

ALABAMA DEPARTMENT OF TRANSPORTATION WELDING PROCEDURE SPECIFICATION

Project Number: _____ County: _____ Date: _____
 Specifications & Codes: _____
 Material Specifications: _____
 Welding Process: _____ Manual or Semi- Automatic or Automatic: _____
 Filler Metal Specification: _____ Classification: _____ Flux: _____
 Manufacturer: _____ Trade Name: _____ Ref. PQR#: _____
 Shielding Gas: _____ Flow: _____ Dew Point: _____ PQR Date: _____
 Single or Multiple Pass _____ Single or Multiple ARC: _____
 Welding Current: _____ Polarity: _____ Progression: _____
 Root Treatment: _____
 Preheat Temp: _____ Interpass: _____ Post Heat: _____
 Angle of Electrode: _____ Electrode Stickout: _____ Position of Weld: _____
 Max. Heat Input (J/in): _____ Min. Heat Input (J/in): _____

Pass Num.	Electrode Size	Welding Current		Travel Speed	Weld Size	Joint Details	
		Amperes	Volts				
						Joint Code:	WPS #:

PREHEAT	
Thickness	Temp.
Up to 3/4"	50°
Over 3/4" to 1 1/2"	70°
Over 1 1/2" to 2 1/2"	150°
Over 2 1/2"	225°

COMMENTS: _____

Shop Order #: _____
 Revision #: _____

Authorized By: _____
 Fabricator: _____