

Appendix II

Cambering and Sweep per 863, AWS and AASHTO: Check Point 4			
Cambering or Straightening, AASHTO and AWS 12.12 shop procedure posted (2 points)			
1200 degrees F pyrometric sticks (follow shop procedure) (5 points)			
location and shape of heats (follow shop procedure) (1 point)			
location and number of support blocks (follow shop procedure) (1 point)			
Natural Cooling (follow shop procedure) (5 point)			
Fitting per AWS, 863 and AASHTO: Check Point 5			
Check size, grade , piece mark and locations of parts to be fitted (1 point)			
Remove all scale, moisture, grease & foreign material AWS 3.2.1 (1 point)			
Standard fillet weld fit up tolerance, 1/16" AWS 3.3 (1 point)			
Groove weld fit up tolerance, AWS 3.3 (1 point)			
Bearing Stiffener, mill fit @ bearing, tight fit @ other end, 863.14 (1 point)			
Intermediate Stiffener without cross frames, tight fit at compression flange, 863.14 (1 point)			
Clearance between clipped stiffener corners and fillets on rolled beams (1 point)			
Flange and Web Butt Splice, Web-to-Flange CJP Welding per AWS, 863 and AASHTO: Hold and Witness Point 6			
Record Welding Type: SMAW, SAW, FCAW (1 point)			
Record Shop Welding Procedure (WPS) identification and ODOT approval date. (1 point)			
Record Tackers Name, ODOT Qualified? (1 point)			
Record Welders Name, ODOT Qualified? (1 point)			
Record Location of Splices (1 point)			
Record Flux and Wire combination, does it match WPS (1 point) Are Flux and Wire lot tested Check Temperature of Flux oven			
Check joint geometry tolerances per AWS figure 2.4 (2 point) witness			
Record Preheat Temperature (F) (1 point) witness			
Record Amperage (Amps) (1 point) witness			

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Record Voltage (Volts) (1 point) witness			
Record Travel Speed (IPM) (1 point) witness			
Check backgouge and cleaning per AWS 3.2.6 (5 point) witness			
Record Second side Amperage (Amps) (1 point) witness			
Record Second side Voltage (Volts) (1 point) witness			
Record Second side Travel Speed (IPM) (1 point) witness			
Visual inspection width, thickness AWS 3.6.3 (5 point) witness			
Visual inspection surface finish AWS 3.6.4 125 uin. (5 point) witness			
Flange to Web Fillet Welds per AWS, 863 and AASHTO: Hold and witness Point 7			
Record Welding Type: SMAW, SAW, FCAW (1 point)			
Record Welding Procedure (WPS) identification and ODOT approval date (1 point)			
Record Tackers Name, ODOT Qualified? (1 point)			
Record Welder Name, ODOT Qualified? (1 point)			
Record Flux and Wire combination, does it match WPS Are Flux and Wire lot tested Check temperature of flux oven			
Check fit- up flange to weld, AWS 3.3.1 (2 point) witness			
Check surface cleaning, remove all scale, AWS 3.2.1 (2 point) witness			
Record Preheat Temperature (F) (1 point) witness			
Record Amperage (Amps) (1 point) witness			
Record Voltage (Volts) (1 point) witness			
Record Travel Speed (IMP) (1 point) witness			
Visual inspection weld size and profile, AWS 3.6 (5 point) witness			
Stiffener Fillet Welds per AWS, 863 and AASHTO: Hold and witness Point 8			
Record Welding Type: SMAW, SAW, FCAW (1 point)			
Record Welding Procedure (WPS) identification and ODOT approval date (1 point)			
Record Tackers Name, ODOT Qualified? (1 point)			