AISC 360-10 INSPECTIONS FOR WELDING

TABLE N5.4-1 INSPECTION TASKS PRIOR TO WELDING	QC	QA
WELDING PROCEDURE SPECIFICATION (WPSs) AVAILABLE	P	P
MANUFACTURER CERTIFICATIONS FOR WELDING CONSUMABLES AVAILABLE	P	P
MATERIAL IDENTIFICATION (TYPE/GRADE)	O	O
WELDER IDENTIFICATION SYSTEM (1)	O	O
FIT-UP OF GROOVE WELDS (INCLUDING JOINT GEOMETRY) • JOINT PREPARATION • DIMENSIONS (ALIGNMENT, ROOT OPENING, ROOT FACE, BEVEL) • CLEANLINESS (CONDITION OF STEEL SURFACES) • TACKING (TACK WELD QUALITY AND LOCATION) • BACKING TYPE AND FIT (IF APPLICABLE)	O	O
CONFIGURATION AND FINISH OF ACCESS HOLES	O	O
FIT-UP OF FILLET WELDS • DIMENSIONS (ALIGNMENT, GAPS AT ROOT) • CLEANLINESS (CONDITION OF STEEL SURFACES) • TACKING (TACK WELD QUALITY AND LOCATION)	O	O
CHECK WELDING EQUIPMENT	O	—
TABLE N5.4-2 INSPECTION TASKS DURING WELDING		
USE OF QUALIFIED WELDERS	O	O
CONTROL AND HANDLING OF WELDING CONSUMABLES • PACKAGING • EXPOSURE CONTROL	O	O
NO WELDING OVER CRACKED TACK WELDS	O	O
ENVIRONMENTAL CONDITIONS • WIND SPEED WITHIN LIMITS • PRECIPITATION AND TEMPERATURE	O	O
WPS FOLLOWED • SETTINGS ON WELDING EQUIPMENT • TRAVEL SPEED • SELECTED WELDING MATERIALS • SHIELDING GAS TYPE/FLOW RATE • PREHEAT APPLIED • INTERPASS TEMPERATURE MAINTAINED (MIN/MAX) • PROPER POSITION (F, V, H, OH)	O	O
WELDING TECHNIQUES • INTERPASS AND FINAL CLEANING • EACH PASS WITHIN PROFILE LIMITATIONS • EACH PASS MEETS QUALITY REQUIREMENTS	O	O
TABLE N5.4-3 INSPECTION TASKS AFTER WELDING		
WELDS CLEANED	O	O
SIZE, LENGTH AND LOCATION OF WELDS	P	P
WELDS MEET VISUAL ACCEPTANCE CRITERIA • CRACK PROHIBITION • WELD/BASE-METAL FUSION • CRATER CROSS SECTION • WELD PROFILES • WELD SIZE • UNDERCUT • POROSITY	P	P
ARC STRIKES	P	P
K-AREA (2)	P	P
BACKING REMOVED AND WELD TABS REMOVED (IF REQUIRED)	P	P
REPAIR ACTIVITIES	P	P
DOCUMENT ACCEPTANCE OR REJECTION OF WELDED JOINT OR MEMBER	P	P

(1) THE FABRICATOR OR ERECTOR, AS APPLICABLE, SHALL MAINTAIN A SYSTEM BY WHICH A WELDER WHO HAS WELDED A JOINT OR MEMBER CAN BE IDENTIFIED. STAMPS, IF USED, SHALL BE THE LOW-STRESS TYP.

(2) WHEN WELDING OF DOUBLER PLATES, CONTINUITY PLATES OR STIFFENERS HAS BEEN PERFORMED IN THE K-AREA, VISUALLY INSPECT THE WEB K-AREA FOR CRACKS WITHIN 3 IN. (75 MM) OF THE WELD.

AISC 360-10
FABRICATOR AND ERECTOR QUALITY CONTROL PROGRAM

FABRICATOR INSPECTION TASKS	QC	QA
DETAILS IN ACCORDANCE WITH SECTION N5	P	-
SHOP CUT AND FINISHED SURFACES IN ACCORDANCE WITH SECTION M2	P	-
SHOP HEATING FOR STRAIGHTENING, CAMBERING AND CURVING IN ACCORDANCE WITH SECTION M2.1	P	-
TOLERANCES FOR SHOP FABRICATION IN ACCORDANCE WITH SECTION 6 OF THE *CODE OF STANDARD PRACTICE*	P	-
INSPECT THE FABRICATED STEEL TO VERIFY COMPLIANCE WITH DETAILS SHOWN ON SHOP DRAWINGS, SUCH AS PROPER APPLICATION OF JOINT DETAILS AT EACH CONNECTION	P	-
ERECTOR INSPECTION TASKS		
DETAILS IN ACCORDANCE WITH SECTION N5	P	-
STEEL DECK HEADED STEEL STUD ANCHOR PLACEMENT AND ATTACHMENT IN ACCORDANCE WITH SECTION N6	P	-
FIELD CUT SURFACES IN ACCORDANCE WITH SECTION M2.2	P	-
FIELD HEATING FOR STRAIGHTENING IN ACCORDANCE WITH SECTION M2.1	P	-
TOLERANCES FOR FIELD ERECTION IN ACCORDANCE WITH SECTION 7.13 OF THE *CODE OF STANDARD PRACTICE*	P	-
INSPECT THE ERECTED STEEL FRAME TO VERIFY COMPLIANCE WITH THE DETAILS SHOWN ON THE ERECTION DRAWINGS, SUCH AS BRACES, STIFFENERS, MEMBER LOCATIONS AND PROPER APPLICATION OF JOINT DETAILS AT EACH CONNECTION	P	-
INSPECT PLACEMENT OF ANCHOR RODS AND OTHER EMBEDMENTS SUPPORTING STRUCTURAL STEEL FOR COMPLIANCE WITH CONSTRUCTION DOCUMENTS. AS A MINIMUM, THE DIAMETER, GRADE, TYPE AND LENGTH OF THE ANCHOR ROD OR EMBEDDED ITEM, AND THE EXTENT OR DEPTH OF EMBEDMENT INTO CONCRETE, SHALL BE VERIFIED PRIOR TO PLACEMENT OF CONCRETE	-	P
INSPECT THE FABRICATED STEEL OR ERECTED STEEL FRAME, AS APPROPRIATE, TO VERIFY COMPLIANCE WITH THE DETAILS SHOWN ON CONSTRUCTION DOCUMENTS, SUCH AS BRACES, STIFFENERS, MEMBER LOCATIONS AND PROPER APPLICATION OF JOINT DETAILS AT EACH CONNECTION	-	O
REVIEW THE MATERIAL TEST REPORTS AND CERTIFICATIONS FOR COMPLIANCE WITH THE CONSTRUCTION DOCUMENTS	-	P

GENERAL NOTES

1) SEE SHEET S-003 FOR SPECIAL INSPECTION PROGRAM NOTES.

Sheet Title
STATEMENT OF SPECIAL INSPECTIONS

Dwg. No.
PLS2021-0432-0004D

Sht. No.
S-004