

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

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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: Agree. ANSI will be deleted.
Change made.

2. 11.5.5 GENERAL INFORMATION

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

Response: Agree. Change made.

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

Response: No.

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

Response: Agree. “Minimum” will be deleted and language will be changed as follows: “Preheat per the applicable WPS and maintain the interpass temperature.” Also, (5) renumbered to (4) due to the deletion of (2).
Changes made.

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: Text “...using low hydrogen electrodes.” will be deleted. Also, (6) renumbered to (5) due to the deletion of (2).
Changes made.

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: "AASHTO" will be deleted.
Change made.

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

Response: There is no tolerance for exceeding unaffected base metal hardness in the code. This follows the D1.5 code. No change made.
The last coma will be changed to a semicolon. Change made.

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: (Which requirements of A6?) Non-persuasive
Language "weld procedure" will be changed to "welding procedure". Change made.

8 Repair Procedure 3 (6): Suggest "should be performed for the WELDED repair area".

Response: Language will be changed to "...welded repair area...". Change made.

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: Language will be changed to "For material with specified minimum yield strength not greater than 50,000 psi"). Change made.

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: Language will be changed to, "Heating shall not be applied to one location more than three times until all other locations have been utilized." Also, (3) renumbered to (2) due to the deletion of (2).Changes made.

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

Response: Language will be changed to "...specified minimum yield strength...". Change made.

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: Language will be changed to, "Heating shall not be applied to one location more than three times until all other locations have been utilized". Change made.

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

Response: Language will be changed to "...specified minimum yield strength...". Change made.

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: Language will be changed to, "Heating shall not be applied to one location more than three times until all other locations have been utilized".

Changes made.
