TR-50 (2-26)

Pennsylvania
Department of Transportation
www.pa.gov/penndot

PRODUCTION JOINT WELDING PROCEDURE SPECIFICATION
(D1.1-2015)

Procedure No:	Date Issued:
Revison No:	Revision Date:

Contractor (Fabricator):

Prepared by: ☐ Prequalified ☐ Qualified by testing

Supporting PQR No(s):

Material specification(s) (Grade, Type):

Material Thickness(es):

Diameter (pipe):

Welding Process: ☐ Manual ☐ Machine ☐ Semiautomatic

Position(s) of Welding:

Filler metal specification:

Filler metal classification:

Brand Name:

Flux class: Brand:

Type: ☐ Active ☐ Neutral ☐ Alloy

Shielding gas: Flow rate (cfh):

☐ Single Pass ☐ Multiple Pass ☐ Single Arc ☐ Multiple Arc-Tandem ☐ Multiple Arc-Parallel

Multiple Electrode Arc Spacing (SAW):   Longitudinal: Lateral:

Angle (degrees):   (show in joint detail)

Welding current: ☐ AC ☐ DCEP ☐ DCEN ☐ Pulsed

Transfer Mode (GMAW): ☐ Globular ☐ Spray Vertical Progression: ☐ Up ☐ Down

Root cleaning:

Postheat treatment:

Electrode extension (electrical stickout):

For PENNDOT use only

Weld Size	Pass No(s)	Electrode Size	Welding Process Variables		Travel Speed (IPM)
			AMPS/WFS*	Volts	

Joint Detail
Show relevant dimensions and AWS symbols

* Wire feed speed may be used along with amperage (include chart)

Preparer's Signature:

Additional Notes:

Preheat and Interpass Temperature Chart		
Base metal thickness range	Minimum preheat (ºF)	Max Preheat & Interpass (ºF)