

WELDING PROCEDURE SPECIFICATION



Unique ID:
Status: **Date:** **Project No:**
File No: **Sub File No:**
Road No:
Road Info:
Contractor:

Material Specification:
Welding Process:
Manual or Machine: **Position of Welding:**
Filler Metal Specification:
Filler Metal Classification:
Flux:
Shielding Gas: **Flow Rate:**
Single or Multiple Pass: **Single or Multiple Arc:**
Welding Current: **Polarity:**
Welding Progression:
Root Treatment:
Preheat and Interpass Temp: N/A **Postheat Temp:** N/A
Heat Input: **Min:** N/A **Max:** N/A
Certified Welder Required: **Welder's SCDOT Certification No.:**
Welder's Name:

Pass No.	Electrode Size	Welding Current		Travel Speed	Joint Detail
		Amperes	Volts		
1.	<input type="text"/> / <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/> in/min	
2.	<input type="text"/> / <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/> in/min	
3.	<input type="text"/> / <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/> in/min	
4.	<input type="text"/> / <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/> in/min	
5.	<input type="text"/> / <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/> in/min	
6.	<input type="text"/> / <input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/> in/min	

This procedure may vary due to fabrication sequence, fit-up, pass size, etc, within the limitations of variables given in AWS D1.5, Section 5.

Procedure No: **Revision No:**
Contractor Foreman:
Authorized by:

Note: The Contractor shall submit a copy of this completed form to the SCDOT Resident Construction Engineer and the Research and Materials Engineer per Section 709.22A.2 of the Standard Specifications, Edition 2000 a minimum of ten (10) days prior to performing any field welding. The Department may or may not review and provide comments on the submittal. If the Department has not responded within ten (10) days of the submittal date, the Contractor may proceed with the welding.

Resident Engineer:

Signature: _____ **Date:** _____