several different audiences. The table below describes how each section can be used by each intended audience.

Section	Training Providers	Employers/ Sponsors	Apprentices	Challengers
Program Credentialing Model	Communicate program length and structure, and all pathways to completion	Understand the length and structure of the program	Understand the length and structure of the program, and pathway to completion	Understand challenger pathway to Certificate of Qualification
OAC	Communicate the competencies that industry has defined as representing the scope of the occupation	Understand the competencies that an apprentice is expected to demonstrate in order to achieve certification	View the competencies they will achieve as a result of program completion	Understand the competencies they must demonstrate in order to challenge the program
Training Topics and Suggested Time Allocation	Shows proportionate representation of general areas of competency (GACs) at each program level, the suggested proportion of time spent on each GAC, and percentage of time spent on theory versus practical application	Understand the scope of competencies covered in the technical training, the suggested proportion of time spent on each GAC, and the percentage of that time spent on theory versus practical application	Understand the scope of competencies covered in the technical training, the suggested proportion of time spent on each GAC, and the percentage of that time spent on theory versus practical application	Understand the relative weightings of various competencies of the occupation on which assessment is based
Program Content	Defines the objectives, learning tasks, high level content that must be covered for each competency, as well as defining observable, measurable achievement criteria for objectives with a practical component	Identifies detailed program content and performance expectations for competencies with a practical component; may be used as a checklist prior to signing a recommendation for certification (RFC) for an apprentice	Provides detailed information on program content and performance expectations for demonstrating competency	Allows individual to check program content areas against their own knowledge and performance expectations against their own skill levels
Training Provider Standards	Defines the facility requirements, tools and equipment, reference materials (if any) and instructor requirements for the program	Identifies the tools and equipment an apprentice is expected to have access to; which are supplied by the training provider and which the student is expected to own	Provides information on the training facility, tools and equipment provided by the school and the student, reference materials they may be expected to acquire, and minimum qualification levels of program instructors	Identifies the tools and equipment a tradesperson is expected to be competent in using or operating; which may be used or provided in a practical assessment



Section 2

PROGRAM OVERVIEW

Welder Foundation

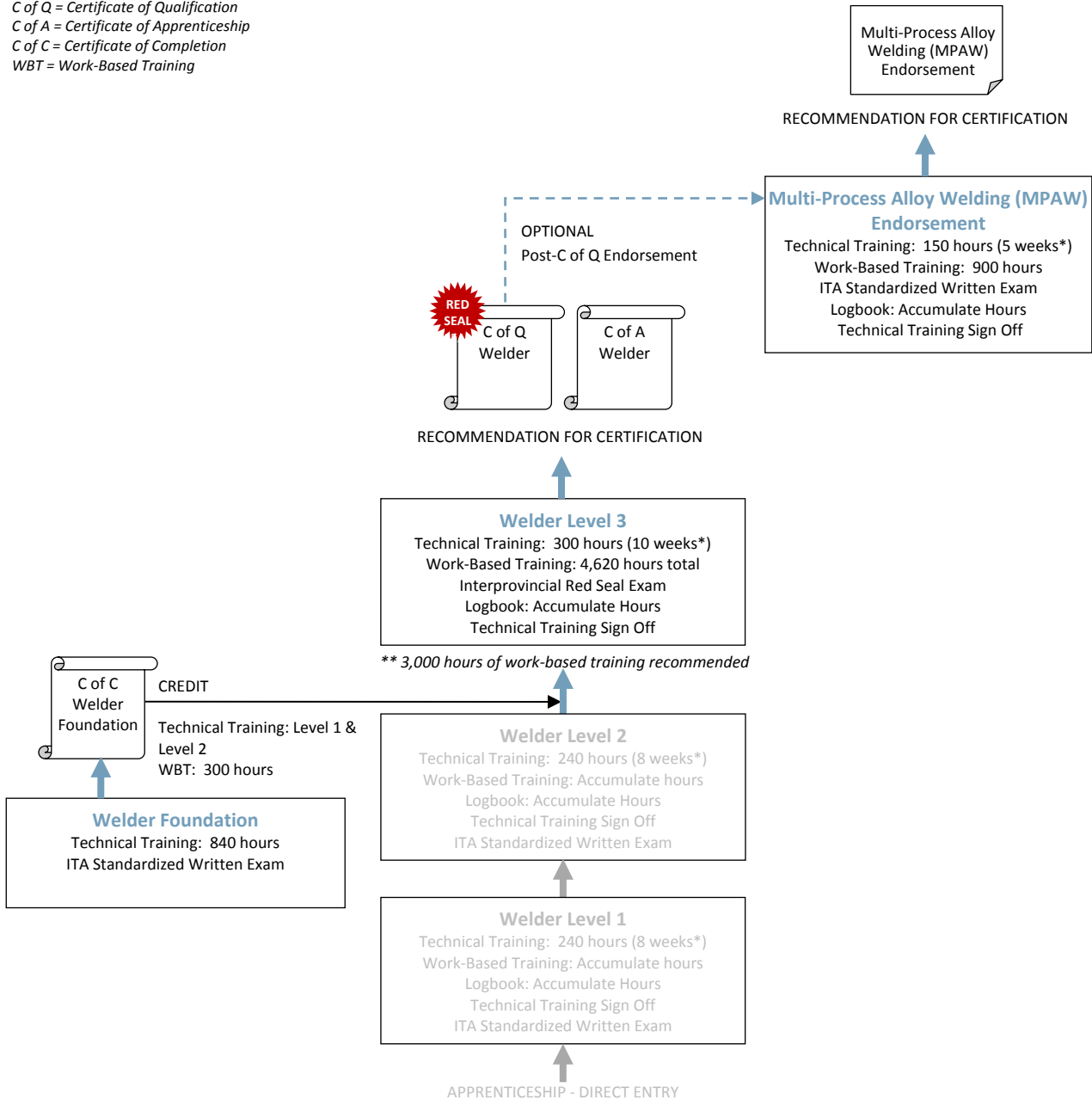


Program Credentialing Model

Apprenticeship Pathway

This graphic provides an overview of the Welder apprenticeship pathway.

*C of Q = Certificate of Qualification
 C of A = Certificate of Apprenticeship
 C of C = Certificate of Completion
 WBT = Work-Based Training*



**** 3,000 hours of work-based training recommended prior to entering Level 3 Technical Training (hours to be verified by Sponsor/Employer)**

CROSS-PROGRAM CREDITS

Individuals who hold the credentials listed below are entitled to receive partial credit toward the completion requirements of this program

None



Occupational Analysis Chart

WELDER

Occupation Description: “Welder” means a person who has training in and is capable of welding ferrous and non-ferrous metals in all positions, on both plate and/or pipe, using various welding processes. Certified welders qualify for testing with CSA, Technical Safety BC and for ASME procedures in British Columbia.

EN = Endorsement
F = Foundation

Occupational Skills A	Describe welder apprenticeship and the scope of the trade in BC A1 F 1	Describe safe working practices A2 F 1	Perform basic trade related mathematical calculations A3 F 1	Use and maintain measuring and layout tools A4 F 1	Use and maintain hand tools A5 F 1	Use and maintain power tools (electric and pneumatic) A6 F 1
	Describe shop materials A7 F 1	Apply lifting, hoisting and rigging procedures A8 F 1 2				
Cutting and Gouging Processes B	Describe Oxy-Fuel Cutting (OFC) processes and their applications B1 F 1	Describe Oxy-Fuel Cutting (OFC) equipment and its operation B2 F 1	Perform freehand and guided cuts on low carbon steel (OFC) B3 F 1	Use automatic and semi-automatic cutting machines (OFC) B4 F 1	Describe CAC-A and PAC processes, equipment and their applications B5 F 1	Use CAC-A and PAC cutting and gouging processes and equipment B6 F 1
	Describe fusion welding, braze welding and brazing processes and their applications C1 F 1	Describe fusion welding, braze welding and brazing equipment and its operation C2 F 1	Describe filler metals, fluxes and tips used for fusion welding, braze welding and brazing C3 F 1	Describe joint design and weld positions for OFW C4 F 1	Fusion weld on low carbon steel sheet C5 F 1	Braze weld (TB) using the OFW process C6 F 1
Fusion and Braze Welding (TB) Using the Oxy-Fuel (OFW) Process C	Silver alloy braze on similar and dissimilar metals C7 F 1					



Program Overview

Shielded Metal Arc Welding (SMAW) D	Describe the SMAW process D1 F 1	Describe SMAW equipment and its operation D2 F 1	Select electrodes for SMAW D3 F 1 2 3 EN	Describe basic joint design and weld positions for SMAW D4 F 1	Describe weld faults and distortion in fabrications in SMAW D5 F 1	Use the SMAW process on low carbon steel plate and pipe D6 F 1 2 3 EN
	Use the hardsurfacing process on low carbon steel D7 F 1	Describe the SMAW process on grey cast iron D8 F 2	Use the SMAW process on stainless steel and/or low carbon steel plate and pipe D9 F 1 EN			
Semi-Automatic and Automatic Welding E	Describe GMAW, GMAW-P, FCAW, MCAW and SAW processes and their applications E1 F 1	Describe semi-automatic and automatic welding equipment and its operation E2 F 1	Describe filler metal and shielding gases for semi-automatic and automatic processes E3 F 1	Use the GMAW and GMAW-P process E4 F 1 2 3	Use the FCAW process E5 F 1 2	Use the MCAW process E6 F 2
	Use the SAW process E7 F 2	Use combined GMAW, MCAW and FCAW processes E8 3				
Gas Tungsten Arc Welding (GTAW) F	Describe the GTAW process and its application F1 F 2	Describe GTAW equipment and its operation F2 F 2	Describe the application of GTAW for ferrous metals F3 F 2	Use the GTAW process for ferrous metals F4 F 2 3	Use the GTAW process for stainless steel F5 F 2 EN	Use the GTAW process for aluminum F6 3
Specialized Processes G	Describe specialized welding processes G1 EN					
Basic Metallurgy H	Describe production processes for manufacturing metals H1 F 2	Describe mechanical and physical properties of ferrous and non-ferrous metals H2 F 2 3	Describe common ferrous, non-ferrous and reactive metals and their weldability H3 F 2 3 EN	Describe the grain structure of metals H4 3	Describe aluminum, aluminum alloys and their weldability H5 3	Describe die castings and their weldability H6 EN



Program Overview

Welding Drawings, Layout and Fabrication I

Identify common welding symbols and bolted connections					I1
F	1				

Read and interpret drawings					I2
F		2	3		

Perform basic drafting					I3
F		2			

Perform mathematical calculations					I4
F		2			

Interpret and apply mechanical drawings and layout components					I5
F		2	3	EN	

Fabricate weldments					I6
F		2	3	EN	

Costing and estimating					I7
F		2	3		

Quality Control and Inspection J

Describe basic welding quality control and inspection requirements					J1
			3		

Describe inspection and testing procedures					J2
			3		

Describe the scope of the welding supervisor and inspector responsibilities					J3
			3		

Standards, Codes, Specifications and Welder Qualifications K

Identify applicable standards, codes, specifications and jurisdictional bodies					K1
			3		

Describe compliance with weld procedure specifications (WPS) and data sheets					K2
			3		



Training Topics and Suggested Time Allocation: Foundation

Welder – Foundation

% of Time Allocated to:

	% of Time	Theory	Practical	Total
Line A Occupational Skills	7%	50%	50%	100%
A1 Describe welder apprenticeship and the scope of the trade in BC		✓		
A2 Describe safe working practices		✓		
A3 Perform basic trade related mathematical calculations		✓		
A4 Use and maintain measuring and layout tools		✓		
A5 Use and maintain hand tools		✓	✓	
A6 Use and maintain power tools (electric and pneumatic)		✓	✓	
A7 Describe shop materials		✓	✓	
A8 Apply lifting, hoisting and rigging procedures		✓	✓	
Line B Cutting and Gouging Processes	6%	20%	80%	100%
B1 Describe Oxy-Fuel Cutting (OFC) processes and their applications		✓		
B2 Describe Oxy-Fuel Cutting (OFC) equipment and its operation		✓		
B3 Perform freehand and guided cuts on low carbon steel (OFC)			✓	
B4 Use automatic and semi-automatic cutting machines (OFC)			✓	
B5 Describe CAC-A and PAC processes, equipment and their applications		✓		
B6 Use CAC-A and PAC cutting and gouging processes and equipment		✓	✓	
Line C Fusion and Braze Welding (TB) Using the Oxy-Fuel (OFW) Process	3%	20%	80%	100%
C1 Describe fusion welding, braze welding and brazing processes and their applications		✓		
C2 Describe fusion welding, braze welding and brazing equipment and its operation		✓		
C3 Describe filler metals, fluxes and tips used for fusion welding, braze welding and brazing		✓		
C4 Describe joint design and weld positions for OFW		✓		
C5 Fusion weld on low carbon steel sheet			✓	
C6 Braze weld (TB) using the OFW process		✓	✓	
C7 Silver alloy braze on similar and dissimilar metals		✓		



Line D Shielded Metal Arc Welding (SMAW)

- D1 Describe the SMAW process
- D2 Describe SMAW equipment and its operation
- D3 Select electrodes for SMAW
- D4 Describe basic joint design and weld positions for SMAW
- D5 Describe weld faults and distortion in fabrications in SMAW
- D6 Use the SMAW process on low carbon steel plate and pipe
- D7 Use the hardsurfacing process on low carbon steel
- D8 Describe the SMAW process on grey cast iron
- D9 Use the SMAW process on stainless steel and/or low carbon steel plate and pipe

42% 20% 80% 100%

- ✓
- ✓
- ✓
- ✓
- ✓
- ✓
- ✓
- ✓
- ✓

Line E Semi-Automatic and Automatic Welding

- E1 Describe GMAW, GMAW-P, FCAW, MCAW and SAW processes and their applications
- E2 Describe semi-automatic and automatic welding equipment and its operation
- E3 Describe filler metal and shielding gases for semi-automatic and automatic processes
- E4 Use the GMAW and GMAW-P process
- E5 Use the FCAW process
- E6 Use the MCAW process
- E7 Use the SAW process

30% 25% 75% 100%

- ✓
- ✓
- ✓
- ✓
- ✓
- ✓
- ✓

Line F Gas Tungsten Arc Welding (GTAW)

- F1 Describe the GTAW process and its application
- F2 Describe GTAW equipment and its operation
- F3 Describe the application of GTAW for ferrous metals
- F4 Use the GTAW process for ferrous metals
- F5 Use the GTAW process for stainless steel

4% 15% 85% 100%

- ✓
- ✓
- ✓
- ✓
- ✓

Line H Basic Metallurgy

- H1 Describe production processes for manufacturing metals
- H2 Describe mechanical and physical properties of ferrous and non-ferrous metals
- H3 Describe common ferrous, non-ferrous, reactive metals and their weldability

1% 90% 10% 100%

- ✓
- ✓
- ✓
- ✓



		7%	15%	85%	100%
Line I	Welding Drawings, Layout and Fabrication				
I1	Identify common welding symbols and bolted connections		✓		
I2	Read and interpret drawings		✓		
I3	Perform basic drafting		✓	✓	
I4	Perform mathematical calculations		✓		
I5	Interpret and apply mechanical drawings and layout components		✓	✓	
I6	Fabricate weldments		✓	✓	
I7	Costing and estimating		✓	✓	
Total Percentage for Welder Foundation		100%			



Section 3

PROGRAM CONTENT

Welder Foundation



Foundation



Line (GAC): **A** **Occupational Skills**
Competency: **A1** **Describe welder apprenticeship and the scope of the trade in BC**

Objectives

To be competent in this area, the individual must be able to:

- Describe the scope of the welder trade in BC.
- Describe the requirements and structure of the BC Welder Apprenticeship program.

LEARNING TASKS

CONTENT

- | | |
|---|---|
| <ol style="list-style-type: none"> 1. Describe the four levels of training in the BC welder program
 2. Describe the requirements and procedure for registration at each level
 3. Describe the Welder Learning Resource modules
 4. Describe employment opportunities for each level of the training program and more advanced training opportunities | <ul style="list-style-type: none"> • Historical structure • Current apprenticeship <ul style="list-style-type: none"> ○ Foundation ○ Level 1, Level 2, Level 3 ○ Level 4 (Endorsement)
 • Skills and qualities of a welder • Specific job knowledge <ul style="list-style-type: none"> ○ Equipment knowledge ○ Metal identification ○ Personal qualities • Roles and responsibilities <ul style="list-style-type: none"> ○ Employer responsibilities ○ Apprentice responsibilities • Logbook requirements <ul style="list-style-type: none"> ○ Identification of the welder ○ Registration seals ○ Training endorsements ○ Qualifications tests, general section ○ Employment record ○ W.P.Q.R.
 • The training program • Training requirements • P lines • RK lines
 • High school, college or technical training institute <ul style="list-style-type: none"> ○ Tacker ○ Welding operator ○ Welder ○ Welder fabricator/fitter • College, technical institute or university: <ul style="list-style-type: none"> ○ Welding inspector level 1, 2 and 3 ○ Welding technician |
|---|---|



- Welder technologist
 - Mechanical engineer
 - Welding engineer

- 5. Identify industrial and construction fields that provide employment opportunities for welders
 - Metal fabricating
 - Ship building
 - Pulp and paper mills
 - Wood products manufacture
 - Machinery manufacture
 - Equipment maintenance and repair
 - Smelt and refining
 - Motor vehicle, truck/trailer manufacture
 - Mining
 - Construction
 - Iron and steel mills
 - Special trades
 - Mining services
 - Coal mines
 - Gas distribution and transmission
 - Public administration and defence
 - Machinery wholesalers
 - Forestry and forest services
 - Electric utilities
 - Motor vehicle dealers and repairs
 - Communications equipment and manufacture
 - Pipeline
 - Food and beverage industry

- 6. Communicate effectively
 - Resumes
 - Cover letter
 - Internet information sourcing
 - Listening skills
 - Effective verbal communication
 - Non effective verbal communication
 - Workplace culture



Line (GAC): **A** **Occupational Skills**
Competency: **A2** **Describe safe working practices**

Objectives

To be competent in this area, the individual must be able to:

- Describe regulations for health and safety in a welding workplace.
- Describe fire safety precautions, confined space entry and H2S requirements.

LEARNING TASKS

CONTENT

- | | |
|---|--|
| <p>1. Describe regulations for health and safety in a welding workplace</p> | <ul style="list-style-type: none"> • WorkSafeBC <ul style="list-style-type: none"> ○ Employer responsibility and eligibility ○ Worker responsibility and eligibility ○ WorkSafeBC coverage ○ Standards, codes and regulations • Occupational Health and Safety (OH&S) • Workplace Hazardous Material Information System (WHMIS) <ul style="list-style-type: none"> ○ Training ○ Material Safety Data Sheets (MSDS) ○ Labelling |
| <p>2. Describe general safety precautions for welding</p> | <ul style="list-style-type: none"> • Worksite safety <ul style="list-style-type: none"> ○ Safety meetings ○ Emergency procedures • Shop safety • Electrical safety • Safety requirements for welding processes |
| <p>3. Describe fall protection requirements</p> | <ul style="list-style-type: none"> • Personal fall protection requirements <ul style="list-style-type: none"> ○ Ladders and scaffolds ○ Handrails and guardrails ○ Harnesses and tethers ○ Fall restraint ○ Fall arrest ○ Access equipment |



4. Describe physical hazards and select Personal Protective Equipment (PPE)
 - Hazards
 - Radiation
 - Extreme temperatures
 - Noise
 - Bodily injury hazards
 - Chemical hazards
 - Respiratory
 - Personal protective equipment
 - Protective clothing
 - Skin protection (leathers)
 - Head protection
 - Hand protection
 - Foot protection
 - Hearing protection
 - Welding screens and curtains
 - Eye protection for welding
 - Safety glasses and goggles
 - Face shields
 - Flash goggles
 - Welding helmets
 - Welding goggles
 - Respiratory protection

5. Identify fire hazards and describe methods for preventing and extinguishing fires
 - WorkSafeBC requirements for fire watch
 - Fire hazards
 - Sparks
 - Elements of a high hazard area
 - Fire and explosion prevention
 - Clean area of combustible debris
 - Fire/water hose and/or fire extinguisher set up before and after work
 - Contain sparks by the use of fire-retardant blankets
 - Wet area down in high hazard area before starting hot work
 - Cover wall/floor openings with fire retardant blanket
 - Extinguishing fires
 - Fire triangle
 - The four classes of fires
 - Types of fire extinguishers
 - Toxic fumes/ventilation
 - Cadmium
 - Zinc
 - Lead
 - Beryllium
 - Other alloys



- 6. Describe confined space entry
 - Synthetic materials
 - Employer/employee responsibilities
 - Hazard assessment and work procedures
 - Identification and entry permits
 - Lockout and isolation
 - Verification and testing
 - Cleaning, purging, venting, inserting
 - Standby persons
 - Rescue
 - Lifelines, harnesses and lifting equipment
 - Personal protective equipment and other precautions

- 7. Describe requirements for H2S training
 - Properties, characteristics and locations of H2S
 - Health hazards
 - MSDS requirements
 - Initial response strategy
 - Ventilation, controls and PPE
 - Respiratory protective equipment
 - Self-Contained Breathing Apparatus (SCBA)
 - Supplied Air Breathing Apparatus (SABA)
 - Detecting and monitoring for H2S
 - Detector tube devices
 - Electronic monitors
 - Rescue techniques
 - Rescue breathing
 - Emergency response planning



Line (GAC): A Occupational Skills
Competency: A3 Perform basic trade related mathematical calculations

Objectives

To be competent in this area, the individual must be able to:

- Perform basic welder trade related mathematical calculations.

LEARNING TASKS

1. Solve trade related mathematical problems related to measurement

2. Solve problems involving geometric formulas

CONTENT

- Fractions
 - Basic mathematical functions
 - Calculate averages
 - Key terms and concepts
 - Convert to percentages and decimals
- Decimals
 - Basic mathematical functions
 - Decimal fractions
 - Convert decimals to common linear measurements (i.e. feet and inches)
 - Convert to percentages
- Whole numbers
- Ratio and proportion
- Metric and Imperial measurements
- Convert between units of measurement
 - Linear measurements
 - Volumetric measurements
- Metric and Imperial measurements
- Geometric formulas
 - Perimeter
 - Area
 - Volume
- Calculate the weight of a solid



Line (GAC): **A** **Occupational Skills**
Competency: **A4** **Use and maintain measuring and layout tools**

Objectives

To be competent in this area, the individual must be able to:

- Describe and demonstrate the safe use and care of measuring and layout tools.

LEARNING TASKS

CONTENT

- | | |
|---|--|
| <p>1. Identify, describe and select layout tools</p> | <ul style="list-style-type: none"> • Combination squares <ul style="list-style-type: none"> ○ Square head ○ Center head ○ Protractor head • Marking tools <ul style="list-style-type: none"> ○ Soapstone ○ Scriber or awl ○ Chalkline ○ Divider and trammel points ○ Center punch ○ Prick punch ○ Spring loaded punch ○ Transfer punch ○ Number and letter stamps ○ Pneumatic or electronic etching |
| <p>2. Use and maintain layout tools</p> | <ul style="list-style-type: none"> • Selecting correct tool for task • Proper usage • General maintenance and storage |
| <p>3. Identify, describe and select measuring tools</p> | <ul style="list-style-type: none"> • Systems of measuring <ul style="list-style-type: none"> ○ Metric ○ Imperial • Measuring tools <ul style="list-style-type: none"> ○ Pocket measuring tape ○ Steel rule ○ Torpedo level ○ Spirit level ○ Laser level ○ Plumb bob ○ Framing square • Gauges <ul style="list-style-type: none"> ○ Fillet weld ○ Pipe internal alignment ○ Single purpose weld ○ Bridge cam |



4. Use and maintain measuring tools

- Selecting correct tool for task
- Proper usage
- General maintenance and storage



Line (GAC): **A** **Occupational Skills**
Competency: **A5** **Use and maintain hand tools**

Objectives

To be competent in this area, the individual must be able to:

- Describe and demonstrate the safe use and care of hand tools.

LEARNING TASKS

CONTENT

- | | |
|---|---|
| <p>1. Identify, describe and select clamping tools</p> | <ul style="list-style-type: none"> • Vises <ul style="list-style-type: none"> ○ Bench vise ○ Machine vise ○ Pipe vise ○ Top screw bench chain vise ○ Tri-stand yolk vise • Clamps • Pliers <ul style="list-style-type: none"> ○ Combination ○ Interlocking slip-joint ○ Needle-nose and round-nose ○ GMAW |
| <p>2. Use and maintain clamping tools</p> | <ul style="list-style-type: none"> • Safety • Selecting correct tool for task • Proper usage • General maintenance and storage |
| <p>3. Identify, describe and select alignment tools</p> | <ul style="list-style-type: none"> • Drifts • Pinch line up bars • Pry bars • Dogs and wedges • External pipe alignment tools |
| <p>4. Use and maintain alignment tools</p> | <ul style="list-style-type: none"> • Safety • Selecting correct tool for task • Proper usage • General maintenance and storage |
| <p>5. Identify, describe and select cutting tools</p> | <ul style="list-style-type: none"> • Hacksaws • Files • Manual sheers • Cold chisels • Bolt cutters • Wire cutters |



- 6. Use and maintain cutting tools
 - Safety
 - Selecting correct tool for task
 - Proper usage
 - General maintenance and storage

- 7. Identify, describe and select other common hand tools
 - Wire brushes
 - Hammers
 - Ball-peen
 - Soft-faced
 - Chipping hammers
 - Sledge hammers
 - Dead blow hammers
 - Cross-peen
 - Anvils
 - Wrenches
 - Open-end
 - Box-end
 - Combination
 - Adjustable
 - Cylinder
 - Socket
 - Pipe
 - Hexagon key
 - Screwdrivers
 - Blade
 - Phillips
 - Robertson
 - Torx

- 8. Use and maintain other common hand tools
 - Safety
 - Selecting correct tool for task
 - Proper usage
 - General maintenance and storage

- 9. Identify, describe and select taps and dies
 - Taps
 - Tap wrenches
 - Dies
 - Tapping internal threads
 - Common tapping problems
 - Cutting external threads

- 10. Use and maintain taps and dies
 - Safety
 - Selecting correct tool for task
 - Proper usage
 - General maintenance and storage



11. Identify, describe and select alignment tools
- Drifts
 - Pinch line up bars
 - Pry bars
 - Dogs and wedges

Achievement Criteria

Performance The learner will be evaluated on the ability to:

- Fabricate a welding bevel/drill bit point gauge.
- Layout a full-size pan.

Conditions As part of a practical shop project, given the required tools and materials.

- Criteria
- Welding bevel/drill bit point gauge will be evaluated for:
 - Squareness and accuracy of dimensions
 - Correct angles and correct placement of holes, stamps, graduations, etchings
 - Overall appearance
 - Pan layout will be evaluated for:
 - Squareness and accuracy of measurement
 - Accurate marking of break or cut lines
 - Overall appearance

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): **A Occupational Skills**
Competency: **A6 Use and maintain power tools (electric and pneumatic)**

Objectives

To be competent in this area, the individual must be able to:

- Describe and demonstrate the safe use and care of electric and pneumatic power tools.

LEARNING TASKS

CONTENT

- | | |
|---|---|
| 1. Identify, describe and select power drilling tools | <ul style="list-style-type: none"> • Portable power drills • Rechargeable drills • Keyless chuck drills • Hammer drills • Magnetic base drills • Drill presses • Twist drill bits • Hollow bits • Hole saws • Carbide tipped masonry bits |
| 2. Use and maintain power drilling tools | <ul style="list-style-type: none"> • Safety • Selecting correct tool for task • Set up and adjustment • Proper usage • General maintenance and storage |
| 3. Identify, describe and select power grinding tools | <ul style="list-style-type: none"> • Stationary grinders • Portable grinders • Stationary belt sanders • Portable belt sanders • Abrasives and disks • Carbide burrs • Mini belt sanders |
| 4. Use and maintain power grinding tools | <ul style="list-style-type: none"> • Safety • Selecting correct tool for task • Set up and adjustment • Proper usage • General maintenance and storage |
| 5. Identify, describe and select power shearing tools | <ul style="list-style-type: none"> • Power squaring shears • Rotary throatless shears • Universal machines • Iron worker • Nibblers • Pipe cutters |



- | | |
|---|---|
| 6. Use and maintain power shearing tools | <ul style="list-style-type: none"> • Safety • Selecting correct tool for task • Set up and adjustment • Proper usage • General maintenance and storage |
| 7. Identify, describe and select power sawing tools | <ul style="list-style-type: none"> • Abrasive cut-off saw • Power hacksaw • Metal-cutting band saws • Reciprocating saws • Sabre • Circular saws • Blades for metal-cutting saws |
| 8. Use and maintain power sawing tools | <ul style="list-style-type: none"> • Safety • Selecting correct tool for task • Set up and adjustment • Proper usage • General maintenance and storage |
| 9. Identify, describe and select specialty tools | <ul style="list-style-type: none"> • Scaler • Needle scaler |
| 10. Use and maintain specialty tools | <ul style="list-style-type: none"> • Safety • Selecting correct tool for task • Set up and adjustment • Proper usage • General maintenance and storage |

Achievement Criteria

Performance The learner will be evaluated on the use of power tools, including:

- Sharpen twist drill bits using freehand method.
- Grind, drill, tap and cut low carbon steel flat bar.

Conditions As part of a practical shop project, given the required tools and materials.

- Criteria**
- Sharpening of twist drill bits will be evaluated for:
 - Accuracy of angles
 - Absence of distempering, chips, cracks
 - Cutting efficiency of sharpened drill bits
 - Overall appearance
 - Grind, drill, tap and cut low carbon steel flat bar will be evaluated for:
 - Smooth surfaces/correct location of holes
 - Internal threads, alignment and fit
 - Correct location of cut
 - Clean cut (absence of burrs and sharp edges)
 - Accuracy of dimensions
 - Overall appearance

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): A **Occupational Skills**
Competency: A7 **Describe shop materials**

Objectives

To be competent in this area, the individual must be able to:

- Identify and describe common sheet, plate, pipe and structural shapes.

LEARNING TASKS

1. Identify and describe materials

2. Select materials

3. Describe correct procedures for manually handling and storing structural shapes

CONTENT

- Plate and sheet
 - Specifying sheet sizes
 - Specifying plate sizes
- Steel bars
 - Rectangular bar, flat bar and strip stock
 - Square bar
 - Round bar
 - Half oval bar
 - Hexagon bar
 - Octagon bar
- Shapes
 - W, S and M shapes
- Angles
 - Equal leg lengths
 - Unequal leg angles
 - Structural tees
 - Channel
- Structural tubing (hollow structural sections)
 - Round tubing
- Structural pipe

- Read bill of materials
- Resource materials

- Personal Protective Equipment (PPE)
- Correct body position/posture for lifting
- Center of gravity
- Block and store
 - Location and environment



Line (GAC): **A** **Occupational Skills**
Competency: **A8** **Apply lifting, hoisting and rigging procedures**

Objectives

To be competent in this area, the individual must be able to:

- Apply safety procedures for rigging and material handling.
- Perform safe working load (SWL) calculations involving geometric formulas, volumes and capacities.
- Perform safe manual-lifting procedures.
- Describe wire rope, slings and rigging hardware.
- Use fibre ropes to tie knots.
- Operate hoisting equipment to perform lift.

LEARNING TASKS

CONTENT

- | | |
|--|--|
| <ol style="list-style-type: none"> 1. Describe and apply safety precautions for rigging and hoisting | <ul style="list-style-type: none"> • WorkSafeBC regulations • PPE • Hand signals • Manufacturers' specifications • Common safety hazards <ul style="list-style-type: none"> ○ SWL not known ○ Defective equipment and hardware ○ Unrated lifting lugs ○ Electrical contact ○ Weather conditions |
| <ol style="list-style-type: none"> 2. Describe the basic principles of lifting, hoisting and rigging | <ul style="list-style-type: none"> • Center of gravity • Safe working loads (SWL) <ul style="list-style-type: none"> ○ Interpret safe working load charts ○ WorkSafeBC regulations (part 15) |
| <ol style="list-style-type: none"> 3. Describe and perform safe manual lifting | <ul style="list-style-type: none"> • Personal Protective Equipment (PPE) • Correct body position/posture for lifting • Center of gravity • Block and store |
| <ol style="list-style-type: none"> 4. Identify common rigging hardware (below-the-hook lifting devices) | <ul style="list-style-type: none"> • Hooks <ul style="list-style-type: none"> ○ Hoisting hooks ○ Choker hooks • Clips <ul style="list-style-type: none"> ○ Wire rope clips (number and spacing) ○ Cable clips • Attachments <ul style="list-style-type: none"> ○ Swivels ○ Shackles ○ Eye bolts |



- Snatch blocks
 - Turnbuckles
 - Spreader and equalizer beams
 - Plate clamps
 - Magnets
- 5. Describe the characteristics, applications and care of wire rope, fibre rope and slings
 - Wire ropes
 - Diameter
 - SWL calculations
 - Rejection criteria
 - Sling types
 - Synthetic web slings
 - Wire rope slings
 - Alloy steel chain slings
 - Metal mesh slings
 - Fibre ropes
 - Parts of rope
 - Basic knots and hitches
 - Figure 8
 - Square (reef) knot
 - Clove hitch
 - Sheetbend
 - Round turn and two half hitches
 - Bowline
 - Half hitch
 - Mandatory rating tags on slings
 - Storage
 - Visual inspection
 - Rejection criteria
 - Safe working loads (SWL)
- 6. Describe and demonstrate applications of knots, bends and hitches
 - Tag lines (rigging)
 - Load lines (tie-down)
 - Hoisting lines (materials)
 - Safety harness
 - Joining ropes
 - Stopper knot
- 7. Describe common sling configurations and their application
 - Sling configurations
 - Single vertical hitch
 - Bridle hitch
 - Single basket hitch
 - Double basket hitch
 - Double-wrap basket hitches
 - Single choker hitch
 - Double choker hitch
 - Double-wrap choker hitch
 - Sling angles



- Adjust rated capacity for sling configurations
- 8. Describe common types of hoisting equipment and their application
 - Jacks (ratchet, hydraulic)
 - Jack stands
 - Rollers
 - Block and tackle
 - Chain blocks
 - Lever-operated hoists or come-a-longs
 - Hoists
 - Chain hoists
 - Grip action hoists (Tirfors)
 - Electric hoists and pendant cranes
 - Floor hoists
 - Winches
 - Forklifts
 - Crane types
 - Gantry cranes
 - Remote pendant control
 - Overhead runways
 - Jib cranes
 - Overhead travelling cranes
 - Mobile cranes
 - Tower cranes
- 8. Determine weight, centre of gravity and safe working loads (SWL)
 - Load weight calculations
 - Plate
 - Structural steel shape
 - Pipe
 - Centre of gravity
 - Safe working loads (SWL)
 - Explain safe working load ratios
 - WorkSafeBC regulations (part 15)
 - Material and personnel
- 9. Operate hoisting equipment
 - Hoisting equipment
 - Factors that reduce capacity
 - Plan a lift
 - Estimate weight of load
 - Select proper rigging
 - Attach proper rigging
- 10. Lift, hoist and move loads
 - Hoist (chain fall)
 - Come-alongs
 - Tirfor™ jack

**Achievement Criteria**

- Performance The learner will be evaluated on the ability to:
- Perform a manual lift.
 - Identify and use the proper type of hoisting equipment to perform a lift.
- Conditions As part of a practical shop project, given the required materials, equipment and pre-calculated lift plan under supervision.
- Criteria
- Under supervision, manual lifting will be evaluated for:
 - Personal Protective Equipment (PPE)
 - Correct body position/posture for lifting
 - Center of gravity
 - Block and store
 - Under supervision, using hoisting equipment will be evaluated for:
 - Visual check of the lifting equipment before use
 - Checking capacity of equipment
 - Attaching correct rigging configuration
 - Attaching load correctly to lifting hook
 - Centering lifting hook above load before lifting
 - Hoisting load correctly
 - Lowering load correctly
 - Returning rigging to designated storage place
 - Using all equipment in a safe manner
 - Following all shop safety rules

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): B Cutting and Gouging Processes

Competency: B1 Describe Oxy-Fuel Cutting (OFC) processes and their applications

Objectives

To be competent in this area, the individual must be able to:

- Describe the Oxy-Fuel cutting and gouging (OFC) processes, components and applications.
- Describe techniques for cutting difficult-to-cut ferrous alloys.
- Describe thermal effects and safety precautions for Oxy-Fuel processes.

LEARNING TASKS

CONTENT

1. Describe the Oxy-Fuel processes and their components	<ul style="list-style-type: none"> • Principles of OFC process • Common components • Process specific components
2. Describe the applications of Oxy-Fuel processes	<ul style="list-style-type: none"> • Cutting plate, pipe and structural shapes • Washing bolts and rivets • Gouging and scarfing • Stack cutting • Cutting machines
3. Describe the cutting characteristics of ferrous and non-ferrous metals	<ul style="list-style-type: none"> • Ferrous alloys <ul style="list-style-type: none"> ○ Techniques for cutting ferrous alloys ○ Kindling point ○ Preheating ○ Waster plates • Non-ferrous alloys <ul style="list-style-type: none"> ○ Aluminum ○ Copper ○ Brass ○ Bronze ○ Magnesium
4. Describe the thermal effects of Oxy-Fuel processes	<ul style="list-style-type: none"> • Distortion • Surface hardening
5. Describe safety requirements for Oxy-Fuel processes	<ul style="list-style-type: none"> • PPE • Fire and explosion prevention <ul style="list-style-type: none"> ○ Refer to WorkSafeBC for fire watch regulations • Toxic fumes/ventilation <ul style="list-style-type: none"> ○ Cadmium ○ Zinc ○ Lead ○ Beryllium ○ Other alloys ○ Synthetic materials



Line (GAC): **B** **Cutting and Gouging Processes**
Competency: **B2** **Describe Oxy-Fuel Cutting (OFC) equipment and its operation**

Objectives

To be competent in this area, the individual must be able to:

- Describe oxygen and fuel gases used in Oxy-Fuel processes.
- Describe gas cylinders and regulators, tips and attachments, and cutting machines used in Oxy-Fuel processes.

LEARNING TASKS

CONTENT

- | | |
|---|---|
| <p>1. Describe the gases and their properties, used in Oxy-Fuel processes</p> | <ul style="list-style-type: none"> • Oxygen • Acetylene • Other fuel gases <ul style="list-style-type: none"> ○ Methylacetylene-propadiene ○ Natural gas ○ Propane gas |
| <p>2. Describe oxygen and fuel gas cylinders</p> | <ul style="list-style-type: none"> • Oxygen cylinders • Oxygen cylinder valve • Acetylene cylinders • Acetylene cylinder valves • Cylinder safety devices • Liquid fuel cylinders • Storage and handling of cylinders <ul style="list-style-type: none"> ○ Storage ○ Handling ○ Safety precautions for using cylinders |
| <p>3. Describe pressure regulators and their functions</p> | <ul style="list-style-type: none"> • Oxygen and acetylene regulators • Single and two-stage regulators <ul style="list-style-type: none"> ○ Single-stage regulator ○ Two-stage regulator ○ Safe use of regulators |
| <p>4. Describe Oxy-Fuel hoses and fittings</p> | <ul style="list-style-type: none"> • Oxy-Fuel hose <ul style="list-style-type: none"> ○ Safe handling of hose ○ Hose fitting • Torch line explosions – causes and prevention <ul style="list-style-type: none"> ○ Backfire ○ Flashbacks • Reverse flow check valves |



5. Describe torches and tips used in the Oxy-Fuel processes
 - Injector torch
 - Equal pressure torch
 - Torch types
 - One-piece cutting torch
 - Two-piece cutting torch
 - Machine torch
 - Cutting tips
 - Cutting tip size
 - Types of cutting tips
 - Cutting tip maintenance
 - Tips for special purposes
 - Rivet-cutting tips
 - Gouging tips
 - Heating tips

6. Describe gas manifold systems
 - Oxygen manifold systems
 - Acetylene manifold systems

7. Describe Oxy-Fuel gas cutting accessories and machines
 - Manual cutting guides
 - Straight-line cutting guide
 - Circle cutting guide
 - Templates
 - Cutting machines
 - Straight-line cutting machines
 - Shape-cutting machines
 - Electronic eye tracer
 - Magnetic tracer
 - Pipe-bevelling machines



Line (GAC): B Cutting and Gouging Processes

Competency: B3 Perform freehand and guided cuts on low carbon steel (OFC)

Objectives

To be competent in this area, the individual must be able to:

- Assemble the appropriate oxy-fuel cutting equipment, set pressures, light and adjust the cutting torch.
- Make freehand and guided cuts on low carbon steel plate.
- Make freehand cuts on round stock, structural shape and pipe.
- Pierce holes in low carbon steel plate.

LEARNING TASKS

1. Assemble, ignite and shut down a portable oxyacetylene outfit

CONTENT

- Portable oxyacetylene outfit
 - Secure the cylinders
 - Remove the caps
 - Crack the valves
- Attach the regulators
- Install RFCV
 - Connect the hoses
 - Open the valves
 - Purge the hoses
- Flashback arrestors
- Connect the cutting attachment
 - Set working pressure
- Select and install the appropriate cutting tip
 - Set working pressure
- Test for leaks
 - Light and adjust flame
 - Ignite the torch
 - Add oxygen to the flame
- Shut down an oxyacetylene outfit
- Disassemble the oxyacetylene outfit



- 2. Describe the characteristics of an acceptable cut
 - Characteristics of an acceptable cut
 - Top edge square
 - Vertical draglines
 - Bottom edge sharp
 - Factors that affect the quality of cut
 - Speed of travel
 - Surface condition of the metal
 - Oxygen pressure
 - Tip size
 - Size of the preheat flames
 - Thickness of the material
 - Position of the cutting torch tip
 - Position in relation to the work
 - Starting cuts

- 3. Perform freehand cuts on low carbon steel
 - Low carbon steel sheet
 - Freehand square cuts
 - Freehand bevel cuts
 - Low carbon steel plate
 - Freehand square cuts
 - Structural steel
 - Freehand square cuts
 - Freehand bevel cuts
 - Nuts and weldments
 - Wash nuts
 - Gouge weldments
 - Low carbon steel pipe
 - Freehand square cuts
 - Freehand bevel cuts

- 4. Perform guided cuts on low carbon steel
 - Low carbon steel plate
 - Guided square cuts
 - Guided bevel cuts
 - Guided circular cuts
 - Low carbon steel sheet
 - Guided square cuts
 - Steel pipe

- 5. Pierce holes in low carbon steel plate
 - Freehand piercing of miscellaneous shapes

- 6. Wash nuts off bolts and gouge weldments
 - Wash nuts off bolts
 - Gouge weldments

**Achievement Criteria**

- Performance The learner will be evaluated on the ability to:
- Assemble, ignite and shutdown Oxy-Fuel equipment.
 - Perform freehand and guided cuts on low carbon steel plate, sheet round stock, structural shapes and pipe.
- Conditions As part of a practical shop project, given the required tools and materials.
- Criteria
- Correct procedures followed for:
 - Assembly, setup and shutdown
 - Igniting and adjusting cutting and heating torches
 - Cleaning gas cutting tips
 - Repairing gas hose connection
 - All cuts and holes pierced will be evaluated for:
 - Top and bottom edges are sharp (not rounded)
 - Slag is minimal and easily removed
 - Cut is consistently square (90°, not bevelled)
 - Draglines are perpendicular and not too pronounced
 - Cut surface is flat and not rounded or concave
 - Cut line is followed (cuts are straight - holes are desired size and round)
 - Wash nuts off bolts will be evaluated for:
 - Cut quality
 - Slag is minimal and easily removed
 - No damage to the bolt
 - No damage to the plate surfaces

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): B Cutting and Gouging Processes

Competency: B4 Use automatic and semi-automatic cutting machines (OFC)

Objectives

To be competent in this area, the individual must be able to:

- Set up and operate automatic and semi-automatic cutting machines and produce high quality straight cuts, bevel cuts and pipe bevel cuts.

LEARNING TASKS

CONTENT

- | | |
|--|--|
| <ol style="list-style-type: none"> 1. Perform cuts with a straight-line cutting machine using Oxy-Fuel gas 2. Perform cuts with a shape-cutting machine using Oxy-Fuel gas 3. Perform cuts with a pipe-bevelling machine using Oxy-Fuel gas 4. Use automatic and semi-automatic cutting machines | <ul style="list-style-type: none"> • Straight cuts • Bevel cuts • Pipe cuts • Pipe bevel cuts • Set up <ul style="list-style-type: none"> ○ Automatic cutting machines ○ Semi-automatic cutting machines • Perform cuts <ul style="list-style-type: none"> ○ Straight cuts ○ Bevel cuts ○ Pipe bevel cuts |
|--|--|

Achievement Criteria

- Performance** The learner will be evaluated on the ability to perform cuts with automatic and semi-automatic cutting machines.
- Conditions** As part of a practical shop project, given the required tools and materials.
- Criteria**
- Demonstrate correct setup and safe operation of straight line-cutting machine, shape-cutting machine and pipe-bevelling machine
 - Cut and bevels will be evaluated for:
 - Top and bottom edges are sharp and square
 - Slag is minimal and easily removed
 - Cut is consistently square (90°) or bevelled (37.5° or 30°) as per directions
 - Draglines are vertical and not too pronounced
 - Cut surface is flat and not rounded or concave
 - The cut is straight (cut line was followed)
 - Preheat flame-to-work distance was the same all around the pipe
 - Correct cutting sequence was followed

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): B Cutting and Gouging Processes

Competency: B5 Describe CAC-A and PAC processes, equipment and their applications

Objectives

To be competent in this area, the individual must be able to:

- Describe CAC-A equipment and its cutting and gouging operations.
- Describe PAC equipment and its cutting and gouging operations.

LEARNING TASKS

CONTENT

- | | |
|--|--|
| <p>1. Describe the CAC-A process and equipment</p> | <ul style="list-style-type: none"> • Principles of CAC-A • Components <ul style="list-style-type: none"> ○ Power sources ○ Air supply ○ Power rating ○ DC power sources ○ Connecting two DC power sources in parallel ○ Power cables ○ Electrode holder • Electrode types, shapes and size • Quality of cut surfaces • Effects on the base metal |
| <p>2. Describe the applications of CAC-A</p> | <ul style="list-style-type: none"> • Types of cuts <ul style="list-style-type: none"> ○ Manual ○ Machine ○ Beveling ○ Washing • Elements affecting cut <ul style="list-style-type: none"> ○ Polarity ○ Torch angle ○ Travel speed ○ Correct positioning of electrode ○ Electrode stickout ○ Operator comfort ○ Operating sequence ○ Gouging in other positions <ul style="list-style-type: none"> – Vertical – Horizontal – Overhead • Weld defects • Disassembly and repair |
| <p>3. Describe the PAC process and equipment</p> | <ul style="list-style-type: none"> • PAC process fundamentals <ul style="list-style-type: none"> ○ Advantages ○ Quality of cut |



- Air quality control
 - Oil
 - Moisture
 - Contaminants
 - Metallurgical effects
- PAC cutting system and equipment
 - Electrodes
 - Ventilation
 - Power sources
 - Control unit
 - Torches
 - Consumables
 - Tip stand-off
 - Air-cooled
 - Water-cooled
 - Gases (plasma and secondary)
 - Water-table cutting
 - Electric shock
 - Ventilation
 - Arc radiation
 - Noise
- 4. Describe the applications of PAC
 - Types of cuts
 - Machine
 - Manual
 - Stack
 - Gouging
 - Elements affecting cut
 - Materials being cut
 - Hard-to-cut metals
 - Carbon steel
 - Operating variables
 - Air pressure
 - Travel speed
 - Double arcing
 - Tip-to-work distance
 - Travel direction
 - Torch maintenance
- 5. Describe procedures for gouging cast iron
 - Polarity
 - Pre and post heat
- 6. Describe safety requirements, precautions and procedures for cutting and gouging
 - PPE
 - Eye protection for the electrical welding processes
 - Hearing protection
 - Welding helmets
 - Radiation protection
 - Respiratory protection



- Electric shock
 - Damp conditions
 - Treatment of electric shock victims
- Fire and explosion prevention
 - Refer to WorkSafeBC for fire watch regulations
- Safety requirements for operating electric welding equipment
 - Maintenance of equipment
 - Welding cables and connections
 - Electrode holder
 - Ground clamp
 - Electrode stub disposal
 - Slag
- Toxic fumes/ventilation



Line (GAC): **B** **Cutting and Gouging Processes**
Competency: **B6** **Use CAC-A and PAC cutting and gouging processes and equipment**

Objectives

To be competent in this area, the individual must be able to:

- Set up CAC-A equipment and demonstrate its cutting and gouging operations.
- Set up PAC equipment and demonstrate its cutting and gouging operations.

LEARNING TASKS

CONTENT

- | | |
|---|---|
| <p>1. Use CAC-A process on low carbon steel</p> | <ul style="list-style-type: none"> • Set up equipment • Gouge in all positions • Bevel in the flat position • Remove back-up strip/backing material • Remove discontinuities and faults on groove and fillet welds • Prepare joints |
| <p>2. Use PAC process on low carbon steel</p> | <ul style="list-style-type: none"> • Set up equipment • Perform cuts <ul style="list-style-type: none"> ○ Square cuts <ul style="list-style-type: none"> – Ferrous and non-ferrous ○ Bevel cuts ○ Circular cuts • Gouge in all positions • Bevel in the flat position • Prepare joints |

Achievement Criteria

- Performance** The learner will be evaluated on the ability to:
- Use CAC-A equipment to prepare weld joints and to remove weld faults on low carbon steel.
 - Assemble PAC equipment and perform bevel cuts, square cuts and circular cuts on both ferrous and non-ferrous metals.
- Conditions** As part of a practical shop project, given the required tools and materials.
- Criteria**
- Weld joints will be evaluated for:
 - Uniform width and depth
 - Clean, smooth groove in a straight line
 - Absence of arc strikes
 - No traces of carbon deposit
 - Overall appearance
 - Removal of weld faults will be evaluated for:
 - Complete removal of weld metal or weld defect
 - Absence of arc strikes
 - No traces of carbon deposit



- No damage to base metal
- Clean, smooth gouge surfaces
- Shape of groove in respect to weld repair
- Overall appearance
- PAC cuts will be evaluated for:
 - Top edge is sharp (not rounded)
 - Slag is minimal and easily removed
 - Square cuts are consistently square (90°, not bevelled)
 - Bevelled cuts have a consistent bevel angle of 30°
 - Draglines are consistent and not too pronounced
 - Cut surface is flat and not rounded or concave
 - Bottom edge is sharp
 - Cut edge is straight (cut line was followed)

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): **C Fusion and Braze Welding (TB) Using the Oxy-Fuel (OFW) Process**

Competency: **C1 Describe fusion welding, braze welding and brazing processes and their applications**

Objectives

To be competent in this area, the individual must be able to:

- Describe fusion welding, braze welding, brazing processes, their applications and safety precautions.

LEARNING TASKS

CONTENT

- | | |
|---|--|
| <ol style="list-style-type: none"> 1. Describe the fusion welding process and its application
 2. Describe the braze welding process and its application
 3. Describe the brazing process and its applications | <ul style="list-style-type: none"> • Principles of fusion welding • Filler rods • Applications of fusion welding • Maintenance or repair work • Fabrication • Safety requirements
 • Principles of braze welding • Filler rods • Applications • Maintenance or repair work • Light gauge metals • Dissimilar metals • Grey cast iron • Non-ferrous metals • Safety requirements
 • Principles of brazing • Filler rods • Applications • Safety requirements |
|---|--|



Line (GAC): **C Fusion and Braze Welding (TB) Using the Oxy-Fuel (OFW) Process**

Competency: **C2 Describe fusion welding, braze welding and brazing equipment and its operation**

Objectives

To be competent in this area, the individual must be able to:

- Describe fusion and braze welding equipment and its operation.

LEARNING TASKS

CONTENT

- | | |
|---|---|
| <p>1. Describe OFW equipment and application</p> | <ul style="list-style-type: none"> • Fundamentals of OFW process • Types of equipment <ul style="list-style-type: none"> ○ Regulators ○ Flashback arrestors ○ Hoses ○ Types of torch bodies ○ Torch attachments • Match equipment to application |
| <p>2. Describe fuel gas precautions and procedures</p> | <ul style="list-style-type: none"> • Characteristics of fuel gases • Fuel gas delivery systems • Cylinder and gases handling procedures • Cylinder and gases storage requirements • Hazards associated with different fuel gases • Match fuel gas to type of equipment • Identify type of fuel gas from information on label |
| <p>3. Describe the main factors to consider in gas fusion welding</p> | <ul style="list-style-type: none"> • Correct tip sizes • Correct flame setting • Distance between work and flame • Types of welding technique • Torch angle • Speed and travel movement • Operator comfort and position |
| <p>4. Describe tips and their application</p> | <ul style="list-style-type: none"> • Type of base metal • Base metal thickness • Tip functions • Required weld • Types of tips • Match tip to base metal and required weld • Differentiate between tips |



5. Describe consumables and requirements
 - Fluxes
 - Filler metals

6. Describe operating parameters
 - Base metal thickness
 - Welding tip sizes
 - Gas regulators
 - Manufacturers' recommendations
 - Other task specific guidelines
 - Reference information

7. Describe setting up OFW equipment
 - Set-up procedures
 - OFW safe practices
 - Equipment leak test procedures
 - Safety precautions
 - Reference manufacturers' instructions

8. Describe operating OFW equipment
 - Required task-specific PPE
 - Safe operating practices
 - Prevent flashback
 - Recognize flashback
 - Flashback conditions
 - Prevent backfire burnback
 - Recognize backfire burnback
 - Backfire burnback conditions
 - Welding techniques
 - Metallurgy
 - Types of flames
 - Braze welding techniques
 - Brazing fluxes
 - Flame temperatures
 - Metal fusion techniques
 - Light and adjust torch
 - Detecting defects in weld

9. Describe process related weld discontinuities and their causes
 - Weld defects
 - Lack of penetration
 - Lack of fusion
 - Undercut
 - Reinforcement on groove welds
 - Correct weld profile for fillet weld



Line (GAC): C Fusion and Braze Welding (TB) Using the Oxy-Fuel (OFW) Process

Competency: C3 Describe filler metals, fluxes and tips used for fusion welding, braze welding and brazing

Objectives

To be competent in this area the individual must be able to:

- Identify filler metals, fluxes and tips used for fusion welding, braze welding and brazing.

LEARNING TASKS

CONTENT

- | | |
|--|--|
| <p>1. Describe the filler rods for fusion welding, braze welding and brazing</p> | <ul style="list-style-type: none"> • Filler rods for fusion welding • Low carbon steel rods <ul style="list-style-type: none"> ○ RG 45 ○ RG 60 ○ RG 65 • Filler rod size • Brazing and braze welding alloys <ul style="list-style-type: none"> ○ Silver (BAg) ○ Aluminum-silicon (BA 1Si) ○ Precious-metals (BAu) ○ Copper and copper-zinc (BCu and RBCuZn) brass ○ Copper-phosphorous (BCuP) ○ Magnesium (BMg) ○ Nickel (BNi) ○ Cobalt (BCo) • Choosing a brazing filler rod <ul style="list-style-type: none"> ○ Braze welding filler rods |
| <p>2. Describe the flux for fusion welding, braze welding and brazing</p> | <ul style="list-style-type: none"> • Purpose of flux <ul style="list-style-type: none"> ○ Welding flux ○ Brazing flux • High temperature • Special purpose or low temperature • General purpose flux • Choosing the correct brazing flux <ul style="list-style-type: none"> ○ Using flux ○ Removing flux |
| <p>3. Describe tips for fusion welding, braze welding and brazing</p> | <ul style="list-style-type: none"> • Welding tips <ul style="list-style-type: none"> ○ Selecting the correct welding tip ○ Welding tip maintenance |



Line (GAC): **C Fusion and Braze Welding (TB) Using the Oxy-Fuel (OFW) Process**

Competency: **C4 Describe joint design and weld positions for OFW**

Objectives

To be competent in this area, the individual must be able to:

- Identify basic joint designs, weld positions and the associated abbreviations.

LEARNING TASKS

CONTENT

- | | |
|---|--|
| <p>1. Describe the five basic joints</p> | <ul style="list-style-type: none"> • Corner joint • Lap joint • Tee joint • Butt joint • Edge joint |
| <p>2. Describe the four basic welding positions and abbreviations</p> | <ul style="list-style-type: none"> • Flat position (1F, 1G) • Horizontal position (2F, 2G) • Vertical position (3F, 3G) • Overhead position (4F, 4G) |



Line (GAC): C Fusion and Braze Welding (TB) Using the Oxy-Fuel (OFW) Process

Competency: C5 Fusion weld on low carbon steel sheet

Objectives

To be competent in this area, the individual must be able to:

- Use the OFW process to fusion weld stringer beads on low carbon steel sheet.
- Use the OFW process to fusion weld fillet welds on low carbon steel sheet.
- Use the OFW process to fusion weld groove welds on low carbon steel sheet.

LEARNING TASKS

CONTENT

- | | |
|--|--|
| <p>1. Fusion weld stringer beads using the OFW process</p> | <ul style="list-style-type: none"> • In the flat position <ul style="list-style-type: none"> ○ Without a filler rod ○ With a filler rod |
| <p>2. Fusion weld fillet welds using the OFW process</p> | <ul style="list-style-type: none"> • In the flat (1F) position <ul style="list-style-type: none"> ○ Lap joint ○ Corner joint • In the horizontal (2F) position <ul style="list-style-type: none"> ○ Lap joint • In the vertical (3F) position <ul style="list-style-type: none"> ○ Lap joint |
| <p>3. Fusion weld groove welds using the OFW process</p> | <ul style="list-style-type: none"> • In the flat (1G) position |

Achievement Criteria

Performance The learner will be evaluated on the ability to fusion weld on low carbon steel sheet:

- Stringer beads, with and without filler metal, in the flat position.
- Fillet welds in the 1F, 2F and 3F (uphill) positions.
- Groove welds in the 1G position.

Conditions As part of a practical shop project, given the required tools and materials.

- Criteria**
- Stringer beads will be evaluated for:
 - Correct bead width
 - Convex weld bead profile (welds with filler metal rod)
 - Even ripples
 - Reasonable uniform straight beads
 - Complete fusion
 - Overall appearance
 - Fillet welds and groove welds will be evaluated for:
 - Correct sheet alignment
 - Correct bead width
 - Slightly convex weld bead profile
 - Even ripples



- Uniform, straight bead
- Absence of undercut
- Complete fusion
- Overall appearance

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): **C Fusion and Braze Welding (TB) Using the Oxy-Fuel (OFW) Process**

Competency: **C6 Braze weld (TB) using the OFW process**

Objectives

To be competent in this area, the individual must be able to:

- Braze weld fillet welds on low carbon steel sheet using OFW process.

LEARNING TASKS

CONTENT

- | | |
|---|--|
| <ol style="list-style-type: none"> 1. Describe the procedures for braze welding low carbon steel sheet
 2. Describe braze welding groove welds on grey cast iron using the OFW process
 3. Braze weld fillet welds using the OFW process | <ul style="list-style-type: none"> • Pre-cleaning and edge preparation • Flame setting • Filler rods and flux • Number of passes • Determining the quality of work
 • Braze weld grey cast iron • Pre-cleaning • Pre-heating • Special factors in welding grey cast iron • Welding technique
 • On low carbon steel sheet <ul style="list-style-type: none"> ○ In the flat (1F) position <ul style="list-style-type: none"> – Tee joint ○ In the horizontal (2F) position <ul style="list-style-type: none"> – Lap joint |
|---|--|

Achievement Criteria

Performance The learner will be evaluated on the ability to braze weld:

- Fillet welds on low carbon steel sheet.

Conditions As part of a practical shop project and given the required tools and equipment.

- Criteria**
- Welds will be evaluated for:
 - Correct sheet alignment
 - Correct bead width
 - Slightly convex weld bead profile
 - Even ripples
 - Uniform, straight bead
 - Good adhesion
 - Overall appearance

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): **C Fusion and Braze Welding (TB) Using the Oxy-Fuel (OFW) Process**

Competency: **C7 Silver alloy braze on similar and dissimilar metals**

Objectives

To be competent in this area, the individual must be able to:

- Describe silver alloy brazing on similar and dissimilar metals using OFW processes.

LEARNING TASKS

1. Describe the materials, equipment and procedures for silver brazing

CONTENT

- Joint preparation and design
- Flux selection
- Filler alloys (rods)
- Flame for brazing
- Silver brazing procedure



Line (GAC): **D** **Shielded Metal Arc Welding (SMAW)**

Competency: **D1** **Describe the SMAW process**

Objectives

To be competent in this area, the individual must be able to:

- Describe the SMAW process.
- Describe SMAW safety requirements and precautions.

LEARNING TASKS

CONTENT

- | | |
|---|---|
| <ol style="list-style-type: none"> 1. Describe the SMAW process and its applications 2. Describe safety requirements, precautions and procedures for SMAW | <ul style="list-style-type: none"> • Principles of SMAW • The arc welding circuit • PPE <ul style="list-style-type: none"> ○ Eye protection for the electrical welding processes ○ Welding helmets ○ Hearing protection ○ Radiation protection ○ Respiratory protection • Electric shock <ul style="list-style-type: none"> ○ Damp conditions ○ Treatment of electric shock victims • Fire and explosion prevention <ul style="list-style-type: none"> ○ Refer to WorkSafeBC for fire watch regulations • Safety requirements for operating electric welding equipment <ul style="list-style-type: none"> ○ Maintenance of equipment ○ Welding cables and connections ○ Electrode holder ○ Ground clamp ○ Electrode stub disposal ○ Slag ○ Toxic fumes/ventilation |
|---|---|



Line (GAC): **D Shielded Metal Arc Welding (SMAW)**
Competency: **D2 Describe SMAW equipment and its operation**

Objectives

To be competent in this area, the individual must be able to:

- Describe SMAW equipment and its operation.
- Describe the principles of electricity and types of current.
- Describe AC and DC welding power source, electrode holders, ground clamps and welding cables.

LEARNING TASKS

CONTENT

- | | |
|--|---|
| <p>1. Explain basic principles of electricity</p> | <ul style="list-style-type: none"> • Resistance • Effects of resistance • Electromagnetism • Transformers • Reactor |
| <p>2. Describe types of current and their applications</p> | <ul style="list-style-type: none"> • Alternating current • Direct current • Polarity • Arc blow • Dealing with arc blow |
| <p>3. Describe the effects of a volt-ampere curve on the welding arc</p> | <ul style="list-style-type: none"> • Volt-ampere curve • Interpreting the volt-ampere curve • Constant current welding power sources • Constant potential welding power sources • Adjusting the voltage • Adjusting the amperage |
| <p>4. Describe AC and DC welding power sources</p> | <ul style="list-style-type: none"> • Transformer type welding power sources <ul style="list-style-type: none"> ○ AC transformers <ul style="list-style-type: none"> – AC transformer control ○ Transformer/rectifiers <ul style="list-style-type: none"> – Transformer/rectifier control ○ AC/DC transformers/rectifiers ○ Advantages of transformer type welding power sources ○ Disadvantages of transformer type welding power sources • Generator/alternator type welding power sources • Electric motor drive DC welding power sources <ul style="list-style-type: none"> ○ Fuel engine driven AC, DC and AC/DC welding power sources ○ Controls |



- Advantages of generator/alternator type welding power sources
 - Disadvantages of generator/alternator type welding power sources
 - Multi-operator sets
 - Inverters
 - Advantages of inverter type welding power sources
 - Remote control devices
 - Ratings for welding power sources
 - Power requirements
 - Duty cycle
 - Choosing between AC and DC welding power sources
 - General maintenance of welding power sources

- 5. Describe and select electrode holders, ground clamps and welding cables
 - Electrode holder
 - Jaw
 - Twist head
 - Ground clamps
 - Spring-loaded
 - C-clamp
 - Rotary
 - Magnetic
 - Welding cables
 - Size
 - Connections



Line (GAC): D Shielded Metal Arc Welding (SMAW)

Competency: D3 Select electrodes for SMAW

Objectives

To be competent in this area, the individual must be able to:

- Describe low carbon steel filler metal electrodes.
- Describe hardsurfacing filler metal electrodes.
- Describe stainless steel filler metal electrodes.
- Describe the selection and applications of filler metal electrodes.
- Describe basic care, handling and storage of filler metal electrodes.

LEARNING TASKS

1. Describe the operation of common electrodes for SMAW

CONTENT

- Functions of electrode coatings
- Types of electrodes
 - F1 (fast-fill)
 - F2 (fill-freeze)
 - F3 (fast-freeze)
 - F4 (low hydrogen/basic electrode)
- Electrode coating composition
 - Cellulose
 - Rutile
 - China clay, silica and mica
 - Potassium
 - Ferro-manganese
 - Iron oxide (magnetite, hematite)
 - Iron powder
 - Sodium silicate
- Metal transfer with SMAW electrodes
- Gravity
- Gas expansion
- Electro-magnetic force
- Electromotive force
- Surface tension

2. Describe the classifications of low carbon steel electrodes

- Standards of coated electrode manufacture
- CSA and AWS designations
- Electrode length
- Electrode diameter



3. Describe the selection of filler metal electrodes for SMAW
 - Principles of electrode selection
 - Properties of the base metal
 - Joint design and fit up
 - Welding position and thickness of weld deposit
 - Welding current
 - Service conditions
 - Production factors
 - Common low carbon steel filler metal electrodes
 - E4310 (E6010)
 - E4311 (E6011)
 - E4313 (E6013)
 - E4914 (E7014)
 - E4924 (E7024)
 - E4918 (E7018)
 - E4928 (E7028)
 - Common hardsurfacing filler metal electrodes
 - Stainless steel filler metal electrodes
 - E309-15, -16, -17
 - Common filler metal electrodes for grey cast iron

4. Describe correct handling and storage of common electrodes
 - Handling of electrodes before and after use
 - Storage of electrodes
 - Electrode ovens
 - Handling of electrodes in use



Line (GAC): **D Shielded Metal Arc Welding (SMAW)**
Competency: **D4 Describe basic joint design and weld positions for SMAW**

Objectives

To be competent in this area, the individual must be able to:

- Describe basic joint design and weld positions for fillet welds using the SMAW process.
- Describe groove welds using the SMAW process.

LEARNING TASKS

CONTENT

- | | |
|---|---|
| <p>1. Describe the five basic joint types as they apply to SMAW processes</p> | <ul style="list-style-type: none"> • Lap • Tee • Corner • Edge • Butt |
| <p>2. Describe weld types, their sizes and profiles</p> | <ul style="list-style-type: none"> • Bead welds • Tack welds • Fillet welds • Groove welds <ul style="list-style-type: none"> ○ Square ○ Single-v and double-v ○ Single bevel and double bevel ○ Single U and double U ○ Single J and double J • Profiles, sizes, plate thickness transitions on butt joints • Plug and slot welds • Continuous and intermittent welding |



Line (GAC): D Shielded Metal Arc Welding (SMAW)

Competency: D5 Describe weld faults and distortion in fabrications in SMAW

Objectives

To be competent in this area, the individual must be able to:

- Describe weld faults and their causes.
- Describe distortions and methods of prevention.

LEARNING TASKS

1. Describe the process-related weld faults and their causes

2. Identify distortions and determine methods of prevention and control

CONTENT

- Dimensional defects
- Incorrect weld size
- Overlap
- Structural discontinuities in the weld
- Under cut
- Incomplete penetration
- Lack of fusion
- Porosity
- Slag inclusion
- Cracking (internal/external)
- Insufficient throat/underfill

- Types of distortion
 - Longitudinal distortion
 - Transverse distortion
 - Angular distortion
- Distortion control
 - Use mechanical methods
 - Design methods
 - Procedural methods
 - Rate of heat input/joules
 - Distribute the heat input as uniformly as possible
 - Pre-heat and post-heat when necessary



Line (GAC): **D Shielded Metal Arc Welding (SMAW)**
Competency: **D6 Use the SMAW process on low carbon steel plate and pipe**

Objectives

To be competent in this area, the individual must be able to:

- Describe primary adjustable variables.
- Use the SMAW process to weld bead welds in the flat position.
- Use the SMAW process to perform single-pass fillet welds on low carbon steel sheet.
- Use the SMAW process to perform multi-pass fillet welds on low carbon steel plate, structural shape to plate and on pipe to plate.
- Use the SMAW process to perform multi-pass groove welds on low carbon steel plate, structural shape to plate, and on pipe to plate.
- Perform multi-pass groove welds without backing on low carbon steel plate.
- Perform guided bend tests.

LEARNING TASKS

CONTENT

1. Describe main factors of the SMAW process

2. Describe primary adjustable variables

- Operator comfort and position
- Machine setting
- Arc length
- Electrode angle
- Speed of travel
- Electrode oscillation

- Arc blow
- Dealing with arc blow
- Volt-ampere curve
- Interpreting the volt-ampere curve
- Constant current welding power sources
- Adjusting the voltage
- Adjusting the amperage
- Transformer type welding power sources
- Generator/alternator type welding power sources
- Multi-process welding power sources
 - Inverters
 - Advantages of inverter type welding power sources
- Remote control devices
- Ratings for welding power sources
- Power requirements
- Duty cycle
- Choosing between AC and DC welding power sources
- General maintenance of welding power sources



3. Weld beads in the flat position
 - Strike an arc using scratch and tap method
 - Weld stringer beads in the flat position
 - Weld beads in the flat position using the weave method

4. Weld single-pass fillet welds
 - On low carbon steel sheet
 - Horizontal (2F) position
 - Lap joint
 - Tee joint
 - Vertical (3F) position - downhill
 - Lap joint
 - Tee joint

5. Weld multi-pass fillet welds
 - On low carbon steel plate
 - Flat (1F) position
 - Lap joint
 - Tee joint
 - Corner joint
 - Horizontal (2F) position
 - Lap joint
 - Tee joint
 - Corner joint
 - Vertical (3F) position
 - Lap joint - uphill
 - Tee joint - uphill
 - Corner joint – uphill
 - Vertical (4F) position
 - Lap joint
 - Tee joint
 - Corner joint
 - On structural shape to plate
 - Horizontal (2F) position
 - On pipe to plate
 - Horizontal (2F) position
 - Fixed vertical (5F) position

6. Weld multi-pass fillet groove welds on single bevel butt joints (with backing) using the SMAW process
 - On low carbon steel plate
 - Flat (1GF) position
 - Horizontal (2GF) position
 - Vertical (3GF) position - uphill
 - Overhead (4GF)

7. Weld multi-pass groove welds on single-v butt joints (without backing) using the SMAW process
 - On low carbon steel plate
 - Flat (1G) position

8. Perform guided bend tests
 - Guided bend test equipment
 - Types of guided bend tests
 - Face bend tests



- Root bend tests
- Side bend tests
- Causes of failure

Achievement Criteria 1

- Performance** The learner will be evaluated on the ability to use the SMAW process to:
- Strike an arc using the tap and scratch methods.
 - Weld stringer beads in the flat position and weave beads in the flat position.
 - Weld fillet welds in all positions on low carbon steel plate.
 - Weld fillet welds in the 2F and 3F positions on low carbon steel sheet.
- Conditions** As part of a practical shop project, given the required tools and materials.
- Criteria**
- Strike and maintain arc smoothly
 - Stringer bead and weave bead welds will be evaluated for:
 - Correct bead width
 - Reasonable smooth straight beads
 - Absence of arc strikes
 - Overall appearance
 - Weave bead welds will also be evaluated for crown-to-crown bead placement
 - Fillet welds will be evaluated for:
 - Correct alignment
 - Good penetration and fusion
 - Reasonable smoothness
 - Legs of equal length
 - Slightly convex profile
 - Absence of porosity, irregularities, undercut and arc strikes
 - Overall appearance

Completed within specifications, safety standards and time frames acceptable to industry.

Achievement Criteria 2

- Performance** The learner will be evaluated on the ability to weld using the SMAW process, including:
- Multi-pass fillet welds on pipe to plate in the 2F and 5F positions.
 - Groove welds on low carbon steel plate in the 1G, 1GF, 2GF, 3GF and 4GF positions.
- Conditions** As part of a practical shop project and given the required tools and equipment.
- Criteria**
- Fillet welds will be evaluated for:
 - Correct alignment
 - Good penetration and fusion
 - Reasonable smoothness
 - Legs of equal length
 - Slightly convex profile
 - Absence of porosity, irregularities, undercut and arc strikes
 - Overall appearance
 - Groove welds will be evaluated for:
 - Correct alignment
 - Acceptable smoothness and uniformity



- Absence of irregularities, distortion, undercutting at weld edge and stray strike marks
- Good fusion (wetting) of the deposit (or cover pass) to base metal
- Maximum face reinforcement of 3.2 mm (1/8").
- Maximum root reinforcement of 2.5 mm (3/32").
- Coupons will be evaluated in accordance with Section IX ASME code, CSA W47.1, W59.1 and/or applicable standards
 - Weld and heat-affected zone of a transverse weld-bend specimen shall be completely within the bent portion specimen after testing
 - Guided-bend specimens shall have no open defects in the weld or heat-affected zone exceeding 3.2 mm (1/8") in any direction on the convex surface of the specimen after bending
 - Cracks occurring on the corners of the specimen during testing shall not be considered unless there is definite evidence that they result from slag inclusions on other external defects.

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): D **Shielded Metal Arc Welding (SMAW)**
Competency: D7 **Use the hardsurfacing process on low carbon steel**

Objectives

To be competent in this area, the individual must be able to:

- Describe hardsurfacing preparation.
- Describe problems encountered while hardsurfacing.
- Use hardsurfacing on low carbon steel plate.

LEARNING TASKS

1. Describe hardsurfacing preparation and procedures

2. Describe problems encountered in hardsurfacing

CONTENT

- Welding polarity
- Types of wear
 - Abrasion
 - Impact
 - Erosion
 - Corrosion
 - Oxidation
 - Compression
 - Thermal shock
- Electrodes
 - High-speed steels
 - Austenitic manganese steels
 - Chromium carbides
 - Tungsten carbides
 - Copper alloys
 - Nickel chromium alloys
- Depositing filler metal
- Surface preparations
 - Buildup
 - Preheating
 - Cooling rate
 - Types of patterns
 - Stringer beads
- Dilution
- Spalling
- Underbead cracking
- Stress failure
- Weld cracking
- Transverse or cross cracking
- Longitudinal or centre-line cracking
- Distortion



- 3. Demonstrate build-up and hardsurfacing on low carbon steel plate
 - Build up
 - Flat (1S) position
 - Hardsurface
 - Flat (1S) position
 - Hardsurface buttons
 - Flat (1S) position

Achievement Criteria

Performance The learner will be evaluated on the ability to use the SMAW process to buildup and hard surface on low carbon steel plate in the flat position.

Conditions As part of a practical shop project, given the required tools and materials.

- Criteria**
- Buildup and hardsurfacing a waffle pattern will be evaluated for:
 - Correct alignment
 - Good penetration
 - Good fusion
 - Slightly convex profile
 - Reasonable smoothness
 - Maximum and minimum buildup according to specifications
 - Absence of irregularities, porosity, undercut and arc strikes
 - Overall appearance
 - Hardsurfacing a button pattern will be evaluated for:
 - Good fusion
 - Reasonable smoothness
 - Absence of irregularities, porosity and arc strikes
 - Overall appearance

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): D **Shielded Metal Arc Welding (SMAW)**
Competency: D8 **Describe the SMAW process on grey cast iron**

Objectives

To be competent in this area, the individual must be able to:

- Describe the SMAW process to prepare and apply filler metal to grey cast iron.

LEARNING TASKS

1. Describe the procedure for SMAW on grey cast iron

CONTENT

- Welding techniques
 - Hot welding
 - Cold welding
 - Peening to control bead shrinkage
 - Patching with low carbon steel
- Electrodes
 - ECI group
 - EST group
 - ENI group
- Joint preparation
- Problems welding grey cast iron
 - Contamination
 - Porosity
 - Cracking
 - Lack of fusion



Line (GAC): **D Shielded Metal Arc Welding (SMAW)**
Competency: **D9 Use the SMAW process on stainless steel and/or low carbon steel plate and pipe**

Objectives

To be competent in this area, the individual must be able to:

- Describe proper handling of stainless steel plate and consumables.
- Use the SMAW process to apply stainless steel filler metal to low carbon steel plate.

LEARNING TASKS

CONTENT

- | | |
|---|--|
| <ol style="list-style-type: none"> 1. Describe specific safety precautions when welding stainless steel
 2. Describe proper handling and preparation procedures for materials and consumables
 3. Describe the principal considerations in the SMAW welding of stainless steel
 4. Weld multi-pass fillet welds using stainless steel electrodes on low carbon steel plate | <ul style="list-style-type: none"> • PPE specific to stainless steel • Toxic fumes/ventilation • Electrode coatings <ul style="list-style-type: none"> ○ Chromium ○ Nickel • Reflective radiation
 • Material handling contamination • Abrasives and hand brushes • Rigging and tooling • Work area • Chemical cleaners
 • Machine settings • Heat input • Weld contamination • Surface oxidation of weld area • Distortion
 • Horizontal (2F) position |
|---|--|

**Achievement Criteria**

Performance The learner will be evaluated on the ability to weld multi-pass fillet welds on low carbon steel plate in the horizontal (2F) position using stainless steel filler metal electrodes.

Conditions As part of a practical shop project, given the required tools and materials.

- Criteria**
- Multi-pass fillet welds will be evaluated for:
 - Correct alignment
 - Good penetration
 - Reasonable smoothness
 - Legs of equal length
 - Slightly convex profile
 - Absence of irregularities, porosity, undercut and arc strikes
 - Overall appearance

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): **E Semi-Automatic and Automatic Welding**
Competency: **E1 Describe GMAW, GMAW-P, FCAW, MCAW and SAW processes and their applications**

Objectives

To be competent in this area, the individual must be able to:

- Describe semi-automatic processes and their applications.
- Describe modes of metal transfer.
- Describe safety precautions.
- Describe weld discontinuities.

LEARNING TASKS

CONTENT

- | | |
|---|---|
| <p>1. Describe the safety considerations for semi-automatic welding processes</p> | <ul style="list-style-type: none"> • PPE • Prevention of electric shock • Fire and explosion prevention • Maintenance of equipment • Toxic fumes/ventilation • Aluminum specific considerations <ul style="list-style-type: none"> ○ Ozone ○ Chemical cleaners • Stainless steel specific considerations <ul style="list-style-type: none"> ○ Chromium ○ Nickel ○ Chemical cleaners |
| <p>2. Describe the GMAW process and its application</p> | <ul style="list-style-type: none"> • Principles of GMAW • Application <ul style="list-style-type: none"> ○ Advantages and disadvantages • Components • Modes of metal transfer <ul style="list-style-type: none"> ○ Pinch effect ○ Short-circuit transfer ○ Globular transfer ○ Spray transfer ○ Transition currents |
| <p>3. Describe the GMAW-P process and its application</p> | <ul style="list-style-type: none"> • Principles of GMAW-P • Application <ul style="list-style-type: none"> ○ Advantages and disadvantages • Components • Modes of metal transfer <ul style="list-style-type: none"> ○ Pinch effect ○ Globular transfer ○ Spray transfer ○ Transition currents |



- Pulsed spray transfer
- 4. Describe the FCAW process and its application
 - Principles of FCAW
 - Application
 - Advantages and disadvantages
 - Components
 - Modes of metal transfer
 - Globular transfer
 - Spray transfer
- 5. Describe the MCAW process and its application
 - Principles of MCAW
 - Application
 - Advantages and disadvantages
 - Components
 - Modes of metal transfer
 - Globular transfer
 - Spray transfer
- 7. Describe the SAW process and its application
 - Principles of SAW
 - Application
 - Advantages and disadvantages
 - Components
 - Filler metals
 - Fluxes
- 8. Describe weld discontinuities in semi-automatic and automatic welding
 - Dimensional defects
 - Incorrect weld size
 - Overlap
 - Structural discontinuities in the weld
 - Under cut
 - Incomplete penetration
 - Lack of fusion
 - Porosity
 - Slag inclusion
 - Cracking (internal/external)
 - Insufficient throat/underfill



Line (GAC): E **Semi-Automatic and Automatic Welding**
Competency: E2 **Describe semi-automatic and automatic welding equipment and its operation**

Objectives

To be competent in this area, the individual must be able to:

- Describe semi-automatic and automatic equipment and its operation.
- Describe weld discontinuities.

LEARNING TASKS

1. Identify power sources for semi-automatic and automatic welding

2. Identify the equipment for semi-automatic and automatic wire-feed systems

3. Describe welding gun assemblies for semi-automatic and automatic processes

CONTENT

- Constant voltage/current power sources
 - Arc voltage
 - Slope
 - Inductance
- Inverter power sources
- Types of controls on power sources
 - Voltage controls
 - Slope controls
 - Inductance controls
 - Current controls
 - Voltmeters and ammeters
 - Remote controls and dual schedules
 - Pulsed power sources
- Wire feed speed (WFS)

- Types of systems
 - Push
 - Pull
 - Push-pull
- Wire-feed controls
- Drive roll types
- Constant and variable speed wire-feeders
- Aluminum specific considerations

- Welding gun types
 - Amperage rating
 - Water cooled
 - Gas cooled
 - Spool
- Welding gun consumables
- Cable assembly – size and adaptors
- Liners
- Preventive maintenance
- Aluminum specific considerations



4. Describe equipment for semi-automatic and automatic welding processes
 - Welding guns
 - Amperage rating
 - Water cooled
 - Gas cooled
 - Spool
 - Welding gun consumables
 - Welding cables
 - Aluminum specific considerations
 - Preventative maintenance
 - Filler metal
 - Shielding gases and flow devices
 - Troubleshooting
 - Mechanical
 - Electrical
 - Shielding gases

5. Describe process variables for semi-automatic and automatic welding
 - Primary process variables
 - Voltage
 - Wire feed speed
 - Welding current
 - Trim or arc length (GMAW-P)
 - Secondary process variables
 - Electrode extension (stickout)
 - Arc length
 - Contact tip to work distance
 - Push/pull technique
 - Gun to work angles
 - Nozzle to work distance
 - Travel speed

6. Identify process related weld discontinuities and their causes
 - Dimensional defects
 - Incorrect weld size
 - Insufficient throat/underfill
 - Structural discontinuities in the weld
 - Undercut
 - Incomplete penetration
 - Lack of fusion
 - Cold lap
 - Porosity
 - Cracking (internal/external)
 - Slag inclusions



Line (GAC): E **Semi-Automatic and Automatic Welding**
Competency: E3 **Describe filler metal and shielding gases for semi-automatic and automatic processes**

Objectives

To be competent in this area, the individual must be able to:

- Describe filler metal and shielding gases for semi-automatic and automatic processes.
- Describe the CSA and AWS filler metal classification systems and specifications for semi-automatic and automatic processes.
- Describe the application for commonly used semi-automatic and automatic processes.
- Describe the basic care, handling and storage procedures for filler metals used with semi-automatic and automatic processes.

LEARNING TASKS

CONTENT

- | | |
|---|--|
| <p>1. Describe filler metal for GMAW</p> | <ul style="list-style-type: none"> • Low carbon steel filler metal classification systems <ul style="list-style-type: none"> ○ CSA ○ AWS • Application of most common GMAW wires <ul style="list-style-type: none"> ○ ER49S-1 to 7 (ER70S-1 to 7) ○ ER49S-G (ER70S-G) • Handling and storage • Aluminum filler metal classification • Stainless steel filler metal classification |
| <p>2. Describe low carbon steel filler metals for FCAW and MCAW</p> | <ul style="list-style-type: none"> • Major classifications of FCAW low carbon steel filler metals <ul style="list-style-type: none"> ○ Gas-shielded wire (T-1 and T-9) ○ Self-shielded wire (T8 and T11) • Major classifications of MCAW low carbon steel filler metals • Filler metal handling procedures • Filler metal storage requirements |
| <p>3. Describe low carbon steel filler metals for SAW</p> | <ul style="list-style-type: none"> • Types • Classifications • Handling and storage requirements |
| <p>4. Describe fluxes for SAW</p> | <ul style="list-style-type: none"> • Types • Classifications • Handling and storage requirements |
| <p>5. Describe the shielding gases for semi-automatic and automatic processes</p> | <ul style="list-style-type: none"> • Types of shielding gases <ul style="list-style-type: none"> ○ Single gas <ul style="list-style-type: none"> – Carbon dioxide – Inert (argon and helium) ○ Mixed gas |



- Argon-oxygen mixtures
 - Helium-argon mixtures
 - Specific gas mixtures to suit applications
 - Quaternary mixtures
- Properties
 - Density
 - Thermal conductivity
 - Ionization potential
 - Flowrates for shielding gases
 - Solutions for regulator “freeze-up”
 - Cathode jet
- Components of shielding gas systems
 - Shielding gas cylinders
 - Carbon dioxide cylinders
 - Regulators
 - Flowmeters
 - Manifold systems
 - Gas mixers
- Safe handling



Line (GAC): E Semi-Automatic and Automatic Welding

Competency: E4 Use the GMAW and GMAW-P process

Objectives

To be competent in this area, the individual must be able to:

- Use the GMAW process to weld on low carbon steel plate.
- Use the GMAW process to weld on aluminum plate.
- Use spray transfer.
- Use the GMAW and GMAW-P processes to weld fillet welds on aluminum and stainless steel plate.
- Use the GMAW-P processes to weld fillet welds on aluminum and stainless steel plate.
- Use the GMAW processes to weld groove welds on low carbon steel plate and sheet
- Perform troubleshooting and maintenance of GMAW equipment.

LEARNING TASKS

1. Set up GMAW equipment using a DC constant voltage power source

2. Weld stringer beads using the GMAW process

3. Weld single-pass fillet welds using the GMAW process

CONTENT

- CV power source
- Wire feeder
- Drive rolls
- Welding gun
- Cable
- Wire
- Cylinder gas
- Flow meter
- Ground clamp

- On low carbon steel plate
 - In the flat (1S) position

- On low carbon steel sheet
 - In the horizontal (2F) position
 - Lap
 - Tee
 - In the vertical (3F) position
 - Lap (downhill)
 - Tee (downhill)

- On low carbon steel plate
 - In the flat (1F) position
 - Lap
 - Tee
 - Corner
 - In the horizontal (2F) position
 - Lap
 - Tee
 - Corner
 - In the vertical (3F) position
 - Lap (uphill and downhill)



- Tee (uphill and downhill)
 - On aluminum plate
 - In the horizontal (2F) position
 - Lap
- 4. Weld multi-pass fillet welds using the GMAW short circuit transfer process
 - On low carbon steel plate
 - In the vertical (3F) position
 - Tee (uphill and downhill)
- 5. Weld multi-pass fillet welds using the GMAW spray transfer process
 - On low carbon steel plate
 - In the flat (1F) position
 - Lap
 - Tee
 - In the horizontal (2F) position
 - Lap
 - Tee
 - On aluminum plate
 - In the horizontal (2F) position
 - Tee
- 6. Describe the principal considerations for welding aluminum using the GMAW process
 - Set welding variables
 - Heat input
 - Shielding gases
 - Weld contamination
 - Surface oxidation of weld area
 - Distortion
- 7. Identify welding variables for GMAW-P
 - Pre-selected variables
 - Equipment selection
 - Filler metal selection
 - Mode of metal transfer and shielding gas
 - Primary adjustable variables
 - Welding current
 - Trim
 - Secondary adjustable variables
 - Pushing and pulling techniques
 - Travel speed
 - Stickout
 - Gun angle
 - Troubleshooting
 - Dimensional defects
 - Incorrect weld size
 - Overlap
 - Excessive reinforcement
 - Structural discontinuities in the weld
 - Under cut
 - Incomplete penetration



- Lack of fusion
 - Porosity
 - Cracking (internal/external)
 - Insufficient throat/underfill
- 8. Set up GMAW-P equipment
 - Assemble GMAW-P equipment
 - Wire feeder requirements
 - Power source requirements
- 9. Describe the principle considerations for welding different types of metals using the GMAW and GMAW-P processes
 - Set welding variables
 - Heat input
 - Types of metals
 - Low carbon steel sheet and plate
 - Stainless steel
 - Aluminum
- 10. Weld single-pass fillet welds using the GMAW-P process
 - On low carbon steel sheet
 - Horizontal (2F) position
 - Lap joint
 - Tee joint
 - Vertical (3F) position - downhill
 - Lap joint
 - Tee joint
- 11. Weld multi-pass fillet welds using the GMAW-P process
 - On low carbon steel plate
 - Horizontal (2F) position
 - Lap joint
 - Vertical (3F) position - uphill
 - Lap joint
 - Tee joint
 - Overhead (4F) position
 - Lap joint
- 12. Weld multi-pass fillet welds using the GMAW spray transfer process
 - On low carbon steel sheet or plate
 - Horizontal (2F) position
 - Tee joint
- 13. Weld single-pass square groove welds using the GMAW short circuit transfer process
 - On low carbon steel sheet
 - Flat (1G) position
 - Vertical (3G) position - downhill
- 14. Weld single-pass square groove welds using the GMAW-P process
 - On low carbon steel sheet
 - Horizontal (2G) position
- 15. Weld multi-pass groove welds using the GMAW spray transfer process
 - On low carbon steel plate with single bevel butt joint (with backing)
 - Flat (1GF) position
- 16. Weld multi-pass groove welds using the GMAW short circuit transfer process
 - On low carbon steel plate with single-vee butt joint



- Flat (1G) position
 - Vertical (3G) position - downhill

- 17. Weld multi-pass fillet welds using the GMAW and GMAW-P processes on aluminum plate
 - On aluminum plate
 - Horizontal (2F) position
 - Lap joint
 - Tee joint
 - Vertical (3F) position – uphill
 - Lap joint
 - Tee joint
 - Overhead (4F) position
 - Tee joint

- 18. Weld single-pass fillet welds using the GMAW and GMAW-P processes on stainless steel plate
 - On stainless steel plate
 - Horizontal (2F) position
 - Lap joint
 - Tee joint

Achievement Criteria 1

- Performance** The learner will be evaluated on the ability to use the GMAW process to:
- Set up GMAW equipment using a DC constant voltage welding power source.
 - Weld beads in the 1S position and fillet welds in the 1F, 2F and 3F uphill positions on low carbon steel plate.
 - Weld fillet welds in the 2F and 3F downhill positions and on low carbon steel sheet.
 - Weld fillet welds in the 2F positions on aluminum plate.
- Conditions** As part of a practical shop project, given the required tools and materials.
- Criteria**
- Beads will be evaluated for:
 - Correct bead width
 - Reasonable straight and uniform weld beads
 - Absence of irregularities and arc strikes
 - Overall appearance
 - Fillet welds will be evaluated for:
 - Correct weld alignment
 - Correct fillet leg length
 - Slightly convex weld bead profile
 - Absence of irregularities, porosity, undercut and arc strikes
 - Good fusion
 - Overall appearance
 - In addition to the above, welds on aluminum will be evaluated for weld spatter

Completed within specifications, safety standards and time frames acceptable to industry.

Achievement Criteria 2

- Performance** The learner will be evaluated on the ability to use GMAW and GMAW-P to weld:
- Fillet welds on aluminum and stainless steel plate
 - Groove and fillet welds on low carbon steel plate and sheet.



- Conditions As part of a practical shop project, using the GMAW and GMAW-P processes and materials
- Criteria
- Groove welds will be evaluated for:
 - Correct alignment
 - Acceptable smoothness and uniformity
 - Absence of irregularities, distortion, undercutting at weld edge and stray strike marks
 - Good fusion (wetting) of the deposit (or cover pass) to base metal
 - Maximum face reinforcement of 3.2 mm (1/8").
 - Maximum root reinforcement of 2.5 mm (3/32").
 - Coupons will be evaluated in accordance with CSA W47.1 and/or Section IX ASME code
 - Weld and heat-affected zone of a transverse weld-bend specimen shall be completely within the bent portion specimen after testing
 - Guided-bend specimens shall have no open defects in the weld or heat-affected zone exceeding 3.2 mm (1/8") in any direction on the convex surface of the specimen after bending
 - Cracks occurring on the corners of the specimen during testing shall not be considered unless there is definite evidence that they result from slag inclusions on other external defects.

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): E Semi-Automatic and Automatic Welding

Competency: E5 Use the FCAW process

Objectives

To be competent in this area, the individual must be able to:

- Use the FCAW gas-shielded process to weld fillet welds on low carbon steel plate.
- Use the FCAW self-shielded process to weld fillet welds on low carbon steel plate.
- Use the FCAW process to weld fillet welds using stainless steel filler on low carbon steel plate.
- Describe hardsurfacing for FCAW.

LEARNING TASKS

CONTENT

- | | |
|---|---|
| <ol style="list-style-type: none"> 1. Identify welding variables for the FCAW process | <ul style="list-style-type: none"> • Pre-selected variables <ul style="list-style-type: none"> ○ Equipment selection ○ Filler metal selection ○ Mode of metal transfer ○ Primary adjustable variables ○ Welding current ○ Arc voltage • Secondary adjustable variables <ul style="list-style-type: none"> ○ Pushing and pulling techniques ○ Travel speed ○ Stickout ○ Gun angle |
| <ol style="list-style-type: none"> 2. Weld stringer beads using the FCAW process | <ul style="list-style-type: none"> • On low carbon steel plate using self-shielding filler metal <ul style="list-style-type: none"> ○ Flat (1S) position • On low carbon steel plate using gas-shielded filler metal <ul style="list-style-type: none"> ○ Flat (1S) position |
| <ol style="list-style-type: none"> 3. Weld single-pass fillet weld | <ul style="list-style-type: none"> • On low carbon steel sheet <ul style="list-style-type: none"> ○ Horizontal (2F) position <ul style="list-style-type: none"> – Lap joint |
| <ol style="list-style-type: none"> 4. Weld multi-pass fillet weld using the FCAW process and self-shielding filler metal | <ul style="list-style-type: none"> • On low carbon steel plate <ul style="list-style-type: none"> ○ Flat (1F) position <ul style="list-style-type: none"> – Lap joint ○ Horizontal (2F) position <ul style="list-style-type: none"> – Tee joint ○ Vertical (3F) position <ul style="list-style-type: none"> – Tee joint - uphill • On structural shape to plate <ul style="list-style-type: none"> ○ Overhead (4F) position |
| <ol style="list-style-type: none"> 5. Weld multi-pass fillet weld using the FCAW process and gas-shielded filler metal | <ul style="list-style-type: none"> • On low carbon steel plate <ul style="list-style-type: none"> ○ Flat (1F) position |



- Tee joint
 - Horizontal (2F) position
 - Lap joint
 - Tee joint
 - Vertical (3F) position
 - Lap joint
 - Tee joint - uphill
 - Overhead (4F) position
 - Tee joint
 - On structural shape to plate
 - Horizontal (2F) position
6. Describe the principal considerations in the FCAW welding of stainless steel
- Set welding variables
 - Heat input
 - Shielding gases
 - Weld contamination
 - Surface oxidation of weld area
 - Distortion
7. Weld multi-pass fillet weld using the FCAW process using stainless steel filler metal **(optional)**
- On low carbon steel plate
 - Horizontal (2F) position
 - Tee joint
8. Weld multi-pass groove welds
- On low carbon steel plate
 - Flat (1G) position
 - Butt joint (both sides)
 - Gouge to Sound Metal (GTSM)
 - Side bend tests
 - On low carbon steel plate with single bevel butt joint with backing
 - Flat (1GF) position
 - Horizontal (2GF) position
 - Vertical (3GF) position - uphill
 - Overhead (4GF) position
9. Describe hardsurfacing for FCAW
- Types of hardsurfacing materials
 - Application

Achievement Criteria

- Performance The learner will be evaluated on the ability to use the FCAW process to:
- Weld stringer beads in the flat position on low carbon steel plate.
 - Weld fillet welds in a variety of positions on low carbon steel plate using self-shielded filler metal wire and using gas-shielded filler metal wire.
 - Weld fillet welds in the 3F and 4F positions on tee joints.
 - Weld fillet welds using stainless steel filler metal on low carbon steel plate. **(optional)**
 - Weld multi-pass groove welds 1GF, 2GF, 3GF, 4GF on low carbon steel plate.
 - Weld a square groove butt joint in the flat 1G position.
- Conditions As part of a practical shop project, given the required tools and equipment.



Criteria

- Stringer beads will be evaluated for:
 - Correct bead width
 - Reasonable straight and uniform weld beads
 - Absence of irregularities and arc strikes
 - Overall appearance
- Fillet welds will be evaluated for:
 - Correct weld alignment and
 - Equal leg length
 - Slightly convex weld bead profile
 - Absence of irregularities, porosity, undercut and arc strikes
 - Acceptable smoothness, uniformity and straightness of weld passes
 - Good fusion
 - Overall appearance
 - In addition, fillet welds on aluminum will be evaluated for weld spatter
- Groove welds will be evaluated for:
 - Correct alignment
 - Acceptable smoothness and uniformity
 - Absence of irregularities, distortion, undercutting at weld edge and stray strike marks
 - Good fusion (wetting) of the deposit (or cover pass) to base metal
 - Maximum face reinforcement of 3.2 mm (1/8")
 - Maximum root reinforcement of 2.5 mm (3/32")
- Coupons will be evaluated in accordance with CSA W47.1 and/or Section IX ASME code
 - Weld and heat-affected zone of a transverse weld-bend specimen shall be completely within the bent portion specimen after testing
 - Guided-bend specimens shall have no open defects in the weld or heat-affected zone exceeding 3.2 mm (1/8") in any direction on the convex surface of the specimen after bending
 - Cracks occurring on the corners of the specimen during testing shall not be considered unless there is definite evidence that they result from slag inclusions on other external defects.

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): E Semi-Automatic and Automatic Welding

Competency: E6 Use the MCAW process

Objectives

To be competent in this area, the individual must be able to:

- Select filler metals and shielding gases for MCAW.
- Describe the welding variables for using the MCAW process on low carbon steel plate.
- Use the MCAW process to weld fillet welds and groove welds on low carbon steel plate.

LEARNING TASKS

CONTENT

- | | |
|--|--|
| <ol style="list-style-type: none"> 1. Identify welding variables for MCAW on low carbon steel plate | <ul style="list-style-type: none"> • Pre-selected variables <ul style="list-style-type: none"> ○ Equipment selection ○ Filler metal selection ○ Mode of metal transfer ○ Primary adjustable variables ○ Welding current ○ Arc voltage • Secondary adjustable variables <ul style="list-style-type: none"> ○ Pushing and pulling techniques ○ Travel speed ○ Stickout ○ Gun angle |
| <ol style="list-style-type: none"> 2. Weld multi-pass fillet welds using the MCAW process | <ul style="list-style-type: none"> • On low carbon steel plate <ul style="list-style-type: none"> ○ Flat (1F) position <ul style="list-style-type: none"> – Lap joint – Tee joint ○ Horizontal (2F) position <ul style="list-style-type: none"> – Lap joint – Tee joint |
| <ol style="list-style-type: none"> 3. Weld multi-pass square groove welds using the MCAW process | <ul style="list-style-type: none"> • On low carbon steel plate <ul style="list-style-type: none"> ○ Flat (1G) position <ul style="list-style-type: none"> – Butt joint (both sides) – Gouge to Sound Metal (GTSM) ○ Side bend tests |
| <ol style="list-style-type: none"> 4. Weld multi-pass groove welds using the MCAW process | <ul style="list-style-type: none"> • On low carbon steel plate with single bevel butt joint (with backing) <ul style="list-style-type: none"> ○ Flat (1GF) position • Face and root bend tests |

**Achievement Criteria**

- Performance The learner will be evaluated on the ability to use the MCAW process to:
- Weld fillet welds in the 1F and 2F positions on low carbon steel plate.
 - Weld groove welds in the 1G position on low carbon steel plate.
 - Successful face, root and side bent tests.
- Conditions As part of a practical shop project, given the required tools and materials.
- Criteria
- Fillet welds will be evaluated for:
 - Correct alignment
 - Equal leg length
 - Slightly convex profile
 - Acceptable smoothness, uniformity and straightness of weld passes
 - Absence of porosity
 - Absence of undercut
 - Absence of stray arc strikes
 - Groove welds will be evaluated for:
 - Correct alignment
 - Straightness of cover pass
 - Good fusion (wetting) of cover pass to base metal
 - Acceptable smoothness and uniformity
 - Absence of undercut and stray arc strikes
 - Maximum reinforcement of 3.2 mm (1/8")
 - Coupons will be evaluated for successful completion of guided bend tests on face and root or side bends will be evaluated to CSA W47.1

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): E Semi-Automatic and Automatic Welding

Competency: E7 Use the SAW process

Objectives

To be competent in this area, the individual must be able to:

- Describe the welding variables for using the SAW process on low carbon steel plate.
- Use the SAW process to weld fillet welds on low carbon steel plate.

LEARNING TASKS

1. Identify welding variables for SAW on low carbon steel plate

2. Weld multi-pass fillet welds using the SAW process

CONTENT

- Pre-selected variables
 - Equipment selection
 - Filler metal selection
 - Mode of metal transfer
 - Primary adjustable variables
 - Welding current
 - Arc voltage
- Secondary adjustable variables
 - Pushing and pulling techniques
 - Travel speed
 - Stickout
 - Gun angle
- On low carbon steel plate
 - Flat (1F) position
 - Tee joint

Achievement Criteria

Performance The learner will be evaluated on the ability to use the SAW process to:

- Weld fillet welds in the 1F position on low carbon steel plate.

Conditions As part of a practical shop project, given the required tools and materials.

- Criteria**
- Fillet welds will be evaluated for:
 - Correct alignment
 - Equal leg length
 - Slightly convex profile
 - Acceptable smoothness, uniformity and straightness of weld passes
 - Absence of porosity
 - Absence of undercut
 - Absence of stray arc strikes

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): F **Gas Tungsten Arc Welding (GTAW)**
Competency: F1 **Describe the GTAW process and its application**

Objectives

To be competent in this area, the individual must be able to:

- Describe the GTAW process.
- Describe the function of electrodes and shielding gases.
- Describe the basic components of a GTAW work station.
- Identify the applications of GTAW and the safety requirements.

LEARNING TASKS

CONTENT

- | | |
|---|---|
| <p>1. Describe the GTAW process, equipment and applications</p> | <ul style="list-style-type: none"> • Components of a GTAW workstation <ul style="list-style-type: none"> ○ Electrodes ○ Filler rods ○ Shielding gases • GTAW process <ul style="list-style-type: none"> ○ Applications ○ Advantages ○ Disadvantages |
| <p>2. Identify safety requirements for GTAW</p> | <ul style="list-style-type: none"> • Safe working practices • Special PPE requirements • Ozone |
| <p>3. Describe purging requirements and techniques</p> | <ul style="list-style-type: none"> • Purging <ul style="list-style-type: none"> ○ Purpose ○ Types of purging gas <ul style="list-style-type: none"> – Argon – Nitrogen ○ Equipment <ul style="list-style-type: none"> – Dams – Flow regulators • Purging calculation charts • Techniques |



Line (GAC): F **Gas Tungsten Arc Welding (GTAW)**
Competency: F2 **Describe GTAW equipment and its operation**

Objectives

To be competent in this area, the individual must be able to:

- Identify types of GTAW power sources.
- Describe shielding gases and systems.
- Describe torches and their components.
- Describe tungsten electrodes used for GTAW.
- Correctly assemble GTAW equipment.

LEARNING TASKS

CONTENT

- | | |
|--|--|
| <ol style="list-style-type: none"> 1. Describe GTAW power sources and their operation
 2. Describe shielding gases and equipment used in GTAW
 3. Describe GTAW torches and their components
 4. Describe tungsten electrodes used for GTAW | <ul style="list-style-type: none"> • Welding current for GTAW • Controls on GTAW power source <ul style="list-style-type: none"> ○ Current controls ○ High-frequency controls ○ Shielding gas controls ○ Water flow controls ○ Remote controls and contact switches • Types of shielding gases <ul style="list-style-type: none"> ○ Argon ○ Helium • Gas regulators • Flowmeters • Hoses
 • Types of torches <ul style="list-style-type: none"> ○ Air-cooled ○ Water-cooled • Torch components <ul style="list-style-type: none"> ○ Torch body ○ Collet body ○ Gas lens ○ Collet ○ Back cap ○ Gas nozzles or cups <ul style="list-style-type: none"> – Ceramic gas cups – Alumina cups – Fused-quartz cups • Water radiator
 • Types of electrodes <ul style="list-style-type: none"> ○ Pure tungsten electrodes ○ Thoriated tungsten <ul style="list-style-type: none"> – Non-radioactive |
|--|--|



- (Ceriated, Lanthanated)
 - Zirconium alloyed tungsten
 - Electrode finishes
 - Electrode selection
 - Size
 - Current
 - Profile preparation of tungsten electrodes
 - Balled or rounded ends
 - Tapered or pointed ends
 - Proper use
 - Preventing contamination
 - Avoiding heat build up
- 5. Select and assemble GTAW welding equipment
 - Torches
 - Tungsten electrodes
 - Maintenance, care and storage

Achievement Criteria

- Performance** The learner will be evaluated on the ability to select and assemble gas tungsten arc welding equipment and correctly prepare tungsten electrodes for the GTAW process.
- Conditions** As part of a practical shop project, given the required tools and equipment.
- Criteria** Equipment must be assembled correctly, within specifications, safety standards and time frames acceptable to industry.



Line (GAC): F **Gas Tungsten Arc Welding (GTAW)**
Competency: F3 **Describe the application of GTAW for ferrous metals**

Objectives

To be competent in this area, the individual must be able to:

- Describe the GTAW process on low carbon steel.
- Identify discontinuities.
- Identify the main factors of GTAW.

LEARNING TASKS

1. Describe the GTAW process
2. Identify discontinuities in the GTAW process
3. Identify the main factors of GTAW

CONTENT

- Low carbon steel
 - Filler metals
 - Deoxidized filler rod
 - Handling and storing filler rod
 - Welding low carbon steel
- Incomplete and insufficient penetration
- Excessive penetration
- Undercut
- Porosity and dark appearance
- Burn-through
- Root side concavity (suck-back)
- Tungsten inclusion
- Weld cracking
- Power source setting
- Welding torch, electrode and filler rod variables
- Electrode stickout
- Arc length
- Torch angle and filler metal angle
 - Butt joints
 - Lap joints
 - Tee joints
 - Corner joints
- Shielding gas flow
- Speed of travel
- Operator comfort and position



Line (GAC): F Gas Tungsten Arc Welding (GTAW)

Competency: F4 Use the GTAW process for ferrous metals

Objectives

To be competent in this area, the individual must be able to:

- Use the GTAW process to strike an arc using three methods.
- Use the GTAW process to weld stringer beads and fillet welds on low carbon steel sheet.
- Use the GTAW process to weld groove welds on low carbon steel sheet.

LEARNING TASKS

CONTENT

- | | | |
|----|-----------------------------------|--|
| 1 | Strike an arc using three methods | <ul style="list-style-type: none"> • Methods <ul style="list-style-type: none"> ○ Scratch start ○ Lift arc ○ High frequency |
| 2. | Weld stringer beads | <ul style="list-style-type: none"> • Flat (1S) position |
| 3. | Weld single-pass fillet welds | <ul style="list-style-type: none"> • On low carbon steel sheet: <ul style="list-style-type: none"> ○ Flat (1F) position <ul style="list-style-type: none"> – Corner joints ○ Horizontal (2F) position <ul style="list-style-type: none"> – Lap joints – Tee joints ○ Vertical (3F) position - uphill <ul style="list-style-type: none"> – Lap joints – Tee joints |
| 4. | Weld single-pass groove welds | <ul style="list-style-type: none"> • On low carbon steel sheet <ul style="list-style-type: none"> ○ Flat (1G) position |

Achievement Criteria

- Performance** The learner will be evaluated on the ability to:
- Strike an arc using the touch start methods and high frequency start method.
 - Weld stringer beads in the 1S flat position on low carbon steel sheet.
 - Weld fillet welds in the 1F, 2F and 3F uphill positions on lap and tee joints on low carbon steel sheet.
 - Weld single-pass groove weld in the 1G position on low carbon steel sheet.

- Conditions** As part of a practical shop project and given the required tools and equipment.
- Criteria**
- Striking an arc must follow correct procedure and establish a weld pool of desirable size.
 - Stringer beads will be evaluated for:
 - Good fusion
 - Smooth, slightly convex beads
 - Absence of stray strike marks
 - Absence of irregularities, porosity and undercut
 - Fillet welds will be evaluated for each of the criteria above, plus they must have legs of equal length
 - Groove welds will be evaluated for each of the criteria above, plus they must have complete root penetration

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): F Gas Tungsten Arc Welding (GTAW)

Competency: F5 Use the GTAW process for stainless steel

Objectives

To be competent in this area the individual must be able to:

- Describe the GTAW process and procedures on stainless steel.
- Use the GTAW process to weld fillet welds on stainless steel sheet.
- Use the GTAW process to weld groove welds on stainless steel sheet.

LEARNING TASKS

CONTENT

- | | |
|---|---|
| <ol style="list-style-type: none"> 1. Describe the GTAW process and procedures on stainless steel
 2. Describe purging and fluxing requirements and techniques
 3. Weld single-pass fillet welds
 4. Weld single-pass groove welds | <ul style="list-style-type: none"> • Stainless steel filler metal • Welding stainless steel • Joint design for stainless steel • Preparation of stainless steel: <ul style="list-style-type: none"> ○ Pre-cleaning ○ Post-cleaning • Recognize weld defects
 • Purging <ul style="list-style-type: none"> ○ Purpose ○ Types of purging gas <ul style="list-style-type: none"> – Argon – Nitrogen ○ Equipment <ul style="list-style-type: none"> – Dams – Flow regulators • Purging calculation charts • Techniques • Solar flux
 • On stainless steel sheet <ul style="list-style-type: none"> ○ Horizontal (2F) position <ul style="list-style-type: none"> – Lap joints – Tee joints ○ Vertical (3F) position - uphill <ul style="list-style-type: none"> – Lap joints – Tee joints
 • On stainless steel sheet <ul style="list-style-type: none"> ○ Flat (1G) position |
|---|---|

**Achievement Criteria**

- Performance The learner will be evaluated on the ability to use the GTAW process to:
- Weld fillet welds in the 2F, 3F uphill position on lap and tee joints on stainless steel sheet.
 - Weld groove welds in the 1G position on stainless steel sheet.
- Conditions As part of a practical shop project and given the required tools and equipment.
- Criteria
- All welds will be evaluated for:
 - Good fusion
 - Smooth, slightly convex beads
 - Absence of irregularities, porosity, undercut and stray strike marks
 - Fillet welds will be evaluated for each of the criteria above, and they must have legs of equal length
 - Groove welds will be evaluated for each of the criteria above, and they must have complete joint penetration

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): **H** **Basic Metallurgy**

Competency: **H1** **Describe production processes for manufacturing metals**

Objectives

To be competent in this area, the individual must be able to:

- Describe the production processes for manufacturing metals.

LEARNING TASKS

1. Describe types of iron and current production methods

2. Describe current steel production and forming methods

CONTENT

- Blast furnace – pig iron
- Cast irons
- Grey cast iron
- White cast iron
- Malleable cast iron
- Nodular iron (ductile iron)

- Open hearth furnace
- Basic oxygen furnace
- Electric furnace
- Bessemer converter
- Ingots
- Rimmed, killed and semi-killed steel
- Continuous casting process
- Blooms, billets and slabs
- Hot and cold-rolled sheet products
- Galvanized sheet steel products
- Tin mill products
- Structural shapes and bars
- Steel plate and large diameter pipe
 - Pipe and tubing
 - ERW
 - Seamless
- Forging process
 - Open-die forging
 - Closed-die forging
- Casting process
 - Sand casting
 - Centrifugal casting
 - Die casting



3. Describe types of steel and steel classifications
 - Main elements of carbon steels
 - Types of steel
 - Low carbon
 - Medium carbon
 - High carbon (tool)
 - Alloying elements
 - Chromium
 - Cobalt
 - Copper
 - Magnesium
 - Nickel
 - Titanium
 - Tungsten
 - Vanadium
 - Steel classification
 - CSA standards
 - UNS numbering system
 - SAE and AISI systems
 - First digit
 - Second digit
 - Third and fourth digits
 - ASTM classification
 - Manufacturer's certification and identification markings
 - Colour coding
 - Numbering systems
 - Heat numbers
 - Mill certification



Line (GAC): H Basic Metallurgy

Competency: H2 Describe mechanical and physical properties of ferrous and non-ferrous metals

Objectives

To be competent in this area, the individual must be able to:

- Identify the mechanical and physical properties of metals.

LEARNING TASKS

1. Define the terms relating to mechanical and physical properties of metals
2. Describe the mechanical properties of metals
3. Describe the physical properties of metals

CONTENT

- Metallurgy
- Alloys
- Ferrous metals
- Wrought iron
- Cast iron
- Carbon steels
- Low alloy steels
- Alloy steels
- Non-ferrous metals
 - Aluminum
 - Copper
 - Lead
 - Magnesium
 - Nickel
 - Silver
 - Tin
 - Zinc
- Tensile strength
- Elasticity, yield point, ultimate tensile strength
- Elongation
- Impact strength
- Compressive strength
- Fatigue strength
- Toughness
- Hardness
- Ductility
- Malleability
- Brittleness
- Density
- Resistance to corrosion
- Electrical conductivity
- Thermal conductivity
- Thermal expansion
- Melting point



Line (GAC): H Basic Metallurgy

Competency: H3 Describe common ferrous, non-ferrous and reactive metals and their weldability

Objectives

To be competent in this area, the individual must be able to:

- Identify metals by their visual appearance, relative weight, typical shape and texture.
- Describe tests for identifying metals.

LEARNING TASKS

CONTENT

- | | |
|--|---|
| <p>1. Describe types of metals by their physical characteristics (visual appearance, colour, relative weight, typical shape and texture)</p> | <ul style="list-style-type: none"> • Steel • Cast steel • Cast irons • Copper • Brass and bronze • Aluminum • Stainless steel • Lead • Magnesium • Zinc • Titanium |
| <p>2. Describe mechanical and thermal tests for identifying metals</p> | <ul style="list-style-type: none"> • Chip • Spark • Hardness • Files • Center punch • Chisel • Flame • Magnetic • Non-magnetic • Slightly magnetic • Melting point |
| <p>3. Describe weldability and pre and post heat treatment</p> | <ul style="list-style-type: none"> • Low carbon steel • Cast iron • Aluminum • Stainless steel |

Achievement Criteria

Performance The learner will be evaluated on the ability to inspect metals for identification.

Conditions As part of a practical shop project, given the required tools and materials.

- Criteria**
- Identify metals by visual inspection
 - Perform flame, chip, spark and file tests

Completed within specifications, safety standards and time frames acceptable to industry.



Line (GAC): I **Welding Drawings, Layout and Fabrication**
Competency: I1 **Identify common welding symbols and bolted connections**

Objectives

To be competent in this area, the individual must be able to:

- Identify standard welding symbols and supplementary welding symbols.
- Describe the dimensioning of fillet and groove weld symbols.
- Describe other weld symbols and the dimensioning of threaded fasteners used in structural steel construction.

LEARNING TASKS

CONTENT

- | | |
|--|---|
| <p>1. Describe standard welding symbols</p> | <ul style="list-style-type: none"> • Welding symbols <ul style="list-style-type: none"> ○ Arrows ○ Supplementary weld symbols ○ Weld-all-around symbol ○ Field weld symbol ○ Contour and finish symbols ○ Location of weld symbol |
| <p>2. Describe the dimensioning of fillet and groove welds</p> | <ul style="list-style-type: none"> • Fillet welds <ul style="list-style-type: none"> ○ Size ○ Length ○ Intermittent fillet welds • Groove welds <ul style="list-style-type: none"> ○ Groove size (depth of operation) ○ Effective throat size (depth of penetration) ○ Root opening ○ Groove or included angle ○ Backing or spacer material symbol • Complete penetration welds <ul style="list-style-type: none"> ○ Back gouging and its application to groove welds ○ Back welds and backing welds ○ Melt-thru welds |



3. Identify other basic weld symbols and their dimensions
 - Plug welds
 - Plug size
 - Angle of countersink
 - Depth of filling
 - Slot welds
 - Spot welds
 - Size and strength of spot welds
 - Pitch of spot welds
 - Number of spot welds
 - Seam welds
 - Size and strength of seam welds
 - Scarf for brazed joint
 - Flange welds
 - Surface welds

4. Identify the dimensioning of bolted connections
 - Thread symbols on drawings
 - Designation of UNC and UNF threads
 - Metric thread designations



Line (GAC): I **Welding Drawings Layout and Fabrication**

Competency: I2 **Read and interpret drawings**

Objectives

To be competent in this area, the individual must be able to:

- Read structural drawings.

LEARNING TASKS

1. Identify types of structural drawings

2. Identify bills of material and other information found on structural drawings

CONTENT

- Engineering drawings
- Site plans
- Foundation plans
- Framing plans
- Elevation plans
- Sections
- Connection detail drawings
- Shop drawings
- Detail drawings
- Assembly drawings
- Detail assembly drawings

- Title block
- Revisions block
- Notes and specifications
- Material list
- Item number
- Quantity
- Description
- Length
- Specifications
- Material
- Remarks



Line (GAC): I **Welding Drawings Layout and Fabrication**
Competency: I3 **Perform basic drafting**

Objectives

To be competent in this area, the individual must be able to:

- Describe types of drawings, basic lines used on drawings, and auxiliary and sectional views.
- Sketch orthographic projections of basic objects.
- Sketch isometric and dimensioned drawings of basic objects.

LEARNING TASKS

CONTENT

- | | |
|--|---|
| 1. Describe types of drawings | <ul style="list-style-type: none"> • Orthographic • Pictorial • Isometric |
| 2. Identify basic lines used in drawings | <ul style="list-style-type: none"> • Object lines • Hidden lines • Centre lines • Dimension and extension lines • Leader lines • Phantom lines • Cutting plane lines • Section lines • Break lines |
| 3. Draw orthographic projections | <ul style="list-style-type: none"> • Freehand sketching to approximate scale • Graph paper • Sketching orthographic views • Scale rule |
| 4. Describe and draw auxiliary and sectional views | <ul style="list-style-type: none"> • Auxiliary views • Sectional views • Locating sectional views • Showing sectional views • Types of sectional views <ul style="list-style-type: none"> ○ Full sections ○ Half-sections ○ Broken sections ○ Revolved sections |
| 5. Identify systems of measurements used on drawings | <ul style="list-style-type: none"> • SI metric units of measurement • Imperial system of measurement • Dual dimensioning • Position method • Bracket method • Conversion chart method |



6. Describe methods of dimensioning
 - Types of dimensions
 - Rules for placing dimensions
 - Dimensioning curved surfaces
 - Angular dimensioning
 - Tolerance dimensions
 - Dimensioning external chamfers and bevels
7. Sketch isometric drawings of basic objects
 - Simple rectangular objects
 - Figures using isometric lines
 - Objects with circular features
8. Sketch a dimensioned drawing of a simple object
 - Dimensioned drawing

Achievement Criteria

- Performance The learner will be evaluated on the ability to reproduce drawings with proper dimensioned parts made to scale.
- Conditions As part of a practical shop project, given the required tools and materials.
- Criteria *Completed within specifications, safety standards and time frames acceptable to industry.*



Line (GAC): I **Welding Drawings, Layout and Fabrication**

Competency: I4 **Perform mathematical calculations**

Objectives

To be competent in this area, the individual must be able to:

- Perform mathematical calculations involving angles, triangles and geometric construction.

LEARNING TASKS

1. Solve problems involving angles, triangles and geometric construction

CONTENT

- Basic terms
- Lines and points
- Angles and angle terms
- Basic theorems
- Apply the principles of angles
- Read protractor
- Calculate angles
- Right angle triangles
- Apply geometric constructions
- Exponents



Line (GAC): I **Welding Drawings, Layout and Fabrication**
Competency: I5 **Interpret and apply mechanical drawings and layout components**

Objectives

To be competent in this area, the individual must be able to:

- Source required information and materials.
- Prepare work area and layout materials.

LEARNING TASKS

CONTENT

- | | |
|--|---|
| <ol style="list-style-type: none"> 1. Source required information for selecting materials and equipment
 2. Describe work area requirements
 3. Plan sequence of operation
 4. Gather work materials and equipment
 5. Develop templates and transfer drawings to materials | <ul style="list-style-type: none"> • Material information sources <ul style="list-style-type: none"> ○ Location of information ○ Identify unique or special information ○ Type of materials ○ Material selection • Documentation and markings <ul style="list-style-type: none"> ○ Mill test reports ○ Traceability methods ○ Traceability requirements • Equipment information sources <ul style="list-style-type: none"> ○ Equipment selection
 • Good housekeeping practices • Access and egress • Material and equipment • Identify safety hazards
 • Assembly requirements • Codes • Weld procedure specifications (WPS) • Final product • Welding sequence • Possible distortion • Organize sequence of work • Visualize final components
 • Work plan • Finished component • Assembly of requirements
 • Construct template <ul style="list-style-type: none"> ○ Template materials ○ Measuring tools ○ Conform to dimensional tolerances • Transfer methods <ul style="list-style-type: none"> ○ Layout tools • Checking layout |
|--|---|



6. Select cutting equipment and cut materials to dimensions
 - Cutting equipment
 - Materials
 - Tolerances
 - Cutting sequence

7. Identify preparation and marking requirements for specialty processes
 - Galvanizing
 - Heat treatment
 - Paint and/or finishing
 - Anodizing

8. Describe the preparation of materials for assembly
 - Grinding of materials
 - Type of base metal
 - Abrasive selection
 - Application of identification markings
 - Paint mark
 - Stamp



Line (GAC): I **Welding Drawings, Layout and Fabrication**
Competency: I6 **Fabricate weldments**

Objectives

To be competent in this area, the individual must be able to:

- Fabricate weldments using selected processes and materials.

LEARNING TASKS

CONTENT

- | | |
|---------------------------------------|---|
| 1. Fit and tack structural components | <ul style="list-style-type: none"> • Select fitting equipment <ul style="list-style-type: none"> ○ Dogs and wedges ○ Clamps ○ Jigs and fixtures ○ Hydraulic porta-power ○ Hand tools • Welding process and consumables • Organize work in sequential order • Fitting <ul style="list-style-type: none"> ○ Techniques ○ Equipment ○ Distortion control ○ Specifications |
| 2. Weld weldments | <ul style="list-style-type: none"> • Preheating procedures • Welding procedures |
| 3. Finish final product | <ul style="list-style-type: none"> • Conforms to dimensions • Conforms to specifications |

Achievement Criteria

- Performance** The learner will demonstrate the ability to fabricate weldments.
- Conditions** Given a practical project using a selected process and materials.
A minimum of two shop projects is recommended.
- Criteria** *Completed within specifications, safety standards and time frames acceptable to industry.*



Line (GAC): I **Welding Drawings Layout and Fabrication**
Competency: I7 **Costing and estimating**

Objectives

To be competent in this area, the individual must be able to:

- Identify project costs.
- Calculate project cost for simple fabrication.

LEARNING TASKS

CONTENT

- | | |
|---|--|
| <ol style="list-style-type: none"> 1. Identify project costs
 2. Calculate project cost for simple fabrication | <ul style="list-style-type: none"> • Materials <ul style="list-style-type: none"> ○ Weight ○ Wastage • Labour • Consumables • Transportation <ul style="list-style-type: none"> ○ Shipping ○ Material handling • Lead time
 • Weight • Estimate labour and consumables |
|---|--|

Achievement Criteria

Performance The learner will be evaluated on the ability to cost a simple fabrication project consisting of 3 structural columns complete with base plates.

Conditions Given project specifications and fixed costs.

Criteria *Completed within specifications, safety standards and time frames acceptable to industry.*



Section 4

ASSESSMENT GUIDELINES



Assessment Guidelines

Foundation Grading Sheet: Subject Competency and Weightings

PROGRAM: IN-SCHOOL TRAINING:		WELDER FOUNDATION	
LINE	SUBJECT COMPETENCIES	THEORY WEIGHTING	PRACTICAL WEIGHTING
A	Occupational Skills	17%	8%
B	Cutting and Gouging Processes	10%	5%
C	Fusion and Braze Welding (TB) Using the Oxy-Fuel (OFW) Process	5%	3%
D	Shielded Metal Arc Welding (SMAW)	25%	37%
E	Semi-Automatic and Automatic Welding	25%	35%
F	Gas Tungsten Arc Welding (GTAW)	3%	4%
H	Basic Metallurgy	5%	2%
I	Welding Drawings, Layout and Fabrication	10%	6%
	Total	100%	100%
In-school theory / practical subject competency weighting		20%	80%
Final in-school percentage score		IN-SCHOOL %	

In-school Percentage Score Combined theory and practical subject competency multiplied by	80%
Standard Level Exam Percentage Score The exam score is multiplied by	20%
Final Percentage Score	FINAL%



Section 5

TRAINING PROVIDER STANDARDS



Facility Requirements

Classroom Area

All levels

- Comfortable seating and tables suitable for training, teaching, lecturing
- Compliance with all local and national fire code and occupational safety requirements
- Lighting controls to allow easy visibility of projection screen while also allowing students to take notes
- Windows must have shades or blinds to adjust sunlight
- Heating/Air conditioning for comfort all year round
- In-room temperature regulation to ensure comfortable room temperature
- In-room ventilation sufficient to control training room temperature
- Acoustics in the room must allow audibility of the Instructor
- White marking board with pens and eraser (optional: flipchart in similar size)
- Projection screen or projection area at front of classroom
- Overhead projector and/or multi-media projector

Shop Area (fixed properties)

- One welding booth per student (minimum booth size must be 6' x 6') fully equipped with:
 - Welding table (minimum recommended size 18" x 20")
 - Industrial grade multi-process welding power source or equipment suitable for all Foundation required welding processes
 - One height adjustable positioning arm
 - One height adjustable positioning arm for pipe
 - One 115 volt receptacle or pneumatic air supply for grinders
 - Ventilation as per WorkSafeBC standards
 - Task lighting
 - Suitable demonstration area of approximately 7' x 14'
 - Aisles size must be a minimum of 6' wide
 - The grinding and test coupon preparation area must be a minimum 300 square feet
 - Material storage area (including a separate, secured cylinder storage area)
 - Ceiling shall be a minimum height of 16' or as varied by good engineering practices and code

Lab Requirements

- N/A

Student Facilities

- Adequate lunch room as per WorkSafeBC requirements
- Adequate washroom facilities as per WorkSafeBC requirements
- Personal storage lockers

Instructor's Office Space

- As required



Tools and Equipment

Shop Equipment

- One floor model drill press, 1/2 hp minimum, 1/2" x 8"
- One 3' x 6' work bench with two vices
- One pedestal grinder, 12" x 2" stone
- One pedestal belt sander with a minimum 3" belt
- One floor model vertical band saw
- One horizontal band saw
- One abrasive chop saw
- Two track cutters
- Four 7" grinders (electric or pneumatic) for general shop use
- Electrode stabilizing oven (minimum 250 lbs)
- One semi-automatic or automatic submerged arc welder
- One guided bend test jig as per CSA W47.1 dimensional specifications
- One 5" grinders per student (one grinding, one bead brush)

Hoisting, Rigging and Lifting Equipment

- One ton overhead jib crane or overhead crane
- Overhead hoist
- Rigging hardware - shackles, swivels, eyebolts, turn buckles, snatch blocks, etc.
- Plate clamps
- Cable clamps
- Chain, wire rope and synthetic slings
- Chains
- Chain fall
- Rope
- Slings
- Come-alongs (chain and cable)
- Connectors
- Tirfor jacks
- Chain block hoist
- Chokers
- Forklift
- Portable boom
- Spreader bars
- Stands
- Supports
- Tuggers



Optional Equipment

- One 1/4" x 4' hydraulic shear
- One iron worker
- One press brake (minimum 4' x 12 gauge mechanical pan brake)

Basic Tools and Equipment

- Adjustable wrenches (various sizes)
- Allen wrenches (metric and imperial)
- Ammeter
- Bench vise
- Broom
- Brushes (various bristle brushes for cleaning and scrubbing)
- "C" clamps
- Center head
- Centering pins
- Chain hoists
- Chalk line
- Chokers
- Cold chisels (various sizes)
- Combination wrenches (metric and imperial)
- Come-alongs
- Contour marker
- Cylinder carts
- Cylinder cradles
- Dollies
- Electric cords
- Files (flat, half-round, rat-tail, bastard)
- Flange pins
- Flashlight
- Friction lighter
- Funnels
- Hack saw
- Hammers (chipping, ball peen, claw, sledge, various sizes)
- Hand shears
- Jacks
- Knives
- Ladders
- Magnets
- Metal markers
- Mop
- Oil can
- Pails (plastic and metal)
- Paint brushes
- Pipe cutters
- Pipe stands
- Pipe wrenches
- Pliers (needle nose, slip joint)
- Positioners
- Pry bars
- Punches
- Rollers
- Scaffolding (safety)
- Scrapers (various sizes)
- Screwdrivers (flat, Phillips, Robertson, various sizes)
- Shovels (flat mouthed)
- Slings
- Snips (heavy duty sheet metal cutting)
- Soapstone markers
- Socket sets (metric and imperial)
- Soldering iron
- Stamping tools
- Temperature sticks
- Tip cleaners
- Tool boxes
- Vice grips
- Vices (chain vice, pipe vice)
- Water hose
- Wrap arounds
- Wire brush
- Wire cutter
- Wrench sets (open and closed ends, both metric and imperial)



Measuring Tools

- Calculator
- Calipers
- Depth gauge
- Feeler gauges
- Fillet gauges
- Laser level
- Torpedo level
- Micrometer
- Plumb bob
- Protractor
- Scribes
- Spirit level
- Squares
- Stop watch
- Straight edges
- Tape measure
- Tri squares
- Vernier calipers
- Welding gauges

Testing Equipment

- Adapter fittings
- Ammeter
- Calibrating gauges
- Infrared pyrometer
- Pressure difference gauges
- Pressure gauge kit
- Temperature gauges
- Temperature sticks

Safety Equipment

- Air hoods
- Aprons
- Body harness
- Boots
- Coveralls
- Ear-plugs and muffs
- Eye wash station
- Face shields
- Fire blankets
- Fire extinguishers
- Fire hoses
- Gloves
- Goggles
- Masks (particle, vapour)
- Respirators
- Safety glasses
- Safety helmet
- Welding shield



Power Tools and Equipment

- Air hose and nozzle
- Air monitoring device
- Arc welder
- Oxy-fuel cutting equipment
- Band saw
- Buffers
- Chop saw (cut-off saw)
- Circular saw
- Coil heating equipment
- Compressors
- Cranes (overhead, gantry-type, monorail, boom)
- Drills (portable, magnetic base, drill press)
- Electric drills
- Electronic measuring device (hand-held “electronic tape measure” type)
- Feeders-wire
- Fork lifts
- Gas detector
- Grinders (wire brush, angle grinders)
- Guns-welding
- Hammer drill
- Hand-held and stationary radios
- Headphones
- Heated hoppers
- Heaters (electric, natural gas, oil, propane)
- Heating torch
- Hydraulic press brake
- Hydraulic shear
- Hydrostatic equipment
- Impact wrenches (electric or pneumatic)
- Nibblers
- Ovens
- Oxyacetylene brazing torch
- Oxyacetylene cutting torch
- Pipe-bevelling machine
- Pipe cutters
- Plasma console
- Pneumatic equipment
- Power hack saw
- Power vice
- Propane torch
- Reamer (hand held or mounted on power threader)
- Reciprocating saw
- Routers
- Sand-blast equipment
- Sanders
- Scissor lift
- Testing pump
- Torches
- Vacuum (wet/dry)
- Winches
- Wire wheel (body grinder or angle grinder with wire brush)

Resource Material

- Code books
- Drawings
- Engineering specifications
- Job schedules
- Manufacturers’ specifications, manuals and charts
- Material Safety Data Sheets
- Packing slips
- Pamphlets
- Prints
- Regulatory information
- Safety manuals
- Service bulletins
- Shop manuals
- Specifications
- Waybills
- Written informational or instructional material



Reference Materials

THIS SECTION IS CURRENTLY UNDER REVIEW, PLEASE SEE YOUR TRAINING PROVIDER FOR A LIST OF REQUIRED MATERIALS

Required Reference Materials

Foundation, Level 1, 2, 3 and Endorsement

- **WELDER TRAINING PROGRAM LEVEL C PACKAGE** (CPUB230M) (7960000058) ISBN 0-7719-1783-X

This package contains the following modules:

- P01 Introduction and Program Orientation (MN1807) ([7960002678](#))
- P02 Oxy-fuel Cutting (MN1808) ([7960002679](#))
- P03 Gas Welding and Braze Welding (MN1809) ([7960002680](#))
- P04 Shielded Metal Arc Welding (SMAW I) (MN1810) ([7960002681](#))
- P05 Air Carbon Arc Gouging (MN1811) ([7960002682](#))
- P06 Gas Metal Arc Welding (GMAW I) & Flux Cored Arc Welding (FCAW I) (MN1812)([7960002683](#))
- RK01 Material Handling (MN1813) ([7960002684](#))
- RK02A Blueprint Reading I (MN1814) ([7960002685](#))
- RK02B Mathematics (MN1815) ([7960002686](#))
- RK03 Welding Metallurgy I (MN1816) ([7960002687](#))

Foundation, Level 2, 3 and Endorsement

WELDER TRAINING PROGRAM LEVEL B

- P07 Shielded Metal Arc Welding (SMAW II)
Goal/Competency P07-P01 to 02 (MN1927)(7850002773) ISBN 0-7719-1670-1
- P07 Shielded Metal Arc Welding (SMAW II)
Goal/Competency P07-P01 to 02 (MN1927) (7850002591) ISBN 0-7719-1670-1
- P08 Gas Metal Arc Welding (GMAW II)
Goal/Competency P08-01 to 05 (MN1927) (7960002787)..... ISBN 0-7719-1671-X
- P09 Flux Cored Arc Welding (FCAW II)
Goal/Competency P09-01 to 04 (MN1929) (7960002788)..... ISBN 0-7719-1672-8
- P10 Gas Tungsten Arc Welding (GTAW I)
Goal/Competency P10-01 to 08 (MN1930) (7960002789)..... ISBN 0-7719-1673-6
- RK04 Welding Quality Control and Inspection Procedures
Goal/Competency RK04 (MN1931) (7960002790) ISBN 0-7719-1674-4
- RK05 Welding Quality Codes, Standards and Specifications
Goal/Competency RK (MN1932) (7960002791) ISBN 0-7719-1675-2
- RK06 Blueprint Reading II
Goal/Competency RK06-01 to 02 Perform Basic Pipe (MN1933) (7960002792) ISBN 0-7719-1676-0
- RK07 Welding Metallurgy II
Goal/Competency RK07-01 to 03 (MN1934) (7960002793)..... ISBN 0-7719-1676-0



Recommended Resources

Foundation, Level 1, 2, 3 and Endorsement

- Welding Principles and Applications, Fifth edition, by Larry Jeffus
Delmar Learning ISBN 1-4018-1046-2
- GMAW-P: Pulsed Spray Transfer
Miller Electric Mfg. Co ©1994, Revised 11/95
- Procedure Handbook of Arc Welding Design and Practics
Lincoln Electric Company
- Pipefitters and Welder’s Pocket Manual, all new 2nd edition
Audel ISBN 0-7645-4205-2 LB
- The Procedure Handbook of Arc Welding, 14th edition
The James F. Lincoln Welding Foundation
- Modern Welding, 10th edition, by Andrew Daniel Althouse
Goodheart-Willcox Company ISBN 0-87006-210-7
- Alberta Individual Learning Modules
Available through Queens Printer/Crown Publications ISBN not available
- Welding Skills, 5th edition, by B. J. Moniz
American Technical Publishers..... ISBN 978-0-8269-3084-2



Foundation, Level 2, 3 and Endorsement

- Measurement and Calculations for the Trades
Sue Grecki ISBN 0-9685027-9-2
- Formulas at Work: Tradesworkers on the Job
Sue Grecki ISBN 978-0-9739-6-1
- ASME Boiler and Pressure Vessel Code – Section IX
- ASME Power Piping (B31.1) Process Piping (B31.3)
- CSA Standards W59, W47.1, Z662
- Metal Trades Training Manual (Steel Fabrication)
IPT Publishing & Training LTD.
- Pipe Trades Training Manual (Pipefitting)
IPT Publishing & Training LTD.
- Safety First Training Manual
IPT Publishing & Training Ltd.

Websites

For all levels

- Lincoln Electric: www.lincolnelectric.com
- Hobart Welders: www.hobartwelders.com
- Miller Welding Equipment: www.millerwelds.com
- WorkSafeBC – publications: www.worksafebc.com/publications/default.asp

Foundation, Level 2, 3 and Endorsement

- Queens Printers: <http://www.publications.gov.bc.ca>
- Canadian Welding Bureau (CWB) Group: <http://www.cwbgroup.org/>
- American Welding Society (AWS): <http://www.aws.org/w/a/>
- Skill Plan: <http://www.skillplan.ca>
- IPT List of Publications: <http://www.iptbooks.com/>

NOTE:
This list of Reference Materials is for training providers. Apprentices should contact their preferred training provider for a list of recommended or required texts for this program.



Instructor Requirements

Occupation Qualification

The instructor must possess for all levels:

- Welder – Certificate of Qualification with Interprovincial Red Seal endorsement
- BC PWP7 and PWP10 pressure tickets

Work Experience

- A minimum of 5 years' experience working in the industry as a journeyperson
- Must have diverse industry experience including code work such as shop fabrication, heavy construction and maintenance/repair (ASME or CSA W59)

Instructional Experience and Education

It is preferred that the instructor also possesses one of the following:

- Instructors Certificate (minimum 30 hr course)
- Instructor's Diploma or be registered in an Instructor's Diploma Program to be completed within a 5 year period;
OR
- Bachelors or Masters degree in Education



Appendices



Appendix A: Previous Contributors

Welder Program Review and Revision 2009 – 2010:

In 2009 – 2010, a Program Review Committee was established to oversee and advise on the review of the Welding Training Program. The PRC was made up of the following members:

- Dennis Brode, The Gisborne Group
- Tim Cross, Fleet Maintenance Facility Cape Breton
- Jerry Dardengo, WMG Victoria Shipyards
- Kerry Jothen, Human Capital Strategies, Chair
- Bernie Kragt, Arc Right Fabrication Ltd.
- Jeff Lekstrom, Northern Lights College
- Al Philips, Piping Industry Apprenticeship Board (PIAB) Trade School
- Jim McCarthy, United Steel Workers
- Ken Pearce, Canadian Welding Bureau
- Mike Parson, EnCana Corporation
- Rob Scales, Industry Training Authority
- Brian Shale, Tolko Industries Ltd.
- Gene von Matt, Teck Coal Limited, Elkview Operations

In addition, consultations were held with bodies representing the training providers:

- Trades Training Consortium
- Welding Articulation Committee (WAC)
- Presidents' Council

A complete list of the regional consultation session participants appears in Appendix 2 of the B.C. Welding Review Final Report (July 2010).

Initial Welder Program Outline Development:

Representatives from industry, labour and training providers were included in the makeup of the project committees. Members of the primary committees were selected with consideration to capturing representation from across the province, as well as representation of large and small companies.

Project Steering Committee (2008) members included:

- Sheldon Frank, Chair, Welding Articulation Committee; Instructor, University College of the Fraser Valley
- Jim Carson, Instructor, University College of the Fraser Valley
- Ralph Finch, Dean of Trades, Thompson Rivers University
- Les Wiebe, Instructor, Thompson Rivers University
- Lindsay Langill, Director, Industry Training Authority
- Jeff Lekstrom, Dean of Trades and Apprenticeship Training, Northern Lights College; System Liaison Person for the Welding Articulation Committee
- Peter Haigh, Instructor, Northwest Community College
- Curt Cain, Director, Resource Training Organization ex officio



- Raili Sharron McIvor, Articulation Coordinator, B.C. Council on Admissions and Transfer
- Sherry Brown, Director, Queen's Printer Publication Services
- Graham Duncan, Director, Open School BC, Queen's Printer
- Eleanor Liddy, Manager of Content, Open School BC, Queen's Printer
- Solvig Norman, Senior Project Manager, Open School BC, Queen's Printer
- Adrian Hill, Project Manager, Open School BC, Queen's Printer
- Kai Robinson, Business Project Coordinator, Open School BC, Queen's Printer

Standards Review Committee (2008) members included:

- Ian MacDonald, Highland Valley Copper
- Stan Boehm, SS Stainless Steel Inc.
- Stan McArthur, Catalyst Paper (Campbell River)
- Tim Cross, FMF Cape Breton
- Greg Burkett, Okanagan College
- Al Wood, BCIT
- Mervyn Kube, PIAB/UA Trade School
- Dan Burroughs, Sheet Metal Workers' Local 280
- Ron McKeown, Kwantlen College Faculty Association
- Al Constable, ILWU Local 50

Project Review Committee members included:

- Lindsay Langill, ITA
- Brad Smith, Catalyst Paper (Campbell River)
- Judy Kujundzic, Victoria Shipyards
- Sheldon Frank, University College of the Fraser Valley
- Al Phillips, PIAB/UA Trade School
- Ed Ferrero, Technical Safety BC
- Ken Bauder, ILWU Canada