



ALUMINUM WELD PROCEDURE QUALIFICATION RECORD (AWS D1.2-2014)

PQR No:		PQR Date (Date Welded):							
PennDOT Approval for: <input type="checkbox"/> witnessing <input type="checkbox"/> w/out witnessing <input type="checkbox"/> resubmit									
Contractor (Fabricator):									
Welder's Name:									
Structure Class & Type: <input type="checkbox"/> I <input type="checkbox"/> II <input type="checkbox"/> non-tubular <input type="checkbox"/> tubular		PQR Prepared by:							
PQR Type: Groove:		Fillet: <input type="checkbox"/> Option 1 <input type="checkbox"/> Option 2							
Welding Process(es): <input type="checkbox"/> GMAW <input type="checkbox"/> GTAW <input type="checkbox"/> PAW-VP Position:									
Direction of Welding: <input type="checkbox"/> forehand <input type="checkbox"/> backhand <input type="checkbox"/> vertical upward <input type="checkbox"/> vertical downward									
AWS A5.10 Filler Classification:		Filler F Number:							
Initial Cleaning: Oxide:		Dirt & Oil:							
Interpass Cleaning:		Dye Penetrant Removal:							
Bead Type Stringer:	Weave:	Welding Current:	Polarity:						
Pulsed:	Shielding Gas:	Flow rate (cfh):	Dew Point (°F):						
M Number:	To	Alloy & Temper:	To						
Base Metal Thickness:	To	Backing/Type Alloy:							
Base Metal and Backing Specification & Heat Nos. (Attach certified copies of mill test reports):									
Preheat Temp (°F):		Interpass Temp. (°F): Min. Max:							
Postheat treatment: <input type="checkbox"/> Yes <input type="checkbox"/> No If Yes: Original Temper:									
Original Temper:		Final Temper:							
Temperature:		Time:							
Quench:									
Weld Process	Weld Size	Pass No(s)	Electrode Ext.	Electrode Size	Welding Process Variables AMPS/WFS* Volts		Travel Speed (IPM)	Joint Detail Show relevant dimensions and AWS symbols	

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

PHYSICAL AND NONDESTRUCTIVE TEST RESULTS (Complete below and attach laboratory reports)

Test for Aluminum Welds	Test Results			
Visual (accept/reject)	Original Temper:		Final Temper:	
Reduced/Full Section Tension (psi)	1.	2.		
Root Bend (accept/reject)	1.	2.		
Face Bend (accept/reject)	1.	2.		
Side Bend (accept/reject)	1.	2.	3.	4.
Nick-Break (Castings) (accept/reject)	1.	2.		
Macro weld size (pjp Groove/Fillet)	1.	2.		
Fracture (accept/reject) (Fillet)	1.	2.	3.	4.

I attest that the above information is correct.

Authorized Representative of contractor (fabricator): _____ Date: _____

Authorized Representative of PENNDOT: _____ Date: _____