STATE OF FLORIDA DEPARTMENT OF TRANSPORTATION

# WELDING PROCEDURE SPECIFICATION (WPS)

AWS D1.5 WPS
Form # 675-070-02
February 13, 2026

**PREQUALIFIED ☐ QUALIFIED BY TESTING ☐**
**AASHTO/AWS D1.5 Qualification Type 7.12.2 ☐ - 7.12.3 ☐ - 7.12.5 ☐**

| | |
|---|---|
| Contractor/Organization: | Identification: |
| Welding Process(es): | Revision: Date: By: |
| Type: Manual ☐ Mechanized ☐ Tandem ☐ | Authorized By: Date: |
| Semiautomatic ☐ Automatic ☐ Parallel ☐ | Supporting: PQR Nos.: FWST Nos.: |
| **JOINT DESIGN USED** | **POSITION** |
| Groove Type: Fillet: ☐ | Position of Groove: Fillet: |
| Backing: Yes ☐ No ☐ | Vertical Progression: Up ☐ Down ☐ |
| Backing Mat'l.: | **ELECTRICAL CHARACTERISTICS** |
| Root Opening: Root Face Dimension: | Transfer Mode (GMAW): Globular ☐ Spray ☐ |
| Groove Angle: Radius (J-U): | Current: AC ☐ DCEP ☐ DCEN ☐ Pulsed ☐ |
| Backgouging: Yes ☐ No ☐ 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) / Max Preheat & Interpass (°F) |
| Flux: Mfg. Trade Name: | |
| 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**

| Pass or Weld Layer(s) | Filler Metal Diam. | Current ☐Amps ☐Wire Feed Speed | Volts | Travel Speed IPM |
|---|---|---|---|---|
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**Joint Designation:**

**UPLOAD JOINT DETAILS**

Click to upload your joint detail image.

**FABRICATOR'S CWI DIGITAL SIGNATURE**

AWS CWI #: CWI Exp. Date:

Contractor's CWI Stamp - Click to Upload

**UPLOAD FDOT CONSULTANT STAMP**

FDOT Consultant CWI Stamp - Click to Upload

Date:

Notes:

**UPLOAD FDOT STAMP**

Date:

Comments:

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