

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

AWS D1.4 WPS
 Form # 675-070-12
 April 2019

PREQUALIFIED QUALIFIED BY TESTING
AWS D1.4 REINFORCING STEEL

| | | | | | | | | | |
|---|--------------------|--|-----------|---|----------------|--|--|--|--|
| Contractor/Organization: | | | | Identification: | | | | | |
| Welding Process: | | FCAW-S <input type="checkbox"/> | | FCAW-G <input type="checkbox"/> | | Revision: Date: By: | | | |
| | | GMAW <input type="checkbox"/> | | SMAW <input type="checkbox"/> | | Authorized By: Date: | | | |
| Weld Type: Groove <input type="checkbox"/> Fillet <input type="checkbox"/> | | | | Supporting PQR No. (s): | | | | | |
| JOINT TYPE | | | | ELECTRICAL CHARACTERISTICS | | | | | |
| Direct Butt <input type="checkbox"/> | | Indirect Butt <input type="checkbox"/> | | T-Joint <input type="checkbox"/> | | Current: AC <input type="checkbox"/> DCEP <input type="checkbox"/> DCEN <input type="checkbox"/> | | | |
| Position: Groove Type: | | | | Transfer Mode (GMAW): Short-Circuiting <input type="checkbox"/> | | | | | |
| Root Opening: Root Face Dimension: | | | | Globular <input type="checkbox"/> Spray <input type="checkbox"/> | | | | | |
| Groove Angle: | | | | BASE METALS | | | | | |
| Backing: Yes <input type="checkbox"/> No <input type="checkbox"/> | | | | Material Spec: | | Grade: | | | |
| Backing Type: | | | | Welded to: Material Spec: | | Grade: | | | |
| Backgouging: Yes <input type="checkbox"/> No <input type="checkbox"/> Method: | | | | Maximum Carbon Equivalent: | | | | | |
| TECHNIQUE: Stringers <input type="checkbox"/> Weave <input type="checkbox"/> | | | | Bar Size: | | Plate Thickness: | | | |
| FILLER METALS | | | | Coated Bar: Yes <input type="checkbox"/> No <input type="checkbox"/> | | | | | |
| AWS Specification: | | | | Type of Coating: | | | | | |
| AWS Classification: | | | | SHIELDING | | | | | |
| PREHEAT/INTERPASS | | | | Gas: Single <input type="checkbox"/> Mixture <input type="checkbox"/> | | | | | |
| Preheat/Interpass Temp. Min.: | | | | Composition: | | Flow Rate: | | | |
| Interpass Temp. Max.: | | | | | | | | | |
| WELDING PROCESS | | | | | | FABRICATOR'S CWI DIGITAL SIGNATURE | | | |
| Pass Nos. | Electrode Diameter | Current | | | | Travel Speed IPM | AWS CWI #: CWI Exp. Date: | | |
| | | Type | Amp Range | Volt Range | Elec. Stickout | | | | |
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| Joint Designation: | | | | | | UPLOAD FDOT CONSULTANT STAMP | | | |
| JOINT DETAILS | | | | | | | | | |
| | | | | | | Date: | | | |
| | | | | | | Notes: | | | |
| | | | | | | UPLOAD FDOT STAMP | | | |
| | | | | | | Date: | | | |
| Comments: | | | | | | | | | |
| E-Mail the completed digital form to SM-StructuresCI@dot.state.fl.us , FDOT State Materials Office | | | | | | | | | |