

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

AWS D1.5

FABRICATOR CONTACT INFORMATION

Facility Name: _____

Facility Location: _____

FCM: Expiration Date (5 Years for Fracture Critical): _____ Non FCM:

PQR #: _____ PQR Date: _____ Weld Date: _____

Prepared By: _____

Qualified Per: 5.12.1 5.12.2 5.12.4 Welder's Name: _____

Process: _____ AWS Electrode Specification: _____

Position: 1G 2G 3G 4G AWS Electrode Classification: _____

Electrodes (S) Manufacturer: _____ Electrode Brand Name (Include CoC): _____

Electrode Extension: _____ SAW Flux Type: Active: Neutral: Alloy:

Flux Manufacturer: _____ Flux Brand Name: _____

Electrode	Dia. (Inch)	Current (Amps)	WFS* IPM	Voltage (Volts)	Current & Polarity	Travel Speed IPM	Electrode Angle (Multi-Elec. SAW)
1							
2							
3							

*wire feed may be used in lieu of current when a correlation curve is provided for the same electrode diameter and electrode extension.

Multiple Electrode Arc Spacing (SAW): Longitudinal: _____ Lateral: _____

Calculated Heat Input (KJ/In): _____

AWS Joint Detail Used: _____

Shielding Gas (Include Cert.): _____ Flow Rate (cfph): _____ Composition: _____

Dew Point (°F): _____ Gas Cup Size: _____

Base Metal Specification & Heat No. (Include MTR): _____

Base Metal: Carbon Equivalent (See 5.4.2): _____ Carbon Content: _____

Backing Metal: Carbon Equivalent (See 5.4.2): _____ Carbon Content: _____

Base Metal Thickness (In): _____ Backing Thickness (in): _____

Backing Specification & Heat No. (Include MTR): _____

Preheat Temp. (°F): _____ Interpass Temp. (°F): Min: _____ Max: _____

Pass Number	Layer	Process	Filler Metal Diam.	Current			Voltage	Travel Speed IPM	Stick Out	Temperature at Start of Pass
				Type & Polarity	Wire Feed Speed	Amp				

For multiple electrodes, list each electrode on separate line. For parallel electrodes, show "2 @ _____" under diameter. Measure preheat and interpass at mid-length of plate approximately 25 mm [1 inch] from the weld centerline.

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Joint Designation:	UPLOAD JOINT DETAILS

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

Specimen	Test Results			
All Weld Metal Tension (AWMT)	Tensile Strength (PSI):			
	Yield Strength (PSI):			
	Elongation In 2 In. (%):			
	Reduction in Area (%):			
Side Bends (Accept/Reject):	1.	2.	3.	4.
Reduced Section Tension (PSI):	Tensile Strength:	1.	Location of Break:	1.
		2.		2.
Charpy V-Notch Impact: ()			
Toughness of Weld Metal (Ft. Lbs.):	** Avg. ft.lb.:		@	°F
** Discard the Highest and Lowest Values and Average the Remaining Values				
Visual Acceptable?:	Radiographic Test Acceptable?:			(Include RT Report)
Comments:				

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 AWS D 1.5, <i>Structural Welding Code (List Code Year)</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			