

STATE OF FLORIDA DEPARTMENT OF TRANSPORTATION
FILLET WELD SOUNDNESS TEST (FWST) for Pipe

AWS D1.1 FWST for Pipe
 Form # 675-070-15
 February 13, 2026

AWS D1.1

FABRICATOR CONTACT INFORMATION

Facility Name:	
Facility Location:	

FWST No:	Date Tested:	List Code Year:
Welding Process(es):		
Supporting PQR No.(s):		
Material Spec:	Type or Grade:	

Prepared By:	Pipe Diameter(s):
T1 Thickness:	T2 Thickness:
Filler Metal Specification:	Electrode Diameter:
Filler Metal Classification:	
Shielding Gas (Composition %):	Gas Flow Rate:
Electrode Manufacturer:	Electrode Brand Name:
Flux Manufacturer:	Flux Brand Name:
Voltage:	(use production voltage of WPS to be qualified)
Amperage/WFS*:	(use production amperage/WFS* of WPS to be qualified)
Travel Speed for Single Pass:	Travel Speed for Multiple Pass:
Polarity:	
Position of Welding: <input type="checkbox"/> 1F <input type="checkbox"/> 2F <input type="checkbox"/> 2F Rotated <input type="checkbox"/> 4F <input type="checkbox"/> 5F	

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

TEST RESULTS (PER AWS D1.1 6.10.4)			
3 MACROS (1F, 2F, 2F Rotated); 4 MACROS (4F, 5F) REQUIRED			
	Maximum Size		Minimum Size
	Single Pass	Required Size	Multiple Pass
	Pass/Fail		Pass/Fail
Weld Size:	<input type="checkbox"/> Pass <input type="checkbox"/> Fail	<input type="checkbox"/> Pass <input type="checkbox"/> Fail	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Cracking:	<input type="checkbox"/> Pass <input type="checkbox"/> Fail	<input type="checkbox"/> Pass <input type="checkbox"/> Fail	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Fusion:	<input type="checkbox"/> Pass <input type="checkbox"/> Fail	<input type="checkbox"/> Pass <input type="checkbox"/> Fail	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Weld Profile per 5.23.1:	<input type="checkbox"/> Pass <input type="checkbox"/> Fail	<input type="checkbox"/> Pass <input type="checkbox"/> Fail	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Undercut > 1/32 inch:	<input type="checkbox"/> Pass <input type="checkbox"/> Fail	<input type="checkbox"/> Pass <input type="checkbox"/> Fail	<input type="checkbox"/> Pass <input type="checkbox"/> Fail

- Notes:
1. A fillet weld Macroetch test shall be made for each non-prequalified WPS and position to be used in construction
 2. AWS D1.1 Figure 10.16 for tubular shall be used

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 Qualification requirements of the most current AWS D 1.1, <i>Structural Welding Code – Steel</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