

Appendix II

Shearing distortion 863.13 (1 point)			
Heat Bending , 90 degrees to rolling direction, visual inspection (document any cracking NDT required) AASHTO and AWS 12.12 (5 point)			
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 and AWS 12.12 shop procedure posted (2 points)			
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 point)			
Straightness and camber are per 863.12 (5 points)			
Flange and Web Butt Splice, Web-to-Flange CJP Welding per AWS, 863.23 and AASHTO: Hold and Witness Point Five (5) QCFS acceptance by witnessing, frequent audits and documentation of listed data for each splice and dates			
Size, grade, piece mark and location 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 (2 point)			
Welders Name and SS#, ODOT Qualified, procedure (3 point)			
Flux and Wire combination, does it match WPS (2 point) Are Flux and Wire lot tested Check Temperature of Flux oven			
Joint geometry tolerances per AWS figure 2.4 (2 point) witness			
Preheat Temperature (F) and shop temperature(F) (3 point) witness			
Amperage (Amps), Voltage(Volts), Travel Speed(F) (3 point) witness			
Backgouge and cleaning per AWS 3.2.6 (3 point) witness			
Visual inspection width, thickness AWS 3.6.3 (5 point) witness			
Visual inspection surface finish AWS 3.6.4 125 uin. (5 point) witness			
Radiographic Inspection per AWS, 863.27 and AASHTO: Check Point Six (6) Hold point QCFS acceptance by cover letter listing piece marks, dates and with technician's reports.			

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Radiographic inspection 100% flange butt welds and back up bars splices(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 100% longitudinal stiffeners butt welds (ODOT review required, Critical process, Document separately) (5 point)			
Radiographic inspection 25% longitudinal web splice(ODOT review required, Critical process, Document separately) (5 point)			
Radiographic identification marked steel stamped and visible in radiographic film, Hole-type image quality indicator (1 point)			
Top and bottom of plate edges visible in the radiographic film (5 point)			
Removal of weld reinforcement (1 point)			
Radiographic technician's signed analysis report (1 point)			
Ultrasonic Inspection per AWS, 863.27 and AASHTO: Check point Seven (7) Hold and witness point QCFS acceptance by cover letter listing piece marks, dates and with technicians reports			
Ultrasonic inspection 100% of complete penetration butt welds in FCM tension or reversal of stress flanges or back up bars. (ODOT review required, Critical Process, 100% QA witness (5 point)			
Ultrasonic inspection 25% of complete penetration butt welds in FCM compression flange or back up bar.(ODOT review required, Critical Process, 100% QA witness (2 point)			
Ultrasonic inspection 25% of complete penetration T or corner joints FCM subject to compression or shear. (ODOT review required, Critical Process, 100% QA witness (2 point)			
Ultrasonic inspection 100% of complete penetration T or corner joints FCM subject to tension or reversal of stress (ODOT review required, Critical Process, 100% QA witness (5 point)			
Ultrasonic technician's signed analysis report (1 point)			
Ultrasonic equipment qualification per AWS 6.17 (1 point)			
Repair procedure per AWS 12.17 hold and witness point Eight (8) QCFS acceptance by witnessing, frequent audits and documentation of listed data for each splice and dates			
Sketch of discontinuity with member piece mark and location on member (1 point)			
QA witness of discontinuity for determination of critical or non critical repairs (2 point)			
Noncritical repair, WPS and repair procedure pre approved (1 point)			