

# NORTH CAROLINA DEPARTMENT OF TRANSPORTATION

## ARMOR ANGLE FIELD SPLICE

### 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, A572, (A709-36, 50), (M270-GR250, 345) Unlimited Thickness

Welding Process: SMAW Manual or Semi- Automatic or Automatic: Manual

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

Manufacturer: NCDOT Approved Electrodes Single or Multiple Pass both Position of Weld Flat

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

Root Treatment: N/A

Preheat Temp: 100° minimum Interpass: 450° maximum Post Heat: N/A

Pass Num.	Electrode Size	Welding Current		Travel Speed		Joint Details
		Amperes	Volts			
All	1/8"	90-150	20-23	6-9 ipm		SEE ATTACHMENT

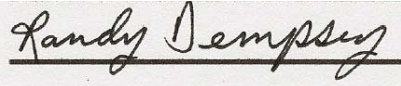
PREHEAT	
Thickness	Min. Temp.
Up to 3/4"	100°
Over 3/4" to 1 1/2"	100°
Over 1 1/2" to 2 1/2"	150°
Over 2 1/2"	225°

**COMMENTS:**

Remove all coating, rust, dirt and mill scale within one inch of the area to be welded. Remove all slag, spatter and weld discontinuities between passes. Clean the completed weld of all debris, slag and spatter.

WPS Description: Armor Angle Field Splice

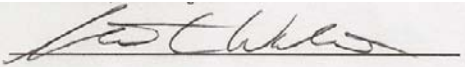
Written By: Randy Dempsey, CWI/CWE, TT IV

Signature: 

WPS #: 032811028

Authorized By: Steve Walton, Metals Engineer

Revision #: 1

Signature: 



## Illustrations Armor Angle Field Splice.



As received



Both pieces beveled and coating next to weld zone removed.



Each pass is cleaned.



The completed weld is grinded flush

NCDOT MATERIALS & TESTS UNIT (STEEL SECTION)