NORTH CAROLINA DEPARTMENT OF TRANSPORTATION
SIP WELDER CERTIFICATION TEST
WELDING PROCEDURE SPECIFICATION (WPS) AWS D1.5

Specifications & Codes: NCDOT Standard Specifications/AASHTO/AWS D1.5, Section 2, 5 and 12

Material Specifications: ASTM A-36, 3/8” THICK


Filler Metal Specification: AWS A5.1 Classification: E-7018

Manufacturer: NCDOT Approved Single or Multiple Pass Position of Weld: Horizontal

Welding Current: DC Polarity: Positive Progression: N/A

Root Treatment: N/A

Preheat Temp: 50° minimum Interpass: 450° maximum Post Heat: N/A

<table>
<thead>
<tr>
<th>Pass Num.</th>
<th>Electrode Size</th>
<th>Welding Current</th>
<th>Travel Speed</th>
<th>Joint Details</th>
</tr>
</thead>
<tbody>
<tr>
<td>All</td>
<td>1/8”</td>
<td>90-150</td>
<td>20-23</td>
<td>SEE ATTACHMENT</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>6-9 ipm</td>
<td></td>
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</tbody>
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PREHEAT

<table>
<thead>
<tr>
<th>Thickness</th>
<th>Min. Temp.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Up to 3/4”</td>
<td>50°</td>
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</tbody>
</table>

COMMENTS:

Remove all rust and mill scale within one inch of the area to be welded prior to fit-up. Remove all slag and spatter between passes. Clean the completed weld of all debris, slag and spatter.

The fillet weld size shall be as directed by the examination proctor.

WPS Description | SIP Welder Certification Test | Written By: Randy Dempsey, CWI/CWE, Transportation Technician IV

WPS #: 040209011 | Authorized By: Steve Walton, Metals Engineer

Revision #: 3 | Signature:

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SIP WELDER CERTIFICATION TEE
JOINT DETAILS

Weld Symbol definitions per AWS A2.4:2007

FILLET WELD, BOTH SIDES OF ARROW
Illustrations for SIP Welder Certification

Coupon Fit-up

Completed Weld

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