

1050302 CONTRACTOR QUALITY CONTROL GENERAL REQUIREMENTS –
COMPLIANCE WITH THE MATERIALS MANUAL – SECTION 11.5 PRE-APPROVED
REPAIR PROCEDURES FOR STRUCTURAL STEEL
COMMENTS FROM INTERNAL/INDUSTRY REVIEW

Heather Gilmer
813-389-5889
hgilmer@tti-fss.com

Comments: (4-3-12)

1. 11.5.3 REFERENCES: * Steel Bridge Collaboration, Steel Bridge Fabrication QC/QA Guide Specification: Include document number S4.1. (Context: “S4.1, QC/QA...”) * American Welding Society (AWS), American National Standards Institute, Inc. (ANSI)/American Association of State Highway Transportation Officials (AASHTO)/AWS D1.5, Bridge Welding Code: “ANSI” no longer part of the document title. Delete.

Response:

2. 11.5.5 GENERAL INFORMATION

Response:

2a. Line 5: “engineer Engineer” Delete first "engineer".

Response:

2b. Is it possible to submit plant-specific procedures for general preapproval (i.e., use without subsequent resubmittal on case-by-case basis)?

Response:

3. Repair Procedure 2 I(5): Delete “minimum”. Can preheat higher.

Response:

4. Repair Procedure 2 I(6): "Low-hydrogen electrode" is only applicable to SMAW. Will this also include "low-hydrogen" *processes* such as SAW, FCAW, GMAW? Does FDOT approve non-low-hydrogen WPSs? If not, consider deleting “using low-hydrogen electrodes” rather than trying to rephrase.

Response:

5. Repair Procedure 2 II(3): “AASHTO,AWS D1.5”: Either change to “AASHTO/AWS D1.5” or just “AWS D1.5”, which is how it is elsewhere in the document.

Response:

6. Repair Procedure 3 (4): A small tolerance for exceeding unaffected base metal hardness would be helpful. Final comma should be semicolon.

Response:

7. Repair Procedure 3 (5): Which requirements of A6? If plate is ordered to thickness (which is how we are required to order) A6 allows almost no reduction (which could mean a lot of structurally unnecessary welding in the shop), but the section on ordering to weight can be used

as good guidance for occasional shop repairs. Suggestion: "than that allowed by ASTM A6 for plate ordered to weight" "weld procedure" should be "welding procedure"

Response:

8. Repair Procedure (6): Suggest "should be performed for the WELDED repair area".

Response:

9. Repair Procedure 4 Title: Grades 50S, HPS 50W would also be suitable at the temperatures listed. Suggest similar wording as used in Repair Procedure 5 ("material with specified minimum yield strength not greater than 50,000 psi").

Response:

10. Repair Procedure 4 (3): Consider replacing last sentence with Repair Procedure 7(9). ("Heating shall not be applied to one location more than three times until all other locations have been utilized.")

Response:

11. Repair Procedure 5 1st paragraph: Specified MINIMUM yield strength.

Response:

12. Repair Procedure 5 (4): Consider deleting bold sentence and then adding Repair Procedure 7(9) at the end of the paragraph. ("Heating shall not be applied to one location more than three times until all other locations have been utilized.")

Response:

13. Repair Procedure 7 1st paragraph: Specified MINIMUM yield strength.

Response:

14. Repair Procedure 7 (4): Delete bold sentence; heating more than three times is covered by Repair Procedure 7 (9) ("Heating shall not be applied to one location more than three times until all other locations have been utilized"). Suggested reorganization: delete bold sentence but then move (9) to the end of this paragraph.

Response:
