

Chapter 11.2

WELDING PROCEDURE SPECIFICATION REVIEW AND APPROVAL PROCESS

11.2.1 PURPOSE

This procedure provides guidance to the fabricators for the review and approval process of the fabrication facilities' welding procedure specifications.

11.2.2 AUTHORITY

Sections 20.23(3)(a) and 334.048(3), Florida Statutes (F.S.)

11.2.3 REFERENCES

Structures Design Guidelines, Florida Department of Transportation - Structures Design Office, Procedure No. 625-020-154

American Association of State Highway Transportation Officials/National Steel Bridge Alliance (AASHTO/NSBA) Steel Bridge Collaboration, Steel Bridge Fabrication QC/QA Guide Specification

American Institute of Steel Constructors (AISC) Quality Certification Program for Structural Steel Fabricators (that program initiated prior to July 2002)

American Welding Society (AWS) ANSI/AASHTO/AWS D1.5, Bridge Welding Code

American Welding Society (AWS) D1.1/D1.1M, Structural Welding Code – Steel

American Welding Society (AWS) D1.2/D1.2M, Structural Welding Code-Aluminum

American Welding Society (AWS) D1.3, Structural Welding Code-Sheet Steel

American Welding Society (AWS) D1.4 Structural Welding Code-Reinforcing Steel

American Welding Society (AWS) D1.6, Structural Welding Code-Stainless Steel

11.2.4 SCOPE

The procedure affects the fabrication facilities, Department's State Materials Office, and the consultants who are involved in the verification and other quality assurance inspection and testing of the steel and miscellaneous metal products.

11.2.5 GENERAL INFORMATION

Each fabrication facility is required to perform welding in accordance with Department approved Welding Procedure Specification. Any welding performed without Department approved Welding Procedure Specification will be rejected.

11.2.6 WPS REVIEW AND APPROVAL PROCESS

11.2.6.1 Review of the Proposed Welding Procedure Specification

The fabrication facility's Certified Welding Engineer or Certified Welding Inspector reviews, signs, and stamps the proposed Welding Procedure Specification. Upon the completion and stamping of the Welding Procedure Specifications, submit two stamped copies to the Department's responsible Verification Inspection Consultant assigned to that facility. Contact the State Materials Office to determine the name of the Verification Inspection Consultant that is responsible for the review of the proposed Welding Procedure Specifications.

The responsible Verification Inspection Consultant reviews the submitted Welding Procedure Specification and associated procedure qualification records and returns the original, stamped welding procedures within two weeks of receipt of such documents to the fabrication facility. The responsible Verification Inspection Consultant places the review stamp on the front of each Welding Procedure Specification indicating its disposition. This disposition will be either, approved, approved as noted, not approved, or revise and resubmit.

The Verification Inspection Consultant forwards a copy of each welding procedure marked "approved" or "approved as noted" to the State Materials Office.

If additional information is required for the review, the responsible Verification Inspection Consultant contacts the fabrication facility in writing to request clarification or additional information. The two-week review time clock will be reset after the submittal of the additional information.

11.2.6.2 Maintaining Records of Approved Welding Procedure Specification

The State Materials Office posts welding procedures marked “approved” or “approved as noted” to the State Materials Office’s P-Drive. The State Materials Office provides access to the P-Drive or e-mails a copy of the document to the authorized individuals and organizations that need the document.

11.2.7 Utilization of the Approved Welding Procedure Specification

Use the approved Welding Procedure Specification on any applicable Department projects. Submittals of Welding Procedure Specification on a per project basis are not necessary, unless the project requires additional information that is not available in the current Welding Procedure Specification. Welding Procedure Specifications may be given an expiration date based on their **Procedure Qualification Records**, in accordance with – **American Welding Society’s AWS D 1.5**. Approved Welding Procedure Specifications may be used by the fabrication facility until they expire.

Provide a list of the approved Welding Procedure Specifications that will be used on the project, with the submittal of shop drawings and also provide the same list during the prefabrication meetings. During the completion of the project, revise and resubmit the list of the Welding Procedure Specifications to include the actual Welding Procedure Specifications that were used.

If additional welding procedures are required for a particular project, or as existing procedures expire, submit the additional and new Welding Procedure Specifications to the responsible Verification Inspection Consultant for review as stated in **Section 11.2.6.1**.

Provide the original copy of the approved Welding Procedure Specifications, when requested by the Department representatives. Post copies of approved Welding Procedure Specifications in the fabrication shop for reference by shop personnel performing welding.

11.2.8 Responsible Fabrication Facilities

The steel and miscellaneous metals fabrication facilities of the bridge components, overhead cantilevered sign supports with cantilevered arms exceeding 41 feet [12 m], movable bridge components, or any other items identified as items requiring commercial inspections, are required to have approved Welding Procedure

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Specification.

The fabricators of the following products are only required to include their proposed Welding Procedure Specification as part of their quality control plan:

The fabricators of overhead cantilevered sign supports with cantilevered arms less than or equal to 41 feet [12 m], light poles, high mast poles, expansion joints, roadway decking, bearings, Monotube Assemblies, standard mast arm assemblies, drainage items, stay-in-place forms, casing pipes, and Steel strain poles products and any other items that are not designated as items requiring commercial inspections.

11.2.9 TRAINING

No training is required for the implementation of this document.

11.2.10 FORMS

There are no specific forms associated with this procedure.