

Appendix II

FABRICATOR _____ RATING FOR SHOP FABRICATION

Project: _____ Bid line No.: _____ Shop ID: _____ Level: _____

Rater/Date: _____ Reviewer/Date: _____

Check, Hold or Witness Point Descriptions for Levels of Fabrication 1 thru 5	Yes	No	NA
ASTM A709, Grade, Physical & Chemical Requirements, CVN : Check point one (1) QCFS acceptance by cover letter listing piece marks and dates			
Heat number and member description (1 point)			
Yield Strength, Fy (psi) (3 points)			
Tensile Strength, Fu (psi) (1 point)			
Elongation% and gage length (2 point)			
CVN minimum average energy(ft lb.) (1 point)			
Chemical Requirements (1 point)			
Heat No. Steel Stamped and matched to Mill Test Reports per 863.10 prior to release or painting (1 point)			
ASTM A6 Quality and permissible Variations: Check Point two(2) QCFS acceptance by cover letter listing piece marks and dates.			
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 three (3) QCFS acceptance by cover letter listing piece marks and dates			
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 (1 point)			
Cut Edge Discontinuities AWS 3.2.3 (1 point)			
Reentrant corners AWS 3.2.4 and Radii of Beam copes 3.2.5 (1 point)			
Rounding of edges main members AWS 3.2.9 (1 point)			
Shearing distortion 863.13 (1 point)			
Bending , 90 degrees to rolling direction, visual inspection look for cracks AASHTO (1 point)			

Appendix II

Cambering and Sweep per 863.12, AWS and AASHTO: Check Point four (4) QCFS acceptance by cover letter listing piece marks and dates.			
Cambering or Straightening, AASHTO shop procedure posted (1 point)			
1150 degrees F pyrometric sticks (follow shop procedure) (5 points)			
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 points)			
Straightness and camber are per 863.12 (5 points)			
Flange and Web Butt Splice Welding per AWS, 863.23 and AASHTO: Check Point five (5) QCFS acceptance by frequent audits and documentation of listed data for each splice and dates.			
Size, grade , piece mark and locations of parts to be fitted (1 point)			
Clean scale, moisture, grease & foreign material per AWS 3.2.1 (1 point)			
Groove weld fit up tolerance, AWS 3.3 (1 point)			
Shop Welding Procedure (WPS) identification and ODOT approval date. (5 point)			
Tackers Name and SS#, ODOT Qualified, procedure (1 point)			
Welders Name and SS#, ODOT Qualified, procedure (1 point)			
Flux and Wire combination, does it match WPS (1 point)			
Joint geometry tolerances per AWS figure 2.4 (2 point)			
Preheat Temperature (F) and Shop Temperature(F) (1 point)			
Amperage (Amps),Voltage (Volts),Travel Speed (IPM) (5 point)			
Back gouge and cleaning per AWS 3.2.6 (5 point)			
Visual inspection width, thickness AWS 3.6.3 (5 point)			
Visual inspection surface finish AWS 3.6.4 125 uin. (2 point)			
Radiographic Inspection per AWS, 863.27 and AASHTO: Check Point six (6), Hold Point for B & C Rated fabricators QCFS acceptance by cover letter listing piece marks , dates and with technician's reports.			
Radiographic inspection 100% flange butt welds and back up bar splices(ODOT review required, Critical process) (5 point)			
Radiographic inspection web butt welds, top & bottom 1/3 (ODOT review required, Critical process) (5 point)			