

Weld Production Guide



Updated 9/18/2023

OVERVIEW


Quick guide for Weld production role (Field Engineers, Superintendents, Foremen, etc).

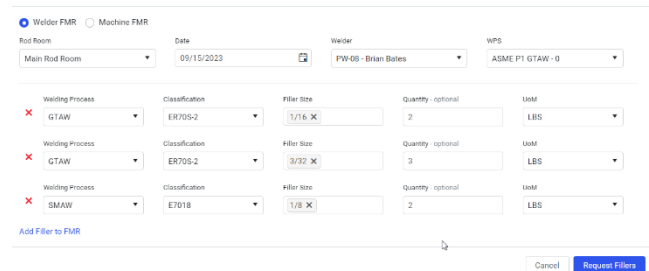
Topics covered:

- FMR Request
- Heat Treat Request
- Single Weld Traveler
- Report Progress

FMR REQUEST

Steps


1. At the top of the Welds page, select Create FMR 
 - a. Depending on project settings, users may need to select a specific weld checkbox for Create FMR be selectable.
2. Fill out the FMR Request form by selecting the appropriate:
 - a. Rod Room (if more than one at the project)
 - b. Date – leave this field as is, even if the request is for the next business day
 - c. Welder
 - d. WPS
3. Next select the appropriate information regarding the material requested:
 - a. Welding Process (may add multiple in the same FMR)
 - b. Classification
 - c. Filler Size
 - d. Quantity – simply a communication point
 - e. Unit of Measure for quantity
4. Select Request Fillers to submit the FMR to the Rod Room.
5. *Note – users must be online to use this feature.



Welding Process	Classification	Filler Size	Quantity - optional	UOM
GTAW	ER70S-2	1/16	2	LBS
GTAW	ER70S-2	3/32	3	LBS
SMAW	E7018	1/8	2	LBS

HEAT TREAT REQUEST

Steps

1. Using the checkbox, select the checkbox on the weld that heat treat is being requested for, then select Request Heat Treat. 



Request Preheat for 104ET28020-003-L1X-CFW-001

Cycle: Initial Weld
Request Date: 9/15/2023

Confirmations:

- Weld Properly Supported
- Weather Protection in Place
- Weld Accessible
- QC / Fit-up Accepted

Planned Start Date: 9/22/2023

Comments:

Cancel Request Preheat

2. Complete the Heat Treat Request form. Note that all checkboxes must be completed in order for the submission to go through:
3. Select Request Preheat to send the request to the Heat Treat grid.
4. *Note – users must be online to use this feature

SINGLE WELD TRAVELER (SWT)

Steps

1. Use the checkboxes next to the welds to select the welds.
2. Select the Print SWT button on the left side of the screen.
3. A PDF file will be created and downloaded to the computer. Open that file and print the SWT as needed.
4. *Note – users must be online and on a computer to use this feature.



REPORT PROGRESS

Steps

1. Find the weld on the grid and select the Production Options button
2. Select Report Progress from the dropdown menu.
3. On the Report Progress Screen, first make note of any remaining production inspections assigned to the weld, if any (listed on the upper right of the screen).
4. Next, complete the report progress form by selecting:
 - a. The date the weld/part of the weld was made
 - b. Welder
 - c. FMR
 - d. WPS
 - e. Process – AWS
 - f. Part Complete – indicate what was completed
 - g. Weld location – indicate where the weld currently is – is it in-place, in the fab shop, etc.?
 - h. Notes – this is where you can indicate which part of the buddy weld this welder completed, or any other information
 - i. Upload a photo – optional on most projects
5. If the weld has been marked as 100%, Cap, or Fill and Cap and all remaining inspections have been completed, the Ready for Final VT box will be available to select.
6. Below the progress records, users can also add Base Material 1 and Base Material 2 Heat numbers.



- To add multiple records, select “Add progress” and then complete the form for the next progress record.
- After the progress record(s) have been added, select Save and Close.

Report Progress for 375WBF75003-002-05H-CFW-021-C1

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Cycle
Initial weld

Date
9/15/2023

Welder
Select

Weld FMR
Select

WPS
Select

Process - AWS
Select

Part Complete
Select

Weld Location
in place

Notes

Ready for Final VT

Remaining Inspections		
Type	Method	SubType
Root	Visual	
Root	Surface	
In-process	Visual	
Fit-up	Visual	

R#	Date	Welder	Part Complete	FMR Number	WPS	Process - AWS	Location	Notes
Initial weld	12/9/2022	PF-0019 - OMAR ALEJANDRO	ROOT	000160	ASME P1 GTAW	GTAW - ER70S-2		
Initial weld	12/9/2022	PF-0019 - OMAR ALEJANDRO	FIT-UP	000160	ASME P1 GTAW	GTAW - ER70S-2	in place	top side

Questions? Contact CustomerSuccess.Team@Kiewit.com

