

STATE OF FLORIDA DEPARTMENT OF TRANSPORTATION
PROCEDURE QUALIFICATION RECORD (PQR)

AWS D1.2 - ALUMINUM

FABRICATOR CONTACT INFORMATION

Facility Name:		Prepared By:	
Facility Location:		Welder's Name:	
PQR #:		PQR Date:	Weld Date:
Structural Class & Type:	Type I: <input type="checkbox"/>	Type II: <input type="checkbox"/>	PQR Type:
	Non-Tubular: <input type="checkbox"/>	Tubular: <input type="checkbox"/>	Groove: <input type="checkbox"/>
Process(es):	GMAW: Transfer Mode: <input type="checkbox"/>		Fillet: Option 1: <input type="checkbox"/>
	PAW-VP: <input type="checkbox"/> Position:		Option 2: <input type="checkbox"/>
Initial Cleaning Oxide:		Direction of Welding:	Forehand: <input type="checkbox"/> Backhand: <input type="checkbox"/>
Initial Dirt & Oil Cleaning:		Vertical Upward: <input type="checkbox"/>	Vertical Downward: <input type="checkbox"/>
Interpass Cleaning:		AWS Classification:	
Dye Penetrant Removal:		F-Number:	
Stringer: _____ Weave: _____		Shielding Gas:	
Bead Welding Current:		Flow Rate: (chf): _____ Dew Point (°F): _____	
Type: Polarity: _____ Pulsed: _____		Preheat Temp. (°F): _____	
M Number: _____ to _____		Interpass Temp (°F): Min: _____ Max: _____	
Alloy & Temper: _____ to _____		Postheat Treatment? Yes: <input type="checkbox"/> No: <input type="checkbox"/>	
Base Metal Thickness: _____ to _____		IF YES Describe:	
Backing/Type Alloy:		Original Temper: _____ Final Temper: _____	
Temp: _____ Time: _____ Quench: _____		Temp: _____ Time: _____ Quench: _____	

***Include Certified Copies of Mill Test Reports**

Weld Size (in)	Pass No(s)	Electrode Size (in)	Welding Process Variable		Travel Speed IPM
			AMPS/WFS**	VOLTS	

** wire feed speed may be used along with amperage (include chart)

PHYSICAL AND NONDESTRUCTIVE TEST RESULTS: (Complete Below and Include Laboratory Reports)

Tests for Aluminum Welds	Test Results					
Visual (Accept/Reject):	Weld Size:		Contour:			
Reduced/Full Section Tension (PSI)	1.	2.				
Root Bend (Accept/Reject):	1.	2.				
Face Bend (Accept/Reject):	1.	2.				
Sind Bend (Accept/Reject):	1.	2.			3.	4.
Nick-Break (Castings) (Accept/Reject):	1.	2.				
Macro Weld Size (PJP Groove/Fillet):	1.	2.				
Fracture (Accept/Reject) (Fillet):	1.	2.	3.	4.		

Joint Designation:	UPLOAD JOINT DETAILS

Comments:

STATE OF FLORIDA DEPARTMENT OF TRANSPORTATION
PROCEDURE QUALIFICATION RECORD (PQR)

AWS D1.2 - ALUMINUM

We certify by our digital signatures below that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of the most current AWS D 1.2, <i>Structural Welding Code – Aluminum</i> .			
		Fabricator's AWS CWI #:	CWI Exp. Date:
Fabrication Facility Name		Date Signed	
		Inspection Firm's CWI #:	CWI Exp. Date:
Commercial Inspection Firm Name (Welding Witness)		Date Signed	
E-Mail the completed digital form to SM-StructuresCI@dot.state.fl.us, FDOT State Materials Office			