

The QCPS shall be responsible for being familiar with the applicable paint specifications called for in the contract plans. Where specific shop Quality Control Points (QCP) are established in the specification, the QCPS shall comply with those requirements. If no shop prime coat QCPs are defined in the applicable paint specification, the QCPs in this section shall be the responsibility of the QCPS to assure that all QCPs meet specifications.

Shop Prime coat shall be as specified in the contract documents.

Quality Control Points

Quality control points (QCP) are points in time when one phase of the work is complete and ready for inspection by the fabricator and QA Inspector. The next operational step shall not proceed unless the QCP has been accepted or QA inspection waived by the QA Inspector. At these points the Fabricator shall afford access to inspect all affected surfaces. If QA Inspection indicates a deficiency, that phase of the work shall be corrected in accordance with these specifications prior to beginning the next phase of work. Discovery of defective work or material after a Quality Control Point is past or failure of the final product before final acceptance, shall not in any way prevent rejection or obligate the Department to final acceptance.

<u>Quality Control Points (QCP)</u>	<u>(PURPOSE)</u>
1.) Shop Solvent Cleaning	Remove asphaltic cement, oil, grease salt, dirt, etc.
2.) Shop Grinding Flange Edges	Remove sharp corners, per AWS
3.) Shop Abrasive Blasting	Blasted surface to receive paint, including repair of fins, tears, slivers or sharp edges
4.) Shop Prime Coat Application	Check surface cleanliness apply prime coat check coating thickness

Shop Solvent Cleaning (QCP # 1)

The steel shall be solvent cleaned to remove all traces of asphaltic cement, oil, grease, diesel fuel deposits, and other soluble contaminants per SSPC-SP 1 Solvent Cleaning. Under no circumstances shall any abrasive blasting be done to areas with asphaltic cement, oil, grease, or diesel fuel deposits. Steel shall be allowed to dry before blast cleaning begins.

Shop Grinding Edges (QCP # 2)

All corners of thermally cut or sheared edges shall have a 1/16 inch radius or equivalent flat surface at a suitable angle. Thermally cut material thicker than 1 ½ inch shall have the sides ground to remove the heat effected zone.

Shop Abrasive Blasting (QCP #3)

All steel to be painted shall be blast cleaned according to SSPC-SP10. Steel shall be maintained in a blast cleaned condition until it has received a prime coat of paint.

Metallized or Galvanized steel, and other surfaces not intended to be painted, shall be covered and protected to prevent damage from blasting and painting operations. Any adjacent coatings damaged during the blasting operation shall be repaired at the fabricators expense.

The abrasive shall be a mix of recyclable steel grit and shot that produces an angular profile. After each use and prior to reuse, the steel grit shall be cleaned of paint chips, rust, mill scale and other foreign material by equipment specifically designed for such cleaning.

Abrasives shall also be checked for oil contamination before use. A small sample of abrasives shall be added to ordinary tap water. Any detection of a oil film on the surface of the water shall be cause for rejection. The QCPS shall perform and record this test prior to abrasive blasting and at the start of each shift. The resultant surface profile shall be a minimum of 40 mm (1.5 mils) and a maximum of 90 mm (3.5 mils). The QCPS shall record by the use of replica tape ASTM D4417-93 method C, the profile supplied. Five random readings shall be made for each beam or girder piece. 10% of all secondary material shall have one(1) recorded reading. Abrasives of a size suitable to develop the required surface profile shall be used. Any abrasive blasting which is done when the steel temperature is less than 3° C(5° F) above the dew point shall be re-blasted when the steel temperature is at least 3° C(5° F) above the dew point. The QCPS shall record temperature by the use of a recording Thermometer and Dew point shall be recorded prior to blasting and at the start of each shift.

All abrasives and residue shall be removed from all surfaces to be painted with a vacuum cleaner equipped with a brush-type cleaning tool, or by double blowing. All blast cleaned steel shall be kept dust free, dry and shall be prime coated within 24 hours. The QCPS shall perform and record the following test to ensure that the compressed air is not contaminated: blow air from the nozzle for 30 seconds onto a white cloth or blotter held in a rigid frame. If any oil or other contaminants are present on the cloth or blotter, abrasive blasting shall be suspended until the problem is corrected and the operation is verified by a repeated test. This test shall be done prior to blowing and at the start of each shift.

Abrasive blasting and painting may take place simultaneously as long as abrasive blasting debris and/or dust by the blowing operation does not come in contact with freshly painted surfaces. Work areas for blasting and painting shall be physically separated to eliminate contamination of the priming operation.

All fins, tears, slivers and burred or sharp edges that are present on any steel member or that appear after the blasting operation shall be conditioned per ASTM A6 and the area reblasted to provide the specified surface profile.

Shop Prime Coat Application(QCP # 4)