METHODS OF SAMPLINGB AND TESTING
MT 418-04
METHOD OF ACCEPTANCE FOR MISECLLANEOUS WELDED ITEMS
(MONTANA METHOD)

1 Scope:

1.1 This method is intended as a guide for the acceptance of miscellaneous, low stress carrying welded items. It does not cover any welding in connection with bridge related items.

2 Referenced Documents:

2.1 Montana Department of Transportation Detailed Drawings

3 Field Welding Acceptance:

3.1 The low stress carrying members listed in 3.1.1, 3.1.2, and 3.1.3 below can be approved by the field provided the welding has been done by a qualified welder in accordance with AWS D1.1 Current edition, Limited Thickness. In the event that field welding is necessary, contact the Bridge Bureau for welder qualification tests.

3.1.1 Trash guard racks (MDT Detailed Drawing No. 615-02) and median inlet covers (MDT Detailed Drawing No. 604-00).

3.1.2 Guardrail terminal section anchor plates (MDT Detailed Drawing No. 606-86).

3.1.3 Ladders, stairways, scale pit angles, grates, and miscellaneous items associated with weigh stations, rest areas, and observation points.

4 Acceptance Procedure:

4.1 The procedure listed in 4.1.1, 4.1.2, 4.1.3, and 4.1.4 below must be followed for the acceptance of welded items covered in this method.

4.1.1 A copy of the mill test results must accompany the material.

4.1.2 A copy of the welder qualification form or other verification must accompany the material.

4.1.3 The items must be visually inspected and the welds examined for appearance, size, undercut, and porosity.

4.1.4 Items 4.1.1 and 4.1.2 must be attached to the visual inspection report and submitted in the usual manner.