

Appendix II

Shop Laydown per AWS, 863, and AASHTO: Check Point thirteen(13) QCFS acceptance by frequent audits, documentation of listed data for each member and dates			
Hole patterns, size, spacing, gage, accuracy, 863.20 (2 point)			
Hole de-burring, 863.20 (1 point)			
Blocking horizontal & vertical dimensions @ bearings, after all welding is complete. (document) 1/8" + or - 863.12 (document separately) (5 point)			
Blocking camber dimensions @ points specified, after all welding is complete 863.12 (document separately) (5 point)			
Horizontal curvature of curved members, after all welding is complete 1/8"/10'-0" AWS 3.5.1.4 (document separately) (2 point)			
Fit up at bolted splice, 1/4" max gap 863.17 (2 point)			
Center to center of bearings matches plan dimensions (1 point)			
Flatness at bearing seats, after all welding is complete AWS 3.5.1.9 (2 point)			
Cleaning per 863.27, SSPC and ASTM: Check Point fourteen(14) acceptance by documentation of listed data for each member and dates			
Shop solvent cleaning per SSPC-SP1 where necessary (5 point)			
Shop grinding edges 1/16", material thicker than 1 1/2" shall be checked for removal of the heat effected zone. (1 point)			
Shop blast cleaned SSPC-SP10, <u>Automated process</u> : Five(5) each recorded readings at random locations on one member for 20% of the main members or one beam for each shift (which ever is greater) and One(1) recorded reading for 10% of all secondary material with replica tape ASTM D4417 method C, 1.5 to 3.5 mil profile (10 point)			
Shop blast cleaned SSPC-SP10, <u>Manual process</u> : five (5) each recorded readings at random locations for each main member and One(1) recorded reading for 25% of all secondary material with replica tape ASTM D4417 method C, 1.5 to 3.5 mil profile (10 point)			
Steel ambient (dry bulb) and wet bulb temperatures, humidity and dew point recorded prior to blasting and at the start of each shift (5 degree F above dew point). (2 point)			
Abrasive produces angular profile (1 point)			
Abrasive mix for oil contamination start of each shift (1 point)			
Removal of abrasives & residue by vacuum or double blowing (5 point)			
Test blow air for oil or other contaminants. Blotter test for 30 seconds at the start of each shift. Not required with vacuum (1 point)			

Appendix II

Conditioning all fins slivers and burred or sharp edges ASTM A6 then reblast to 1.5 to 3.5 mil profile, unless condition is less than one square foot per each side of the main member. (1 point)			
Painting per 863, SSPC and ASTM: Hold or Check Point fifteen(15)QCFS acceptance by documentation of listed data for each member and dates.			
Time and dates between blasting and painting (1 point)			
Ambient temperature & humidity (minimum 40 deg.F and 5 deg F above dew point) (1 point)			
Temperature of paint storage location (max/ min) (1 point)			
Paint TE-24, manufactures name and lot numbers (1 point)			
Painter mixes paint (high shear mixer) and strain (5 point)			
Painter is checking operation of automated agitation system with every new paint batch (5 point)			
Prime inside of bolt holes, behind stiffener clips (5 point)			
Prime thickness 3 to 5 mils: 3 gage readings for each spot measurement with 5 spot measurements in each 100 square foot (see additional instructions with paint system notes) (10 point)			
Workman like finish; mud cracking, holidays, pores, runs or sags. (5 point)			
Prime has dried sufficiently prior to handling (1 point)			
Cleaning ASTM A709 Grade 50W steel (A588) Check point sixteen (16). QCFS acceptance by documentation of listed data for each member and dates.			
Shop solvent cleaning per SSPC-SP1 where necessary (5 point)			
Shop grinding edges 1/16"(1 point)			
Shop blast fascia members cleaned SSPC-SP6 achieved			
Abrasive mix for oil contamination start of each shift (1 point)			
Removal of abrasives & residue by vacuum or double blowing (1 point)			
Test blow air for oil or other contaminants. Blotter test for 30 seconds at the start of each shift. Not required with vacuum (1 point)			
Condition all fins slivers and burred or sharp edges per ASTM A6. Re blast to 1.5 to 3.5 mil profile, unless conditioned area is less than one square foot per main member (1 point)			
Repair procedures, QA Inspection : Hold point seventeen (17), Required for all Fabricators.QCFS acceptance by documentation of listed data for each repaired member and dates.			