

spray pattern to follow, before moving to the next spray pattern area. A spray pattern area is such that the gun shall be held perpendicular to the surface and at a distance which will ensure that a wet layer of paint is deposited on the surface. The trigger of the gun should be released at the end of each stroke. The QCPS shall record that each spray operator demonstrated to the QCPS the ability to apply the paint as specified. Any operator who does not demonstrate this ability shall not spray.

The QCPS shall document that all spray equipment used follows the paint manufacturer's equipment recommendations. Equipment shall be suitable for use with the specified paint. to avoid paint application problems.

If air spray is used, traps or separators shall be provided to remove oil and condensed water from the air. The traps or separators must be of adequate size and must be drained periodically during operations. The following test shall be made by the Fabricator and verified by the QCPS to insure that the traps or separators are working properly.

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 4° C (40° F). Paint shall not be applied when the steel surface temperature is expected to drop below 4° C (40° 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.

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 painted surface area. Three gage readings shall be made for each spot measurement. 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 120% 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.

The specified coating thickness is 3 mils minimum to 5 mils maximum.

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 for inspection and safely braced. This opportunity shall be provided to the Inspector during all phases of the work and storage.

The QCPS shall provide a cover letter and specified check point data documenting QCPS acceptance that shop painting has been performed per specification.

**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 where necessary to remove all traces of asphaltic cement, oil, grease, diesel fuel deposits, chalk, paint marks 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 where necessary to remove all traces of asphaltic cement, oil, grease, diesel fuel deposits, and other soluble contaminants per SSPC-SP 1 Solvent Cleaning.