METHODS OF SAMPLING AND TESTING
MT 418-21
METHOD OF ACCEPTANCE FOR MISECLLANEOUS WELDED ITEMS
(*Montana Method*)

1 Scope

1.1 This method describes the procedures for the acceptance of miscellaneous, low stress carrying welded items in the field. It does not cover welding in connection with bridge related items.

1.2 Welder certifications and welding specifications must be approved prior to fabrication of the low stress carrying welded item. See Specifications Section 624.03.3 for required submittals.

2 Referenced Documents

American Welding Society (AWS)
D1.1 Structural Welding Code-Steel (current edition)

Montana Department of Transportation
Detailed Drawings
Standard Specifications for Road and Bridge Construction

3 Field Welding Acceptance

3.1 The low stress carrying members listed below can be approved by the field provided the welding has been done by a certified welder in accordance with AWS D1.1. In the event that field welding is necessary, welder certifications shall be verified prior to welding. If welder certification tests are needed, contact the Materials Bureau.

- Trash guard racks (MDT Detailed Drawing No. 615-02)
- Median inlet covers (MDT Detailed Drawing No. 604-00)
- Concrete barrier rail anchors (MDT Detailed Drawing No. 605-05)
- Intersecting roadway terminal section (MDT Detailed Drawing No. 606-46)
- Box beam to MGS Transition (MDT Detailed Drawing No. 606-58)
- Low tension cable guardrail (MDT Detailed Drawing No. 606-94)
- Box Beam Guardrail (MDT Detailed Drawing No. 606-97, 609-98, and 609-99)
- Heavy duty cattle guard (MDT Detailed Drawing No. 611-00)
- Cattle guard hinged grate (MDT Detailed Drawing No. 611-03)
- Ladders, stairways, scale pit angles, grates, and miscellaneous items associated with weigh stations, rest areas, and observation points.

3.2 In accordance with MDT Standard Specifications 106.09, the low stress carrying welded items must be accompanied by a Form 406 and a certification from the final manufacturer or prefabrication plant indicating that all steel incorporated has been melted/recycled and manufactured in the United States.

3.3 A visual inspection report signed by a Certified Welding Inspector must be submitted with the material.

3.4 The items must be visually inspected per the requirements of the AWS D1.1.

PAGE INTENTIONALLY LEFT BLANK