PENNDOT	**Bureau of Construction & Materials** **Structural Materials Section**	**Production Joint Welding Procedure Specification** **Procedure No:** _____ **Date Issued:** _____ **Revision No:** _____ **Rev. Date:** _____ **D1.5-95**

1. Contractor (Fabricator)_____ Prepared by: _____
2. Non-Fracture Critical _____ Fracture Critical ✘ WPS Expiration date:_____
3. Qualified in accordance with (choose one):
   5.11 (prequalified) _____ 5.12.1_____ 5.12.2_____ 5.13 ✘
   Referenced PQR No(s). _____ _____ _____ _____
   Referenced Fillet Weld Soundness Test No(s). _____ _____ _____
4. Material specification(s) _____
5. Material Thickness(es) (range)_____
6. Welding process _____
7. Manual, machine, or semiautomatic _____
8. Position(s) of welding _____
9. Filler metal specification _____
10. Filler metal classification and brand name_____
11. Flux class & brand (also specify: active, neutral or alloy)_____
12. Shielding gas _____ Flow rate _____
13. Single or multiple pass _____
14. Single or multiple arc _____
15. Welding current _____
16. Polarity _____
17. Welding progression _____
18. Root treatment _____
19. Postheat treatment _____
20. Calculated Heat Input (KJ/In) Min _____ Max _____
21. Electrode extension (electrical stickout) _____

For PaDOT use only

Weld size (In)	Pass No(s).	Electrode Size (In)	Welding Process Variables		Travel Speed (IPM)
			AMPS/WFS*	VOLTS	

Joint Detail

Show relevant dimensions and AWS symbols

*Wire feed speed may be used along with amperage (include chart)

Preparer's Signature:_____

Additional Shop Notes:_____

_____

_____

_____

Preheat and Interpass Temperature Chart

Base metal thickness range	Minimum preheat (°F)	Max Preheat & Interpass (°F)