



QUALIFICATION OF STEEL FABRICATION SHOPS & PLANTS

GENERAL

In addition to the requirements set forth in the Standard Specifications, all steel fabrication shops and plants, shall be on an approved list prior to letting for work covered by Iowa Department of Transportation, English or Metric, Standard Specifications for Highway & Bridge Construction.

Approval of fabrication shops and plants shall be on the following basis:

1. Approved Quality Control Plan/procedures
2. Qualified quality control personnel
3. Applicable certifications
4. Shop approval (welding equipment, certified welders)
5. AISC approval (if applicable)
6. Capability & resources

GROUPS OF FABRICATION

All steel fabrication can be divided into two groups:

1. Steel structures with main members per [Section 2408.01](#).
2. Other steel items are as follows:
 - a. Bridge Components and Miscellaneous Items. This includes swedge anchor bolts*, self lubricating bronze plate, sole plates, pintle plates, masonry plates, curved sole plates, finger joint devices, expansion joint devices, floor drains, drain pipe, pot bearings assemblies, cross frames, diaphragms, welded wire fabric fence panels, metal railing (steel, aluminum, and stainless steel), bearing assemblies-castings, disc bearings, steel laminated elastomeric bearing pads**, and tread plates.
 - b. Traffic Signal Components
 - c. Sign Support Components
 - d. Lighting Structure Components
 - e. Pre-engineered Pedestrian Bridges

For all the items in group 2, welding procedures and requirements shall conform to the ANSI/AWS D1.1 Structural Welding Code, except that filler metal and welder qualification requirements shall be in accordance with the current Standard Specifications.

* For swedge anchor bolts, consult [IM 453.08](#)

** For steel laminated elastomeric bearing pads, consult [IM 495.03](#)

QUALIFICATION

The basis of qualification of a shop or plant shall be based on its quality control program, equipment, welding procedures, certified welders, capability and resources to fabricate the items listed to the appropriate specification requirements.