

STATE OF FLORIDA DEPARTMENT OF TRANSPORTATION  
**WELDING PROCEDURE SPECIFICATION (WPS)**

AWS D1.1 WPS  
 Form # 675-070-05  
 April 2019

**(D1.1) PREQUALIFIED  QUALIFIED BY TESTING**

Contractor/Organization:					Identification #:					
Welding Process(es):					Revision:		Date:		By:	
Supporting: PQR No.(s):					FWST No.(s):			Authorized By:		Date:
<b>JOINT DESIGN USED</b>					Type:	Manual <input type="checkbox"/>	Mechanized <input type="checkbox"/>	Semiautomatic <input type="checkbox"/>	Automatic <input type="checkbox"/>	
Groove Type:					Fillet: <input type="checkbox"/>					
Backing: Yes <input type="checkbox"/> No <input type="checkbox"/>					<b>ELECTRICAL CHARACTERISTICS</b>					
Backing Mat'l:					Transfer Mode (GMAW): Short-Circuiting <input type="checkbox"/>					
Root Opening:					Globular <input type="checkbox"/> Spray <input type="checkbox"/>					
Groove Angle:					Radius (J-U):					
Backgouging: Yes <input type="checkbox"/> No <input type="checkbox"/>					Method:					
Root Treatment:					Power Source: CC <input type="checkbox"/> CV <input type="checkbox"/>					
<b>POSITION</b>					Other:					
Position of Groove:					Tungsten Electrode (GTAW):					
Vertical Progression: Up <input type="checkbox"/> Down <input type="checkbox"/>					Size:		Type:			
<b>BASE METALS</b>					<b>TECHNIQUE</b>					
Material Spec:					Stringer or Weave Bead:					
Type or Grade:					Multi-Pass or Single Pass (per side):					
Thickness: Groove:					Number of Electrodes:					
Diameter (Pipe):					Electrode Spacing: Longitudinal:					
<b>FILLER METALS</b>					Lateral:		Angle:			
AWS Specification:					Electrical Stick Out:					
AWS Classification:					Peening:					
Mfg. Trade Name:					Interpass Cleaning:					
<b>SHIELDING</b>					<b>PREHEAT AND INTERPASS TEMPERATURE CHART</b>					
Flux:					Base Metal Thickness Range		Min Preheat & Interpass (°F)		Max Preheat & Interpass (°F)	
Electrode Flux Class:										
Gas:										
Flow Rate:										
<b>POSTWELD HEAT TREATMENT</b>										
Temp:										
<b>WELDING PROCESS</b>					<b>FABRICATOR'S CWI DIGITAL SIGNATURE</b>					
Pass or Weld Layer(s)	Filler Metal Diam.	Current	Volts	Travel Speed IPM	AWS CWI #:		CWI Exp. Date:			
					<b>UPLOAD FDOT CONSULTANT STAMP</b>					
Joint Designation:					<b>UPLOAD JOINT DETAILS</b>					
					Date:					
					Notes:					
					<b>UPLOAD FDOT STAMP</b>					
					Date:					
Comments:										

**E-Mail the completed digital form to [SM-StructuresCI@dot.state.fl.us](mailto:SM-StructuresCI@dot.state.fl.us), FDOT State Materials Office**