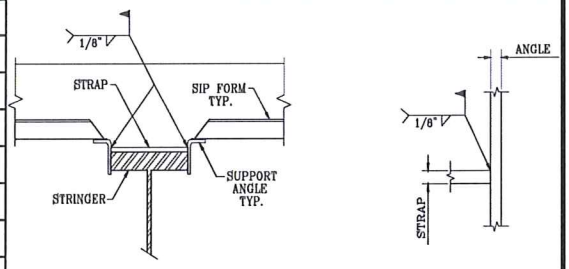
WMSCI Rochester BRF 0162 (18)

WELDING PROCEDURE SPECIFICATION

MATERIAL SPECIFICATION	ASTM A-653 GRADE 40 to A709 GR50/A36/A653
WELDING PROCESS	SMAW
MANUAL, AUTO, SEMI-AUTO	MANUAL
POSITION OF WELDING	HORIZONTAL
FILLER METAL SPEC AWS	A5.1
FILLER METAL CLASSIFICATION	E7018
ELECTRODE & MANUFACTURER	JETWELD LH-73 & LINCOLN ELECTRIC (Conforms to AWS 5.1, ASME SFA 5.1)
FLUX & MANUFACTURER	n/a
SHIELDING GAS	n/a DEW POINT n/a FLOW RATE n/a
SINGLE OR MULTIPLE PASS	SINGLE PASS
SINGLE OR MULTIPLE ARC	SINGLE ARC
WELDING CURRENT	DC
POLARITY	REVERSED
WELDING PROGRESSION	n/a
ROOT TREATMENT	REMOVE DUST, MOISTURE, GREASE & ANY FOREIGN MATERIAL
PREHEAT & INTERPASS TEMP	n/a
POSTHEAT TEMP	n/a

WELDING PROCEDURE

PASS NO.	ELECTRODE SIZE	WELDING PARAMETERS AMPS	WELDING PARAMETERS VOLTS	TRAVEL SPEED	JOINT DETAIL
1	1/8"	200	n/a	12" per/min	

WELD LENGTH AND SPACING PER APPROVED DESIGN

THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT-UP, PASS, SIZE, ETC. WITHIN THE LIMITATION OF VARIABLES GIVEN IN SECTION 8A.

PROCEDURE NO.	711.2	FABRICATOR/ERECTOR	J&B WELDING, INC.
REVISION NO.		AUTHORIZED BY	MARTIN BENZING
		DATE	1/14/2014

Welding Procedure for SIP Forms for BR 19 Bridge Deck.

MG 4/2/15

MATERIALS TESTING, INC.

55 LAURA STREET • NEW HAVEN, CONNECTICUT 06512 • (203)468-5216
42 BOSTON POST ROAD • WILLIMANTIC, CONNECTICUT 06226 • (860)423-1972

WELDER AND WELDING OPERATOR QUALIFICATION TEST RECORD

MTI Qualification No. 1627

Welder's Name Shawn P. Moss
Welder's Address 5247 Conrad Road Cincinnatus, NY 13040
Welding Process SMAW Manual X Semiautomatic Machine
Position Flat (1G) Positions Qualified 1G, 1F, 2F
Material Specification A36
Joint Thickness 3/8" Thickness Range this Qualifies 1/8" to 3/4" groove, 1/8" to unlimited fillet

FILLER METAL

Specification No. AWS A5.1 Classification E7018
Is Backing Used? Yes
Flux for Submerged Arc or Gas for Gas Metal Arc or Flux Cored Arc Welding N/A

VISUAL INSPECTION

Appearance Satisfactory Undercut None Piping Porosity None

Guided Bend Test Results

Type	Result	Type	Result
Root Bend	Satisfactory		
Face Bend	Satisfactory		

Test Conducted By William J. Soucy Laboratory test no. N/A
Per AWS D1.5 Test dates 1-23-14

Fillet Test Results

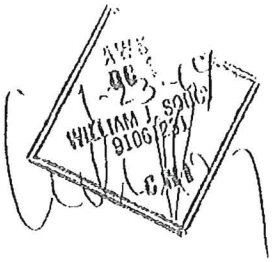
Appearance Fillet Size
Fracture Test Root Penetration Macroetch
Test Conducted By
Per Test Date

RADIOGRAPHIC TEST RESULTS

Film Identification	Results	Film Remarks

Test Witnessed By Test No.
Per Test Date

We the undersigned, certify that the statements in this record are correct and that the welds, were prepared and tested in accordance with requirements of the AWS D1.5 Bridge Welding Code.



Welding witnessed by: Henry Daricek, 90070051
Date 1/23/14
Contractor J&B Welding, Inc.

WTTI
WWW.WELDERINSTITUTE.COM

WELDER TRAINING AND TESTING INSTITUTE
1144 N. GRAHAM ST. · ALLENTOWN, PA 18109 · TEL 610-820-9551 · FAX 610-820-0271

LABORATORY TEST REPORT

LABORATORY TEST NUMBER: 20050348
COMPANY NAME: J & B Welding, Inc.
WELDER'S NAME: Shawn Moss
PROCEDURE NUMBER: SMAW-1
PROCESS: SMAW
POSITION: 1G
MATERIAL SPECIFICATION: A-36 to A-36
THICKNESS: 3/8"
DIAMETER: n/a

GUIDED BENDS OR FILLET WELD TEST RESULTS

SPECIMEN TYPE & FIGURE NO.	*RESULTS*
#1: Face Bend per Figure 4.12	PASSED
#2: Root Bend per Figure 4.12	PASSED
#3: n/a	
#4: n/a	
Other: n/a	

WELDING OF TEST SAMPLE WITNESSED BY: Patrick F. Dorris CWI / WTTI
LABORATORY TEST CONDUCTED BY: Jeffrey T. Wiswesser CWI / WTTI
COMMENTS: n/a
LAB TEST CONDUCTED IN ACCORDANCE WITH: AWS D1.1-2004
DATE: 3/16/2005
FINAL STATUS: PASSED

SIGNATURE:

WTTI
WWW.WELDERINSTITUTE.COM

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WELDER QUALIFICATION TEST RECORD
A.W.S. D1.1

Type of Qualification-Welder: X *Welding Operator:* *Tack Welder:*
Name: Shawn Moss *ID Number:*
Welding Procedure Specification No: SMAW-1 *Rev:* 1 *Date:* 5/10/1995

Variable	*Actual Variable Used in Qualification*		*Qualification Range*
Process/Type	SMAW / Manual		
Electrode (Single/Multiple)	Single		Single
Current/Polarity	DC / Positive		
Position	1G		1G,1F,2F
Weld progression	n/a		n/a
Backing (yes or no)	Yes		With or Both Sides
Material/Spec.	A-36	*to:* A-36	
Base metal			
Thickness: (Plate)			
Groove	3/8"		1/8" - 3/4" Max.
Fillet	n/a		1/8" - Unlimited
Thickness: (Pipe/Tube)			
Groove	n/a		Not Specified
Fillet	n/a		1/8" - Unlimited
Diameter: (Pipe)			
Groove	n/a		>24" OD
Fillet	n/a		>24" OD
Filler Metal Spec. No.	A5.1		
Class	E7018		
F-No	4		1,2,3,4
Gas/Flux Type	n/a		
Other	n/a		n/a

Visual Inspection (4.8.1)
Acceptable-Yes: X *No:*
Guided Bend Test Results (4.30.5)

#1: Face Bend per Figure 4.12 - PASSED *#3:* n/a
#2: Root Bend per Figure 4.12 - PASSED *#4:* n/a

Fillet Weld Test Results (4.30.2

Appearance: n/a *Si*
Penetration: n/a *Mi* n/a

SIGN & DATE

Inspected by: Jeffrey T. Wiswesser CWI / WTTI *Lab Number (s):* 20050348
Organization: Welder Training & Testing Institute *Date:* 3/16/2005

We, the undersigned, certify that the statements in this record are correct and that the test welds were prepared, welded and tested in accordance with the requirements of section 4 of AWS D1.1(2004) Structural Welding Code - Steel.

Contractor: J & B Welding, Inc. *Authorized by:* *Date:*

Moving Massachusetts Forward. massDOT Highway

WELDER AND WELDER OPERATOR QUALIFICATIONS TEST RECORD

SNYDOT

NAME Moss, Shawn P.

SIGNATURE

PROCESS SMAW DATE OF TEST 03/28/2012

MANUAL ☑ SEMI-AUTO ☐ AUTO ☐

TEST POSITION(S) 1F

MATERIAL SPECIFICATION NA POSITIONS QUALIFIED NA

THICKNESS RANGE QUALIFIED Unlimited Fillet

WALL THICKNESS DIAMETER NA JOINT THICKNESS NA

FILLER METAL

SPECIFICATION NO NA GROUP NO NA

CLASSIFICATION NO. NA DIAMETER NA

SHIELDING

FLUX NA GAS NA

VISUAL INSPECTION Satisfactory

FILLET TEST

FILLET SIZE NA APPEARANCE NA MACROETCH NA

DESCRIPTION OF LOCATION AND SIZE OF ANY CRACK

NA

GUIDED BEND TEST

PLATE A-POSITION 1F BEND 1A Acceptable BEND 2A Acceptable

PLATE B-POSITION NA BEND 1B NA BEND 2B NA

RADIOGRAPHIC TEST

FILM I.D. NA RESULTS NA REMARKS NA

TEST NO SPM-8932 / 10 COMPANY new York State Department of Transportation

All welds prepared, tested and inspected in accordance with the requirements of the AASHTO/AWSD1.5 Bridge Welding Code.

WITNESSED BY N. Paul Rimmer CWI NO 0

APPROVED BY

Metals Control Engineer

CERTIFICATION NO 09060

1F
Unlimited
Fillet

09060

WELDER QUALIFICATION CERTIFICATE
WORK RECORD

Shawn P. Moss

No. 100328

Exp. Date Jun. 2013

record must be presented to the Engineer before beginning
ate of New York Engineer-In-Charge, licensed Professional
or AWS certified welding inspector must sign this Certificate at
every six months for the Certificate to remain valid. The person
s card shall have personal knowledge of the welder's
y performance.

NAME (PRINT)	CONTRACT,PE OR CWI NO.	DATE	INITIALS
EDWARD J. MALL	D260985	8-24-10	ejm
THOMAS M FLYCK	D260985	12-3-10	[illegible]
LUKE THOMPSON	D260985 PE #007740	04-08-11	LET
JOEL HARWOOD	D261187	07-28-11	[illegible]
ALBERT PEREZ	CWI 00030621	8-26-11	AP
ALBERT PEREZ	CWI 00030621	9-26-11	AP
LUKE THOMPSON	D260985 PE # 007740	11-22-11	LET
ALBERT PEREZ	CWI 00030621	3-28-12	AP

BD 36d (1/08)

STATE OF NEW YORK
DEPARTMENT OF TRANSPORTATION

WELDER QUALIFICATION CERTIFICATE

No. 100328 Exp. Dat Jun. 2013

Shawn P. Moss

Welder ID SPM-8932

Is qualified to use the Manual Shielded Metal Arc Welding process (Low Hydrogen) to the extent shown on reverse side.

Jul. 2010 N Paul Rimmer CRESTA
Issue Date for Asst. Deputy Chief Engr. (Structures)

[signature]
Signature of Welder

Qualification is granted on the basis of X-Ray examination of test welds interpreted to the requirements of the New York State Steel Construction Manual.

VALID ONLY AS INDICATED
Must be accompanied by welder's work records (BD 141a)

WELDING PROCESS	FILLET WELDS	GROOVE WELDS	
		¾" max. thickness	Unlimited thickness
	Position	Position	Position

DOT

WELDER AND WELDER OPERATOR QUALIFICATIONS TEST RECORD

SNYDOT

NAME Rice, Jay D.

SIGNATURE

PROCESS SMAW DATE OF TEST 07/29/2012

MANUAL ☑ SEMI-AUTO ☐ AUTO ☐

TEST POSITION(S) 1G

MATERIAL SPECIFICATION NA POSITIONS QUALIFIED NA

THICKNESS RANGE QUALIFIED 3/4 Inch Max Groove, Unlimited Fillet

WALL THICKNESS DIAMETER NA JOINT THICKNESS NA

FILLER METAL

SPECIFICATION NO NA GROUP NO NA

CLASSIFICATION NO. NA DIAMETER NA

SHIELDING

FLUX NA GAS NA

VISUAL INSPECTION Satisfactory

FILLET TEST

FILLET SIZE NA APPEARANCE NA MACROETCH NA

DESCRIPTION OF LOCATION AND SIZE OF ANY CRACK

NA

GUIDED BEND TEST

PLATE A-POSITION 1G BEND 1A Acceptable BEND 2A Acceptable

PLATE B-POSITION NA BEND 1B NA BEND 2B NA

RADIOGRAPHIC TEST

FILM I.D. NA RESULTS NA REMARKS NA

TEST NO JDR-9870 / 100 COMPANY New York State Department of Transportaion

All welds prepared, tested and inspected in accordance with the requirements of the AASHTO/AWSD1.5 Bridge Welding Code.

WITNESSED BY N. Paul Rimmer CWI NO 0

APPROVED BY

Metals Control Engineer

CERTIFICATION NO 09057

BD 141a (1/06)

WELDER QUALIFICATION CERTIFICATE WORK RECORD

Jay D. Rice

No. 100478

Exp. Date Sep. 2013

This work record must be presented to the Engineer before beginning work. A State of New York Engineer-In-Charge, licensed Professional Engineer, or AWS certified welding inspector must sign this Certificate at least once every six months for the Certificate to remain valid. The person signing this card shall have personal knowledge of the welder's satisfactory performance.

NAME (PRINT)	CONTRACT,PE OR CWI NO.	DATE	INITIALS
ALBERT POZOTRIGO	068960-1	2/17/2011	[illegible]
ALBERT PEREZ	[illegible]	3-28-11	AP
MUHAMMAD ALI	HBR 1217, [illegible]	6-23-11	[illegible]
Dave Schneider	NY [illegible]	7/26/11	[illegible]
JOEL HARWOOD	D261187	07-29-11	[illegible]

Nika 7/23/12

Can you make green cards for these welders who are NYDOT certified. Need to be entered into data base.

516-457-827

Thad Mulfitz

BD 36d (1/06) STATE OF NEW YORK
DEPARTMENT OF TRANSPORTATION

WELDER QUALIFICATION CERTIFICATE

No. 100478 Exp. Dat. Sep. 2013

Jay D. Rice

Welder ID JDR-9870

Is qualified to use the Manual Shielded Metal Arc Welding process (Low Hydrogen) to the extent shown on reverse side.

Sep. 2010 [illegible]

Issue Date for Asst. Deputy Chief Engr. (Structures)

NAME (PRINT)	CONTRACT,PE OR CWI NO.	DATE	INITIALS
THEODORE FISHER	PE 023204E	11/1/10	
CHRISTOPHER STRACK	D261407	16 JUNE 2011	[illegible]
DAVID [illegible]	CWI 01040831	11-30-11	[illegible]
DON MOORE, PE	D261606	3-12-12	[illegible]
CHRISTOPHER D. ROE	D262026	7-19-12	[illegible]

[illegible]

Signature of Welder

Qualification is granted on the basis of X-Ray examination of test welds interpreted to the requirements of the New York State Steel Construction Manual.

VALID ONLY AS INDICATED

Must be accompanied by welder's work records (BD 141a)

WELDING PROCESS	FILLET WELDS		GROOVE WELDS	
			¾" max. thickness	Unlimited thickness
	Position		Position	Position
Manual-SMAW	F	H	F	

BD 35d (1/06) Reverse

1G 3/4" Max

N. Paul Rimmer 09057