

AASHTO/AWS D1.5/D1.5M:2008

STATE OF MAINE DEPARTMENT OF TRANSPORTATION
REVIEWED REVIEWED WITH COMMENTS
REJECTED RETURNED FOR CORRECTIONS

PROCEDURE QUALIFICATION RECORD

(Include PQR Number on All Supporting Documents)

PQR NUMBER 42

AUG 10 2010

Welder's Name JAMES GENTILE JR

Position 2F

Welding Test Date 3-10-10

Joint Detail: Fig. 5.1 Fig. 5.2

Fig. 5.3 Fig. 5.8

Electrical Stick Out 1/4"

AWS Flux Classification E702-EM12K

Postweld Heat Treatment: Temp. _____ Hold Time _____ Heating/Cooling Rate _____

| Electrode | Diam. | Current | WFS* | Voltage | Current and Polarity |
|-----------|-------|----------|------|---------|----------------------|
| (1) | 3/32 | 600 (50) | | 33 | DCEN |
| (2) | | | | | |
| (3) | | | | | |

Calculated Heat Input (see 5.12)

Shielding Gas _____ Dew Point _____ Flow Rate _____ Gas Cup Size _____

Travel Speed: Min. 19.3 Max. _____

Base Metal Specification and Thickness A57-6300/1 Heat Number _____

Backing Metal Specification and Thickness _____ Heat Number _____

Base Metal Carbon Equivalent (see 5.4.2)

(Attach Copy of Certified Mill Test Report for Base and Backing Materials)

Preheat Temp. 250 Interpass Temp. Min. 70° Max. 450°

SPECIMEN

TEST RESULTS

All Weld Metal Tension (AWMT)

ksi MPa

Tensile Strength

Yield Strength

Elongation in 50 mm [2 in] (%)

Reduction in Area %

Visual Inspection: Acceptable Unacceptable

**Macro Test: Acceptable Unacceptable

Side Bend 1. _____ 2. _____ 3. _____ 4. _____

Reduced Section Tension Tension Strength 1. _____ Location of Break 1. _____

ksi MPa

2. _____ 2. _____

Charpy V-Notch Impact Toughness of Weld Metal _____

BMAW, SAW, FCAW, GMAW—5 Req'd. *Avg. ft-lbs, J _____ °F °C

ESW and EGW—8 Req'd. *Discard the highest and lowest values and average the 3 remaining.

**Chemistry of Deposited Weld Metal C _____ Mn _____ Si _____ P _____ S _____

When Required by Contract Documents Ni _____ Cr _____ Mo _____ V _____ Cu _____

Radiographic Test: Acceptable Unacceptable

Remarks _____

Filet Weld Soundness Maximum Size Single Pass: 5/16 1. OK 2. OK 3. OK

Macroetch Maximum Size Single Pass: 1. _____ 2. _____ 3. _____

We, the undersigned, certify that the above described WPQR/FWS has been qualified in accordance with Clause 5 of the AASHTO/AWS D1.5/D1.5M:2008 Bridge Welding Code.

State/3rd Party Witness _____ Mfr./Contractor ARC Ent.

Date 3-10-2010 Authorized By _____

Date 3-10-10

Vermont Agency of Transportation

RECEIVED

CK'D BY David Peterson OK'D BY JWC

Apr 26, 2012

RESUBMIT APPROVED

BY C. CARLSON DATE 5/7/12

Qualification Record (PQR) List, and Verification Results

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