**Instructions:** The Contractor’s designated inspector must complete section A. Pile Splices or B. Field Welded Components as applicable. The Contractor’s designated inspector must be approved to inspect welds designated as AWS D1.1 and listed in the Contractor’s Field Welding Plan for the current year. The welder and inspector cannot be the same individual.

If information required by this form is unavailable or cannot be verified, do not weld; notify the Engineer and contact the Bureau of Structures. DT2320 must be signed and dated by the Contractor’s designated inspector. The Engineer shall verify the information provided, sign and date the form.

For permanent record retention the Engineer shall submit this form to the Field Welding Inspection Checklist Document Library: <https://wigov.sharepoint.com/sites/dot-dtsd/scr/SitePages/Home.aspx>

For questions contact: Bill Hardy, CWI 715-977-7670, Ryan Janssen, CWI 608-982-1283 or DOTDLStructuresFabrication@dot.wi.gov

1. **PILE SPLICES**

|  |  |  |  |
| --- | --- | --- | --- |
|       |       |       |       |
| Structure ID | Project ID | Contractor | Date |

[ ]  Contractor has an accepted Field Welding Plan (<https://wigov.sharepoint.com/sites/dot-dtsd/scr/SitePages/Home.aspx>)

[ ]  The WPS is listed in the Field Welding Plan

[ ]  The welder is listed in the Field Welding Plan and qualified to the welding process detailed in the WPS and in the welding positions required for the work.

[ ]  For WPSs and/or welders not listed in the Field Welding Plan: Verify the WPS, welder qualifications and welder continuity records have been provided to the Engineer and to the Bureau of Structures for review and approval. Formal approval is required to continue.

**Pile Type**

Select pile points if these will be welded in the field.

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| [ ]  H-Pile (D1.1) | [ ]  Round Pile (D1.1) | [ ]  Exposed H-Pile (D1.5) | [ ]  Exposed Round Pile (D1.5) | [ ]  Pile Points |

**WPS, Welder & Materials Information**

|  |  |
| --- | --- |
|       |       |
| Welding Procedure Specification (WPS) ID(s) | Welder Name |
|       |       (max) hrs |       |
| Electrode  | Exposure Time *SMAW only* | Electrode storage (type, if needed)  |
| [ ]  A709 Gr. 50, A572 | [ ]  A252 (oil field pipe) CE\* =       |       °F |       °F |
| Base Metal (\*Carbon Equivalency = CE) | Ambient Temperature | Preheat Required (WPS) |

[ ]  Verify that the WPS (incl. joint preparation), welding process, and preheat temperature noted above are suitable for the work. If not suitable, submit a new WPS to the project engineer for review and approval.

[ ]  Verify welding machine and voltmeter calibration date.

[ ]  Verify environmental conditions are suitable for welding. Do not weld when: (1) the ambient temperature in the vicinity of the weld is lower than 0°F, (2) surfaces are wet or exposed to rain, snow, or high wind velocities, (3) welding personnel are exposed to inclement conditions.

[ ]  Verify all metal surfaces are clean and clear of galvanizing, paint, water, rust, oil, or grease.

[ ]  Verify that for base metal temperatures at or below 32°F the base metal is preheated to 70°F.

**Visual Acceptance: Pile Splices**

**Min. Preheat for A252 (Oil Field Pipe):** CE below 0.35 = 100F | CE at or between 0.35 - 0.45 = 175F | CE up to 0.50 = 300F

|  |  |  |
| --- | --- | --- |
| **Joint designation, description, or heat numbers** | **Measured Preheat Temp. (°F)** | **Visual Acceptance notes****(Pass or Pass w/ repairs)** |
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| **Additional Notes:** |

|  |  |
| --- | --- |
| **Contractor’s Designated Inspector** | **Field/Project Engineer◊** |
|  |  |
| Signature | Date | Signature | Date |
|  |  |
| Print Name | Print Name |

**◊** Submit completed and signed form to: <https://wigov.sharepoint.com/sites/dot-dtsd/scr/SitePages/Home.aspx>

1. **FIELD WELDED COMPONENTS**

|  |  |  |  |
| --- | --- | --- | --- |
|       |       |       |       |
| Structure ID | Project ID | Contractor | Date |

[ ]  Contractor has an accepted Field Welding Plan (<https://wigov.sharepoint.com/sites/dot-dtsd/scr/SitePages/Home.aspx>)

[ ]  The WPS is listed in the Field Welding Plan

[ ]  The welder is listed in the Field Welding Plan and qualified to the welding process detailed in the WPS and in the welding positions required for the work.

[ ]  For WPSs and/or welders not listed in the Field Welding Plan: The WPS, welder qualifications and welder continuity records have been provided to the Engineer and to the Bureau of Structures for review and approval. Formal approval is required to continue.

**Component Type**

Select the component to be field welded. The component must be approved in the Contractor’s Field Welding Plan.

🟊When choosing *Other* or *Rebar Splices*, additional review and approval from Bureau of Structures is required before welding can begin.

|  |  |  |
| --- | --- | --- |
| [ ]  Steel Railing Repair (D1.1) | [ ]  Steel Sign Structure Repair (D1.1) | [ ]  🟊Rebar Splices (D1.4) |
| [ ]  Steel Bearing (D1.5) | [ ]  Aluminum Sign Structure Repair (D1.2) | [ ]  🟊Other (describe field welding application/component) |
| [ ]  Stainless Steel Bearing Anchor Plate (D1.6) | [ ]  Expansion Joint Splices (D1.1) | \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ |

**WPS, Welder & Materials Information**

|  |  |
| --- | --- |
|       |       |
| WPS ID | Welder Name |
|       |       (max) hrs |       |
| Electrode Classification | Exposure Time *SMAW only* | Electrode storage *SMAW Only* (type, if needed)  |
| [ ]  A709 Gr. 36/50/50W, A572, A36, A595 Gr. A, A500 Gr. C, A1085, API 5L PSL 2 | [ ]  Aluminum alloy 6061-T3, 6063-T6 [ ]  SS 304/316 |       °F |       °F |
| Base Metal | Ambient Temperature | Preheat Required (WPS) |

[ ]  Verify that the WPS (incl. joint preparation), welding process, and preheat temperature noted above are suitable for the work. If not suitable, submit a new WPS to the project engineer for review and approval.

[ ]  Verify environmental conditions are suitable for welding. Do not weld when: (1) the ambient temperature in the vicinity of the weld is lower than 0°F, (2) surfaces are wet or exposed to rain, snow, or high wind velocities, (3) welding personnel are exposed to inclement conditions.

[ ]  Verify all metal surfaces are clean and clear of galvanizing, paint, water, rust, oil, or grease.

[ ]  Verify that for base metal temperatures at or below 32°F the base metal is preheated to 70°F.

**Coated Surfaces**

|  |
| --- |
| [ ]  Remove paint or galvanizing before welding. Describe paint or galvanizing removal method and removal limits: |
| [ ]  Repair paint or galvanizing after welding. Describe paint or galvanizing repair method and products: |

**Visual Acceptance: Field Welded Components**

|  |  |  |
| --- | --- | --- |
| **Joint designation, description, or heat numbers** | **Measured Preheat Temp. (°F)** | **Visual Acceptance notes****(Pass or Pass w/ repairs)** |
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| Additional Notes: |
|  |
| **Contractor’s Designated Inspector** | **Field/Project Engineer◊** |
|  |  |
| Signature | Date | Signature | Date |
|  |  |
| Print Name | Print Name |

**◊** Submit completed and signed form to: <https://wigov.sharepoint.com/sites/dot-dtsd/scr/SitePages/Home.aspx>