

Appendix II

Critical repair, WPS and repair procedure approved for each repair by OSE (2 point)			
Welders Name and SS#, ODOT Qualified last 6 months or annual renewal (1 point)			
Preheat temperature prior to air carbon arc (1 point) witness*			
Grind surfaces to be welded smooth and bright (1 point) witness*			
Flux and Wire combination, does it match WPS (1 point) Are Flux and Wire lot tested, Check Temperature of Flux oven			
Joint geometry tolerances per AWS figure 2.4 (2 point) witness*			
Preheat Temperature (F) and shop temperature (F) (1 point) witness*			
Amperage (Amps), Voltage (Volts) and Travel Speed (IPM) (1 point) witness*			
Visual inspection width, thickness AWS 3.6.3 (2 point) witness*			
Visual inspection surface finish AWS 3.6.4 125 uin. (2 point) witness*			
Visual inspection weld size and profile, AWS 3.6 (2 point) witness*			
Non destructive testing as specified by repair procedure(5 points) witness*			
* witness required for critical repairs not required for non critical repairs			
Flange to Web Fillet Welds per AWS, 863 and AASHTO: Hold and witness Point nine(9),QCFS acceptance by witnessing, frequent audits and documentation of listed data for each splice and dates			
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 (1 point)			
Welding Procedure (WPS) identification and ODOT approval date (5 point)			
Tackers Name and SS#, ODOT Qualified, procedure (2 points)			
Welder Name and SS#, ODOT Qualified, procedure (3 points)			
Flux and Wire combination, does it match WPS Are Flux and Wire lot tested Check temperature of flux oven (2 points)			
Preheat Temperature (F) and shop temperature (1 point) witness			
Amperage (Amps)Voltage (Volts (1 point) Travel Speed (IMP) (5 points) witness			
Visual inspection weld size and profile, AWS 3.6 (5 point) witness			

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Stiffener fitting per AWS, 863 and AASHTO: Check Point Ten(10) QCFS acceptance by frequent audits, documentation of listed data for each member and dates			
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)			
Connection stiffener weld fit at both flanges 863.14 (1 point)			
Clearance between clipped stiffener corners and fillets on rolled beams (1 point)			
Stiffener fillet welds per AWS, 863 and AASHTO: Hold and witness Point Eleven (11)QCFS acceptance by frequent audits, documentation of listed data for each member and dates			
Size, grade, piece mark and location of parts to be welded (1 point)			
Clean scale, moisture, grease & foreign material per AWS 3.2.21 (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) Are Flux and Wire lot tested Check temperature of flux oven			
Record Preheat Temperature(F) and shop temperature(F) (2 point) witness			
Amperage (Amps),Voltage(Volts), Travel Speed (IMP) (3 point) witness			
Visual inspection weld size and profile, AWS 3.6 (5 point) witness			
Magnetic Particle Inspection per AWS, 863 and AASHTO: Check Point twelve (12), Hold and witness for C rated fabricators. QCFS acceptance by cover letter listing piece marks, dates and with technicians reports			
Magnetic Particle Inspection 10% of flange to web welds and girder ends after trimming (ODOT review required, Critical Process, Document separately) Dry powder prod method or probe (2 point) 100% QA witness.			
Magnetic Particle Inspection 10% of Bearing Stiffener Welds (ODOT review required, Critical process, Document separately) Dry powder prod or probe method (2 point). 100% QA witness..			
Magnetic Particle technician's signed analysis report (1 point)			
Calibration of Magnetic Particle Equipment every 6 months (1 point)			