



**NORTH CAROLINA DEPARTMENT OF TRANSPORTATION
Field Welder Agreement**

When performing work to North Carolina Department of Transportation specifications, Field Welders are required to follow proper procedures as listed below:

1. Prior to welding, thoroughly clean, remove all paint, rust and loose scale.
2. Use a heating torch to dry off moisture, acquire proper preheat and maintain proper interpass temperatures.
3. Use *only* E7018 electrodes for coated members and E8018 for non-coated weathering material to be welded.
4. Have and use a suitable portable electrode oven on site.
5. Remove all slag after welding.
6. Follow proper welding procedures as required by ANSI/AASHTO/AWS D1.5 Bridge Welding Code (Current Edition)
7. Strike arcs within the weld zone. Avoid wayward arc strikes. When they accidentally occur, grind them off appropriately.
8. Do not use shortcuts (slugging weld joints, insufficient weld size, etc.)

I understand that failure to comply is cause for immediate revocation of the Field Welder certification of qualification issued to me by the Department of Transportation and that all information contained in this document is considered "Public Information."

Signature: _____ Date: _____

Printed Name: _____

Witnessed by: _____ Date: _____

North Carolina Department of Transportation Materials & Test Unit

Original will remain with Materials and Test Unit, North Carolina Department of Transportation
Revised October 24, 2005