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## INSPECTION AND ACCEPTANCE OF SHEAR CONNECTOR STUDS

### **GENERAL**

Inspection and acceptance of steel studs welded to steel, to connect members and connection devices to concrete shall meet the requirements of Section 2408.13 of the General Specifications and the following requirements:

1-Workmanship, preproduction testing, operator qualification and application qualification testing, shall be required.

2-Quality control and proper inspection of stud welding during production.

3-Mechanical properties of steel studs and requirements for qualification of stud bases(Only studs with qualified stud bases shall be used).

4-Type and size shall be as specified in the contract document and specifications.

5-An Arc shield (ferrule) of heat resistant ceramic or other suitable material (approved by the engineer) shall be furnished with each stud.

### **ACCEPTANCE**

Prior to being allowed to furnish studs on Department of Transportation projects, the manufacturer shall submit test reports showing conformance of their product to the applicable sections of ANSI/AASHTO/AWS D 1.5-95, Bridge Welding Code.

These reports shall be forwarded to the Office of Materials for review.

If the reports are approved, the manufacturer will be placed on the approved list (Appendix A).

### **CERTIFICATION**

Certifications shall be in the form of a manufacturer's test report on the studs, or from bar stock from which the studs were made. The test report shall indicate the mechanical properties of the studs and must be dated not more than six months prior to the manufacture of the studs.

### **MONITOR SAMPLING & TESTING**

The Office of Materials may sample and test studs for certification monitoring purposes.