

SOUTH CAROLINA DEPARTMENT OF TRANSPORTATION

QUALIFIED PRODUCT POLICY FOR FIELD WELDERS

1.0 General:

As prescribed in section 709.3.2.5 of the Standard Specifications, all welders performing structural field welding must be listed on Qualified Product List (QPL) 41. This policy outlines the procedure for inclusion on this QPL.

2.0 Initial:

All field personnel performing structural field welding as defined in Section 709.3.2.5 shall be qualified to perform this type of welding in accordance with the qualification procedure of AASHTO/AWS D1.5, *Bridge Welding Code* as follows:

- 2.1 A welder may be qualified by preparing test specimens in the 2G position (horizontal groove) for limited thickness groove welding and in the 2F position (horizontal fillet) for fillet welding. This testing is the minimum and will qualify the welder for general welding at the job site. The welder may qualify for additional positions and unlimited material thickness as part of the above testing. Specialized welding and welding positions at the job site may require additional welder qualification testing if required by the Resident Construction Engineer.
- 2.2 The test specimens shall be prepared in the presence of and tested and evaluated by an American Welding Society Certified Welding Inspector (CWI) employed by and on behalf of an independent laboratory listed on QPL 26. An ASNT Level II or III technician shall perform all radiographic nondestructive testing of the weld specimens.
- 2.3 The independent laboratory shall furnish a welder qualification test report to the Structural Materials Engineer (SME) at the contact information shown in Subsection 4.0 meeting the following:
 - Must be on company letterhead and include the name of the CWI making the evaluation and the CWI's signature and certification number
 - Must state welder's name and identification number
 - Must state the test welding process, position/positions, and material thickness
 - Must state the positions and material thickness range for which the welder is qualified, based on the testing
 - Must include a statement that the test welds were prepared, welded, and tested in accordance with the requirements of AASHTO/AWS D1.5

- 2.4 Qualification from another state department of transportation (DOT) may be accepted, provided that the other state DOT requires the same testing for qualification. The welder must submit a certificate/document from the other state DOT to the SME at the contact information shown in Subsection 4.0. The certificate/document must detail the positions and thicknesses for which the welder is qualified.

3.0 Expiration and Renewal:

Qualification shall be valid for two years from the date of issuance. The welder may request renewal every two years as follows:

- 3.1 The welder must have been engaged in welding procedures during the preceding 2-year period to obtain qualification renewal
- 3.2 The welder's qualification may be renewed up to 90 days before expiration, and up to 90 days after expiration. After this period, initial qualification, including independent testing, will be required.
- 3.3 Qualification renewal may be requested by sending a letter or email to the SME at the contact information shown in Subsection 4.0. The letter/email must be sent, signed, and dated by the welder's supervisor and must state that the welder has been engaged in welding during the previous two year qualification period. If the welder seeking renewal is also owner of the welding enterprise, he or she may write and sign the required letter/email.

4.0 Submission Information:

Requests for qualification, along with the required independent laboratory test report, and requests for renewal should be submitted to:

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