

Appendix II

Check backgouge and cleaning per AWS 3.2.6 (5 point)			
Record Second side Amperage (Amps) (1 point)			
Record Second side Voltage (Volts) (1 point)			
Record Second side Travel Speed (IPM) (1 point)			
Visual inspection width, thickness AWS 3.6.3 (5 point)			
Visual inspection surface finish AWS 3.6.4 125 uin. (5 point)			
Flange to Web Fillet Welds per AWS, 863 and AASHTO: Check Point 7			
Record Welding Type: SMAW, SAW, FCAW (1 point)			
Record Welding Procedure (WPS) identification and ODOT approval date (1 point)			
Record Tackers Name and SS#, ODOT Qualified, procedure (1 point)			
Record Welder Name and SS#, ODOT Qualified, procedure (1 point)			
Record Flux and Wire combination, does it match WPS (1 point)			
Check fit- up flange to weld, AWS 3.3.1 (2 point)			
Check surface cleaning, remove all scale, AWS 3.2.1 (2 point)			
Record Preheat Temperature (F) Shop Temperature(F) (1 point)			
Record Amperage (Amps) (1 point)			
Record Voltage (Volts) (1 point)			
Record Travel Speed (IMP) (1 point)			
Visual inspection weld size and profile, AWS 3.6 (5 point)			
Stiffener Fillet Welds per AWS, 863 and AASHTO: Check Point 8			
Record Welding Type: SMAW, SAW, FCAW (1 point)			
Record Welding Procedure (WPS) identification and ODOT approval date (1 point)			
Record Tackers Name and SS#, ODOT Qualified, procedure (1 point)			
Record Welder Name and SS#, ODOT Qualified, procedure (1 point)			
Record Flux and Wire combination, does it match WPS (1 point)			
Check fit- up, 863.14 and AWS 3.3.1 (2 point)			
Check surface cleaning, AWS 3.2.1 (2 point)			

Appendix II

Record Preheat Temperature(F) Shop Temperature(F) (1 point)			
Record Amperage (Amps) (1 point)			
Record Voltage(Volts) (1 point)			
Record Travel Speed (IMP) (1 point)			
Visual inspection weld size and profile, AWS 3.6 (5 point)			
Shop Laydown per AWS, 863, and AASHTO: Check Point 9			
check hole patterns, size, spacing, gage, accuracy, 863.20 (2 point)			
Check hole deburring, 863.20 (1 point)			
Check blocking horizontal& vertical dimensions @ bearings, after all welding is complete. (document) 1/8" + or - 863.26 (document separately) (5 point)			
Check blocking camber dimensions @ points specified, after all welding is complete SS xxx.12 (document separately) (5 point)			
Check sweep or horizontal curvature, after all welding is complete 1/8"/10'-0" AWS 3.5 (document separately) (2 point)			
Check fitup at bolted splice, 1/4" max gap SS xxx.11 (2 point)			
Check center to center of field splices matches plan dimensions (1 point)			
Check flatness at bearing seats, after all welding is complete AWS 3.5.1.9 (2 point)			
Radiographic Inspection per AWS, 863.27 and AASHTO: Check Point 10, Hold Point for B & C Rated fabricators			
Radiographic inspection flange butt welds , 100%(ODOT review required, Critical process, Document separately) (5 point)			
Radiographic inspection web butt welds, top & bottom 1/3 (ODOT review required, Critical process ,Document separately) (5 point)			
Radiographic inspection longitudinal stiffeners butt welds, 100% (ODOT review required, Critical process, Document separately) (5 point)			
Radiographic inspection longitudinal web splice, 25% (ODOT review required, Critical process, Document separately) (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)			
Removal of weld reinforcement (1 point)			