NORTH CAROLINA DEPARTMENT OF TRANSPORTATION

Field Welder Agreement

Field welders who are performing work for the North Carolina Department of Transportation are required to follow the specifications and procedures as listed below:

1. Welders shall follow an approved welding procedure applicable to the joint being welded. All details stipulated with in the welding procedure shall be followed including amperes, volts, travel speed and pre-heat temperatures.
2. Surfaces to be welded and surfaces adjacent to a weld shall be free from loose or thick scale, slag, rust, moisture, grease, or other foreign material that would prevent proper welding.
3. Remove paint, galvanizing or other coatings at the location of field welds. Clean sufficiently to prevent contamination of the weld by the coating.
4. Chip the slag and wire brush after every pass, including the completed weld. Wire brush the adjacent metal after the welding is complete. Remove tightly adherent weld spatter if the area is going to be coated.
5. Electrodes must be (a) made in the USA, (b) purchased in a metal hermetically sealed container, (c) 7018 for coated steel, (d) 8018-C3 for uncoated weathering steel.
6. Once the sealed container is opened, electrodes must be stored in a holding oven at a minimum temperature of 250 degrees Fahrenheit. Electrodes that have been wet shall not be used.
7. Repair deficient welds by the following: (a) grind arc strikes that are outside of the weld zone, (b) grind excess weld metal from excessive convexity or overlap, (c) thoroughly clean and add weld metal to under-fill and under cut, (d) remove and re-weld cracks, porosity, slag inclusions and incomplete fusion, (e) clean and add additional passes to under size welds.
8. Welders must have their technician certification card and a US State issued photo ID with them any time they are welding on an NCDOT project, for verification of the technician certification.
9. When multiple welders are engaged in welding on a given project, sufficient documentation shall be maintained by all personnel to distinguish which welds were performed by each welder.
10. Contact M&T immediately if there are any concerns with material fit up or weld quality issues associated with field welding.

I understand that certification cards issued by NCDOT M&T Unit are property of the Department and may be revoked for failure to comply with any of the requirements listed above.

Signature		Date	
Printed Name			
Witnessed By		Date	

The original copy shall remain with the Materials & Tests Unit.

Revised May 5, 2022