

Welding Checklist for Field Welding

Wisconsin Department of Transportation
DT2320 5/2008

Purpose: During the erection/construction stage of installing a structure where field welding is performed quality control checks shall be performed in accordance with AWS, section 6. The construction inspector shall fill out this form on all structures that have field welding on highway bridges and components, pile driving, drilling wells, railings, grid decks, high mast light poles, poles, arms, standards and bases and sign structures. Document welding activities for each structure and submit this form to the engineer for inclusion in the permanent record upon completion of welding the structure.

Structure I.D.: _____

Project: _____

Welder qualifications: Welders shall be qualified according to AWS D1.5 for Highway bridges and components, sign structures, railings, grid decks, and high mast light poles, AWS D1.1 for steel pile, cast in place concrete pile liners and drilled well casings. D1.4 for welding bar reinforcement, AWS D1.2 for aluminum welding, and AWS D1.6 for stainless steel welding.

1. The welder was qualified in accordance with the appropriate process and code? Yes or No
2. Is the welder current? A continuation record signed by the contractors inspector must signify that the welder has produced sound welding in the given process within the last 6 months. Yes or No

List qualified welders: _____

Welding Procedure Specification (WPS)

3. The welder was welding according to (check one): AWS D1.1 AWS D1.2 AWS D1.4 AWS D1.5 AWS D1.6

Note: AWS D1.1 refers to field welding of steel pile splices drilled well casings and sign structures.

AWS D1.2 refers to welding Aluminum

AWS D1.4 refers to welding bar reinforcement

AWS D1.5 refers to field welding of Highway Bridge, sign structures, railings, grid decks, & high mast light poles.

AWS D1.6 refers to welding Stainless Steel.

4. The WPS has been reviewed by central office? Yes or No (Send copies to Craig Wehrle at: craig.wehrle@dot.state.wi.us)
5. Welding was performed according to the given WPS? Yes or No
6. The electrodes were from a hermetically sealed source, dry and in good condition? (SMAW only) Yes or No
7. Rod ovens were used to store open electrode containers 24/7? (SMAW only) Yes or No
8. Preheat(s) being used met code requirements? Temperature(s) used: _____ (If required) Yes or No
9. The conditions were acceptable during the welding process? Note: No welding in water, rain or snow, high winds, and not under 0° F without a shelter Yes or No
10. The surface of steel was clean and clear of galvanizing, paint, water, oil or grease? Yes or No
11. The welder had a way to prove their amperes, and voltage was correct, i.e. calibrated gauges or a calibrated clamp meter? Yes or No
12. The general weld appearance was acceptable: (There should not be an arc strike, or excessive undercut. Is the size ok? Is the weld in an proper location?) Yes or No

If any question was answered "No" explain mitigating action taken:

Contractor Inspector Name: _____ **Date:** _____

Was the Contractor Inspector a CWI or trained personnel experienced in metal fabrication, inspection and testing that is approve by the Engineer? Yes or No (If approval is needed call Craig Wehrle @ 608 266-8487)

Note: See AWS D1.1 or D1.5 section 6 for contractor definitions and responsibilities

If you have questions concerning welding or how to fill out this form please call Craig Wehrle @ 608 266-8487 or Joel Alsum @ 608 444-3388