

Appendix II

Radiographic inspection 100% longitudinal stiffeners butt welds (ODOT review required, Critical process) (5 point)			
Radiographic inspection 25% longitudinal web splice(ODOT review required, Critical process,) (5 point)			
Radiographic identification marked steel stamped and visible in radiographic film, correct image quality indicator (1 point)			
Top and bottom of plate edges visible in the radiographic film (5 point)			
Radiographic technician's signed analysis report (1 point)			
<b>Ultrasonic Inspection per AWS, 863.27 and AASHTO: Check Point seven (7), Hold and Witness Point for B &amp; C Rated Fabricators QCFS acceptance by cover letter listing piece marks , dates and with technician's reports.</b>			
Ultrasonic inspection 25% of complete penetration T or corner joints . (ODOT review required, Critical Process, 100% QA witness with B and C rated fabricators (2 point)			
Ultrasonic technician's signed analysis report (1 point)			
Ultrasonic equipment qualification per AWS 6.17 (1 point)			
<b>Flange to Web Fillet Welds per AWS, 863 and AASHTO: Check Point eight (8), QCFS acceptance by frequent audits , documentation of listed data for each member and dates.</b>			
Size, grade , piece mark and locations of parts to be fitted (1 point)			
Clean scale, moisture, grease & foreign material per AWS 3.2.1 (1 point)			
Standard fillet weld fit up tolerance, 1/16" AWS 3.3 (1 point)			
Welding Procedure (WPS) identification and ODOT approval date (5 point)			
Tackers Name and SS#, ODOT Qualified, procedure (1 point)			
Welder Name and SS#, ODOT Qualified, procedure (3 point)			
Flux and Wire combination, does it match WPS (1 point)			
Preheat Temperature (F) and Shop Temperature(F) (2 points)			
Amperage (Amps),Voltage (Volts) and Travel Speed (IMP) (5 points)			
Visual inspection weld size and profile, AWS 3.6 (5 point)			
<b>Stiffener Fitting per AWS, 863 and AASHTO: Check Point nine (9) QCFS acceptance by cover letter listing piece marks and dates.</b>			
Bearing Stiffener, mill fit @ bearing, tight fit @ other end, 863.14 (1 point)			
Intermediate Stiffener without cross frames, tight fit at tension flange, 863.14 (1 point)			

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Connection Stiffener weld fit at both flanges 863.14 ( 1 point)			
Clearance between clipped stiffener corners and fillets on rolled beams (1 point)			
<b>Stiffener Fillet Welds per AWS, 863 and AASHTO: Check Point ten(10) QCFS acceptance by frequent audits ,documentation of listed data for each member and dates</b>			
Size, grade , piece mark and locations of parts to be welded (1 point)			
Clean scale, moisture, grease & foreign material per AWS 3.2.1 (1 point)			
Standard fillet weld fit up tolerance, 1/16" AWS 3.3 (1 point)			
Welding Procedure (WPS) identification and ODOT approval date (5 points)			
Tackers Name and SS#, ODOT Qualified, procedure (1 point)			
Welder Name and SS#, ODOT Qualified, procedure (3 point)			
Flux and Wire combination, does it match WPS (1 point)			
Preheat Temperature(F) and Shop Temperature(F) (2 point)			
Amperage (Amps), Voltage( Volts) and Travel Speed (IMP) (5 point)			
Visual inspection weld size and profile, AWS 3.6 (5 point)			
<b>Magnetic Particle Inspection per AWS, 863.27 and AASHTO: Check Point eleven (11), Hold and Witness point for C Rated Fabricators.QCFS acceptance by cover letter listing piece marks, dates and with technicians report's.</b>			
Magnetic Particle Inspection 10% of flange to web welds and girder ends after trimming (ODOT review required, Critical Process) Dry powder prod method or probe. 100% QA witness with C rated fabricators. (2 point)			
Magnetic Particle Inspection 10% of Bearing Stiffener Welds (ODOT review required, Critical process) Dry powder prod method or probe. 100% QA witness with C rated fabricators. (2 point)			
Magnetic Particle technician's signed analysis report (1 point)			
Calibration of Magnetic Particle Equipment every 6 months (1 point)			
<b>Shop Laydown per AWS, 863, and AASHTO: Check Point twelve (12) QCFS acceptance by frequent audits, documentation of listed data for each member and dates.</b>			
Hole patterns, size, spacing, gage, accuracy, 863.20 (2 point)			
Hole deburring, 863.20 (1 point)			