

Structural welding special inspection checklist

A weld tells its story once. The independent inspector confirms the procedure and the welder are qualified for the joint, watches the work while it can still be corrected, and records the completed weld and any testing before it is coated over.

Who runs it: A third-party or owner's-rep welding inspector, coordinating with the fabricator or erector's welding crew. When: Before welding starts (qualifications and fit-up), during welding for critical joints, and at completion before coatings or fireproofing.

Qualification and preparation

- ☐ **Welding procedure specifications available for the joints being welded**
A qualified procedure exists and matches the material, position and process. 1 photo required
- ☐ **Welder qualification current for the position and process**
Continuity and qualification records cover the welder and the work in front of you. 1 photo required
- ☐ **Fit-up, joint preparation and pre-heat verified before welding**
Root openings, bevels and cleanliness as detailed; pre-heat confirmed where required. 2 photos required

In-process inspection

- ☐ **Consumables and settings match the qualified procedure**
Electrode type and storage, gas and parameters consistent with the procedure in use. 1 photo required
- ☐ **Interpass condition and technique observed on critical joints**
Interpass cleaning and temperature control witnessed on representative welds. 2 photos required

Completed welds and testing

- ☐ **Completed welds visually inspected against acceptance criteria**
Size, length and profile correct; no undercut, porosity, cracks or missed returns. 3 photos required
- ☐ **Nondestructive testing witnessed where required**
The specified method performed at the specified joints; results recorded with locations. 2 photos required
- ☐ **Repairs re-inspected and accepted before coating**
Any rejected weld reworked, re-tested and signed off; nothing coated before acceptance. 2 photos required