

The QCPS shall perform and record that air is blown from the spray gun for 30 seconds onto a white cloth or blotter held in a rigid frame. If any oil, water or other contaminants are present on the cloth or blotter: painting shall be suspended until the problem is corrected and the operation is verified by repeating this test. This test shall be made at the start of each shift and at 4 hour intervals. This is not required for an airless sprayer.

Application Approval

The end of the application of primer for each beam or girder shall be subject to QCPS inspection and approval to detect any defects which might result from the fabricator's methods. If defects are discovered, the fabricator shall make all necessary adjustments to the method of application to eliminate defects before proceeding with additional prime coat application.

Temperature

Paint shall not be applied when the temperature of the air, steel, or paint is below 10° C (50° F). Paint shall not be applied when the steel surface temperature is expected to drop below 10° C (50° F) before the paint has cured for the minimum times specified below:

	10° C (50° F)	16° C (60° F)	21° C (70° F)
Primer	4 hrs.	3 hrs.	2 hrs.

The QCPS shall record and monitor the above temperatures and times with the recording thermometer.

Moisture

Paint shall not be applied when the steel surface temperature is less than 3° C (5° F) above the dew point. Paint shall not be applied to wet or damp surfaces or on frosted or ice-coated surfaces. Paint shall not be applied when the relative humidity is greater than 85%. Paint shall not be applied outdoors. The QCPS shall record the relative humidity prior to painting, at every shift and 4 hour intervals

Repair Procedures

Damaged areas, and areas which do not comply with the requirements of this specification, shall be repaired in a manner to blend the patched area with the adjacent coating. The finished surface of the patched area shall have a smooth, even profile with the adjacent surface.

The QCPS shall submit his method of conducting repairs, correcting runs, sags, mud cracking and un-workman like conditions in writing to the OSE.

Dry Film Thickness

Prime thickness, shall be determined by use of Type 2 magnetic gage in accordance with the following:

Five separate spot measurements shall be made, spaced evenly over each 9 square meters ( 100 square feet) of new steel surface area to be measured. These measurements shall be taken on flanges, webs, cross bracing, stiffeners, etc. Three gage readings shall be made for each spot measurement of either the substrate or the paint. The probe shall be moved a distance of 25 to 75 mm (1 to 3 inches) for each new gage reading. Any unusually high or low gage reading that cannot be repeated consistently shall be discarded. The average (mean) of the 3 gage readings shall be used as the spot measurement. The average of five spot measurements for each such 9 square meter (100 square foot) area shall not be less than the specified thickness. No single spot measurement in any 9 square meter (100 square foot) area shall be less than 80% of the specified minimum thickness nor greater than 150% of the maximum specified thickness. Any one of 3 readings which are averaged to produce each spot measurement, may under-run or over-run by a greater amount. The 5 spot measurements shall be made for each 9 square meter (100 square feet) of area.

Coating thickness shall meet the requirements of the applicable paint specification.

SAFETY REQUIREMENTS AND PRECAUTIONS

The fabricator shall meet the applicable safety requirements of the Ohio Industrial Commission and the Occupational Safety and Health Administration (OSHA).

INSPECTION ACCESS

In addition to the requirements of CMS 105.11, the fabricator shall furnish, erect, and move scaffolding and other appropriate equipment, to permit the QA Inspector the opportunity to closely observe all affected surfaces. Material shall be separated and braced safely This opportunity shall be provided to the Inspector during all phases of the work.

**863.30 Cleaning A709 Grade 50W Steel (ASTM A 588)** Before the new steel is shipped All the exposed surfaces of A 709 Grade 50W ( A588) steel that are to be left unpainted shall be solvent cleaned to remove all traces of asphaltic cement, oil, grease, diesel fuel deposits, and other soluble contaminants per SSPC-SP 1 Solvent Cleaning. QCP #1 and QCP #2 shall apply per 863.29.

Fascia beams (girders) shall be shop blast cleaned to SSPC- SP6 commercial blast. QCP#3 shall apply per 863.29.

After the placement of the superstructure concrete All the exposed surfaces of A 709 Grade 50W (A588) steel that are to be left unpainted shall be solvent cleaned to remove all traces of asphaltic cement, oil, grease, diesel fuel deposits, and other soluble contaminants per SSPC-SP 1 Solvent Cleaning.

The use of acid for cleaning will not be permitted.

**863.31 Method of Measurement.** Structural steel shall be measured by either lump sum or the plan weight of steel, whichever is stipulated in the contract.