STATE OF FLORIDA DEPARTMENT OF TRANSPORTATION

WELDING PROCEDURE SPECIFICATION (WPS)

AWS D1.3 PQR
Form # 675-070-10
April 2019

PREQUALIFIED ☐ QUALIFIED BY TESTING ☐

AWS D1.3 Sheet Steel

Contractor/Organization:	Identification:
Welding Process(es):	Revision: Date: By:
Type: Manual ☐ Mechanized ☐ Tandem ☐ Semiautomatic ☐ Automatic ☐ Parallel ☐	Supporting PQR No. (s):
JOINT DESIGN USED	**POSITION**
Single ☐ Double Weld ☐	Position of Groove: Fillet:
Backing: Yes ☐ No ☐	Vertical Progression: Up ☐ Down ☐
Backing Mat'l:	**BASE METALS**
Groove Welded From: One Side ☐ Both Sides ☐	Material Spec:
GAS	Type or Grade: Support Steel:
Shielding Gas: Percent Mixture:	Thickness Range: Sheet Steel: Support Steel:
Flow Rate:	Thickness: Base Metal Prep:
Backing Gas: Yes ☐ No ☐	**COATING(S)**
FILLER METAL:	Type:
FLUX:	Thickness:
PREHEAT	**ELECTRICAL CHARACTERISTICS**
Preheat Temp Min:	Transfer Mode (GMAW): Short-Circuiting ☐ Globular ☐ Spray ☐
Preheat Temp Max:	Current: AC ☐ DCEP ☐ DCEN ☐ Pulsed ☐
	Other:
	Tungsten Electrode (GTAW) Size: Type:

WELDING PROCESS

Pass No.	Electrode Size	Welding Current		Travel Speed IPM	Melting Rate	Wire Speed Feed
		Amperes	Volts			

FABRICATOR'S CWI DIGITAL SIGNATURE

AWS CWI #: CWI Exp. Date:

Joint Designation:

JOINT DETAILS

UPLOAD FDOT CONSULTANT STAMP

Date:

Notes:

UPLOAD FDOT STAMP

Date:

Comments:

E-Mail the completed digital form to SM-StructuresCI@dot.state.fl.us, FDOT State Materials Office