

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

AWS D1.5 WPS
 Form # 675-070-02
 April 2019

PREQUALIFIED QUALIFIED BY TESTING
 AASHTO/AWS D1.5 Qualification Type 5.12.1 - 5.12.2 - 5.12.4

Contractor/Organization:				Identification:			
Welding Process(es):				Revision:		Date:	
Type: Manual <input type="checkbox"/> Mechanized <input type="checkbox"/> Tandem <input type="checkbox"/>				Authorized By:		By:	
Semiautomatic <input type="checkbox"/> Automatic <input type="checkbox"/> Parallel <input type="checkbox"/>				Supporting: PQR Nos.:		Date:	
FWST Nos.:							
JOINT DESIGN USED				POSITION			
Groove Type: Fillet: <input type="checkbox"/>				Position of Groove: Fillet:			
Backing: Yes <input type="checkbox"/> No <input type="checkbox"/>				Vertical Progression: Up <input type="checkbox"/> Down <input type="checkbox"/>			
Backing Mat'l.:				ELECTRICAL CHARACTERISTICS			
Root Opening: Root Face Dimension:				Transfer Mode (GMAW): Globular <input type="checkbox"/> Spray <input type="checkbox"/>			
Groove Angle: Radius (J-U):				Current: AC <input type="checkbox"/> DCEP <input type="checkbox"/> DCEN <input type="checkbox"/> Pulsed <input type="checkbox"/>			
Backgouging: Yes <input type="checkbox"/> No <input type="checkbox"/> Method:				Electrical Stick Out:			
Root Treatment:				Other:			
BASE METALS				TECHNIQUE			
Material Spec:				Stringer or Weave Bead:			
Type or Grade:				Multi-Pass or Single Pass (per side):			
Thickness: Groove Fillet				Number of Electrodes:			
FILLER METALS				Electrode Spacing: Longitudinal			
AWS Specification:				Lateral:		Angle:	
AWS Classification:				Interpass Cleaning:			
Mfg. Trade Name:				PREHEAT AND INTERPASS TEMPERATURE CHART			
SHIELDING				Base Metal Thickness Range		Min Preheat (°F)	
Flux: Mfg. Trade Name:				Max Preheat & Interpass (°F)			
Electrode Flux Class:							
Gas Composition:							
Flow Rate: Gas Cup Size:							
POSTWELD HEAT TREATMENT							
Temp.: Hold Time:				QUALIFIED HEAT INPUT FROM PQR			
Heating/Cooling Rate:				Max. Heat Input:		Min. Heat Input:	
WELDING PROCESS				FABRICATOR'S CWI DIGITAL SIGNATURE			
Pass or Weld Layer(s)	Filler Metal Diam.	Current		Volts	Travel Speed IPM	AWS CWI #: CWI Exp. Date:	
		<input type="checkbox"/> Amps	<input type="checkbox"/> Wire Feed Speed				
Joint Designation:				UPLOAD 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