

STATE OF OHIO
DEPARTMENT OF TRANSPORTATION
SUPPLEMENTAL SPECIFICATION 863

STRUCTURAL STEEL MEMBERS

SEPTEMBER 9, 1997

863.01	Description
863.02	Fabricator Approval Procedure
863.03	Fabricator Prequalifications
863.04	Levels of Fabrication Qualification
863.05	Fabricators Evaluation and Required Qualifications
863.051	Miscellaneous Level required Qualifications
863.052	Personnel Qualifications
863.06	Rating System
863.061	Fabricator Rating Review Process
863.07	General
863.071	Fabricator Documentation Responsibility
863.08	Shop Drawings and Submittal Process
863.081	Pre-Fabrication Meeting
863.09	Material
863.10	Material Control
863.11	Care of Material
863.12	Workmanship and Straightening
863.13	Finish
863.14	Stiffeners
863.15	Fillers
863.16	Horizontally Curved Beams and Girders
863.17	Joints and Splices
863.18	Pin Holes
863.19	Pins and Rollers
863.20	Holes for High-Strength and Bearing Bolts
863.21	High-Strength Steel Bolts, Nuts and Washers
863.22	Bearing Bolts
863.23	Welding
863.24	Stud Shear Connectors
863.25	Threads for Bolts and Pins
863.26	Shop Assembly
863.27	Nondestructive Testing
863.28	Shipping, Storage and Erection
863.29	Shop Prime Painting
863.30	Cleaning ASTM A 709 Grade 50 W (A588) Steel
863.31	Method of Measurement
863.32	Basis of Payment
	Appendix I: Facilities Inspection Check List
	Appendix II: Rating Forms
	Shop Drawing Rating Form
	Material Test Report Rating Form

Fabrication Rating Form
Fracture Critical Fabrication Rating Form
Appendix III: Rating Calculations

863.01 Description. This item shall consist of preparing shop drawings, furnishing, fabricating, nondestructive testing, fabricator performed quality control(QC), documentation, cleaning, shop painting, and erecting of all structural steel, and other structural metals, as specified. It shall also include any work required to move existing steel structures to the plan location, to make necessary repairs and alterations, and to connect or join new with old construction.

863.02 Fabricator Approval Procedure: Fabricators performing work under this specification shall be Pre-qualified by the Office of Structural Engineering (OSE). Requests for such Prequalification shall be made by the fabricator in writing. The Prequalification process and its requirements are listed in this specification. The Contractor shall select a fabricator from the Prequalified Fabricator List in effect the date of Contract Letting. The Contractor shall inform the District Construction Engineer and the Office of Structural Engineering of the selected fabricator.

863.03 Fabricator Pre-qualification: OSE will perform facilities inspections for prequalification evaluation of a fabricator. Fabricators meeting all qualification requirements will be assigned a fabrication level and will be included on the Prequalified Fabricator List. The Prequalified Fabricator list will be updated as necessary by the OSE.

Fabricators shall perform all fabrication in plants located within the continental limits of the United States.

Final conformance of fabrication to contract requirements is the responsibility of the Contractor. A pre-qualified fabricator does not guarantee the Contractor that work performed will meet quality and conformance requirements of the contract.

863.04 Levels of Fabrication Qualification: There are seven(7) levels of fabricator qualification. Each fabricator shall be listed at the highest level of fabrication they are qualified to perform.

Level	Description of Capabilities
Misc.	Miscellaneous products not designed to carry tension live load but requiring , shop drawings, material test reports, and inspection quality assurance by the Department such as; curb plates, bearings, expansion joints, railings, catwalk, inspection access, drainage or other products not covered by ODOT standard bridge drawings. Also retrofit cross frames, retrofit gusset plates or retro fit lateral bracing or other misc. structural members not included below
ONE	Single span, straight, rolled beam bridges without stiffeners, secondary and detail materials such as retrofit moment plates.
TWO	Multiple span, straight, rolled beam bridges without stiffeners