

Appendix II

FABRICATOR _____ RATING FOR SHOP FABRICATION

County: _____ Project: _____ Reference: _____ Shop ID: _____

Office of Structural Engineering QA Inspector: _____			
Check, Hold or Witness Point Descriptions for Levels of Fabrication 1 thru 5	Y	N	NA
ASTM A709, Grade, Physical & Chemical Requirements, CVN : Check point 1			
Record Heat number and member description (1 point)			
Record Yield Strength, Fy (psi) (3 points)			
Record Tensile Strength, Fu (psi) (1 point)			
Record Elongation% and gage length (2 point)			
Record CVN minimum average energy(ft lb.) (1 point)			
Check Chemical Requirements (1 point)			
Heat No. Steel Stamped and matched to Mill Test Report (1 point)			
ASTM A6 Quality and permissible Variations: Check Point 2			
ASTM A6, Permissible variations in cross-section (1 point)			
ASTM A6, Permissible variations in Straightness & Storage (1 point)			
ASTM A6 and 863.11, Surface indications, Pitting due to rusting (1 point)			
ASTM A6, Laminar indications (1 point)			
Material Preparation per AWS D1.5, AASHTO and 863: Check Point 3			
Cutting beyond (inside) the prescribed lines AWS 3.2.2 (1 point)			
Cutting roughness AWS 3.2.2 (1 point)			
Occasional notches AWS 3.2.2 (document separately) (1 point)			
Cut Edge Discontinuities AWS 3.2.3 (document separately) (1 point)			
Reentrant corners AWS 3.2.4 and Radii of Beam copes 3.2.5 (1 point)			
Rounding of edges AWS 3.2.9 (1 point)			
Shearing distortion 863.13 (1 point)			
Bending , 90 degrees to rolling direction, visual inspection (document any cracking NDT required) AASHTO (1 point)			

Appendix II

Cambering and Sweep per 863, AWS and AASHTO: Check Point 4			
Cambering or Straightening, AASHTO shop procedure posted (1 point)			
1200 degrees F pyrometric sticks (follow shop procedure) (5 point)			
location and shape of heats (follow shop procedure) (1 point)			
location and number of support blocks (follow shop procedure) (1 point)			
Natural Cooling (follow shop procedure) (5 point)			
Fitting per AWS, 863 and AASHTO: Check Point 5			
Check size, grade , piece mark and locations of parts to be fitted (1 point)			
Remove all scale, moisture, grease & foreign material AWS 3.2.1 (1 point)			
Standard fillet weld fit up tolerance, 1/16" AWS 3.3 (1 point)			
Groove weld fit up tolerance, AWS 3.3 (1 point)			
Bearing Stiffener, mill fit @ bearing, tight fit @ other end, 863.14 (1 point)			
Intermediate Stiffener without cross frames, tight fit at compression flange, 863.14 (1 point)			
Clearance between clipped stiffener corners and fillets on rolled beams (1 point)			
Flange and Web Butt Splice Welding per AWS, 863 and AASHTO: Check Point 6			
Record Welding Type: SMAW, SAW, FCAW (1 point)			
Record Shop Welding Procedure (WPS) identification and ODOT approval date. (1 point)			
Record Tackers Name and SS#, ODOT Qualified, procedure (1 point)			
Record Welders Name and SS#, ODOT Qualified, procedure (1 point)			
Record Location of Splices (1 point)			
Record Flux and Wire combination, does it match WPS (1 point)			
Check joint geometry tolerances per AWS figure 2.4 (2 point)			
Record Preheat Temperature (F) Shop Temperature(F) (1 point)			
Record Amperage (Amps) (1 point)			
Record Voltage (Volts) (1 point)			
Record Travel Speed (IPM) (1 point)			