

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

AWS D1.2 WPS  
 Form # 675-070-06  
 April 2019

**(D1.2 ALUMINUM) QUALIFIED BY TESTING**

Contractor/Organization:					<b>WELDING PROCEDURE</b>		
<b>BACKING</b>					Specification No:	Date:	By:
Type:	Permanent:		Revision:		Date:	By:	
Removed:	Other:		Authorized By:		Date:		
<b>WELDING PROCESS(ES)</b>					Supporting PQR No(s):		
Process:	*Type:		<b>POSITION</b>				
Process:	*Type:		Position of Groove:	Fillet:			
Electrode: (GTAW):	Welding Progression (Forehand/Backhand):				Vertical Welding (Upward/Downward):		
*Manual, Automatic, Polarity Pulsed, etc.					Vertical Welding (Upward/Downward):		
<b>BASE METALS</b>					<b>TECHNIQUE</b>		
M No.:	Thickness:	to		Stringer or Weave Bead:			
Alloy & Temper:					Orifice or Gas Cup Size:		
<b>FILLER METAL</b>					Oscillation:		
F-No.:	AWS No. (Class):		Contact Tube to Work Distance:				
Size of Electrode:					Single Pass or Multipass (per side):		
Type of Electrode:					Tungsten Extension:		
Mfg. Trade Name:					Method of Backgouging:		
<b>SHIELDING GAS</b>					Other:		
Shielding Gas(es):					<b>POSTWELD HEAT TREATMENT</b>		
Percent Composition:					Original Temper:		
Flow Rate:					Final Temper:		
Other:					Temp:	Time:	
<b>CLEANING</b>					Quench:		
Initial Cleaning Oxide:					<b>PREHEAT</b>		
Initial Cleaning Oil & Dirt:					Preheat Temperature:		
Interpass Cleaning:					Interpass Temperature:		
<b>WELDING PROCESS</b>					<b>FABRICATOR'S CWI DIGITAL SIGNATURE</b>		
Pass No.	Welding Process	Current	Volts	Travel Speed IPM	AWS CWI #:	CWI Exp. Date:	
<b>UPLOAD JOINT GROOVE DESIGN SKETCH</b>					<b>UPLOAD WELDING SEQUENCE SKETCH</b>		
Joint Designation:			Joint Designation:				
Date:					Date:		
Notes:					Notes:		
<b>UPLOAD FDOT CONSULTANT STAMP</b>					<b>UPLOAD FDOT STAMP</b>		
Date:					Date:		
Comments:							
E-Mail the completed digital form to <a href="mailto:SM-StructuresCI@dot.state.fl.us">SM-StructuresCI@dot.state.fl.us</a> , FDOT State Materials Office							