

## AASHTO / AWS D1.5 – FIELD WELDING PLAN

To be completed by the Contractor  
and submitted to the Engineer for approval.

Naming Convention: 0395 MDOT ID-JN YYYY-MM-DD Field Welding Plan.pdf

LOCATION		Bridge Field Services Approval Block
CONTRACTOR	JOB NUMBER	
WELDING CONTRACTOR	MDOT ID	
PREPARED BY	DATE	

### SPECIFICATIONS

The Contractor must comply with the current *AASHTO/AWS D1.5 – Bridge Welding Code*, (as modified by the current FUSP 12SP707(A) - Structural Steel and Aluminum Construction), subsection 707.03.D.8 of the MDOT Standard Specifications for Construction, and all other contract requirements.

### WELD INSPECTION AND TESTING

Test 100% of all welds in accordance with subsection 707.03.C.10 of the MDOT Standard Specifications for Construction and AWS D1.5. The testing must be performed by a Certified Welding Inspector (CWI) qualified as American Society for Nondestructive Testing (ASNT) Level II or Level III on Recommended Practice No. SNT-TC-1A. **The Contractor must submit CWI and ASNT certifications to the Engineer prior to beginning the work. Upon completion of testing submit all non-destructive test reports, CWI and ASNT certifications to the Engineer.**

### SCOPE OF WORK

### WELDER CREDENTIALS

All welders performing AASHTO/AWS D1.5 bridge welding on MDOT construction projects must be qualified through [MDOT's Welder Qualification Program](#). Welders qualified through this program will have Form 0396 – *Welder Qualification Test Report* for each welding process and position they are qualified. **The Contractor must submit all welder credentials with this form to the Engineer prior to beginning the work.**

### WELD PROCEDURE SPECIFICATIONS (WPS)

Weld Procedure Specifications (WPS) must be completed by the contractor and submitted to the Engineer for approval. **The Contractor must submit all WPS's with this form to the Engineer for approval prior to beginning the work. The Contractor may complete the WPS's included as additional pages of this form or may delete the additional pages and attach their own WPS's to page 1 of this form.**

### FORM INSTRUCTIONS

- 1) Complete page 1 of Form 0395 and all required WPS's the for project and save as an Adobe PDF file;
- 2) Attach Form 0396 – *Welder Qualification Test Report* for all welders performing the welding;
- 3) Save Form 0395 with all attachments as follows: **0395 MDOT ID-JN YYYY-MM-DD Field Welding Plan.pdf**;
- 4) Submit to the Engineer for approval.

## WELDING PROCEDURE SPECIFICATION (WPS)

To be completed by the Contractor  
and submitted to the Engineer for approval.

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LOCATION				Bridge Field Services Approval Block
WELDING CONTRACTOR		JOB NUMBER		
PROCEDURE #/REVISION #		MDOT ID		
PREPARED BY		DATE		
WELDING INFORMATION				JOINT DETAIL
MATERIAL SPECIFICATION				
WELDING PROCESS				
WELDING METHOD				
WELDING POSITION				
FILLER METAL SPECIFICATION				
FILLER METAL CLASSIFICATION				
CURRENT/POLARITY				
WELDING PROGRESSION				
ROOT TREATMENT				
PREHEAT SURFACES 3" IN EVERY DIRECTION FROM WELD				
BASE METAL THICKNESS		PREHEAT TEMPERATURE		
< 1½"		250 °F MIN		
1½" TO 2½"		300 °F MIN		
> 2½"		400 °F MIN		
INTERPASS TEMPERATURE		650 °F MAX		
WELDING PROCEDURE				WELD INSPECTION AND TESTING
PASS NO.	ELECTRODE DIAMETER	WELDING CURRENT		TRAVEL SPEED
		AMPERES	VOLTS	
<input type="checkbox"/> VISUAL TESTING – 100% <input type="checkbox"/> PENETRANT TESTING – 100% <input type="checkbox"/> MAGNETIC PARTICLE TESTING – 100% <input type="checkbox"/> ULTRASONIC TESTING – 100% <input type="checkbox"/> RADIOGRAPHIC TESTING – 100% <input type="checkbox"/> OTHER _____				

- Approved Form 0395 must be in the possession of the welder performing the work at the jobsite.
- Welding is not allowed when the ambient air temperature is below 40 °F or during periods of precipitation unless heating and housing the area has been approved by the Engineer.