B97-27

File	**BCM 180-7.0**
Date Effective	07/15/1997
Expiration Date	N/A
Supersedes	None
Approved by	R. P. SOMMARIVA, Chief Office of Structure Construction

Subject: Inspection of Weld Backing Plate for Column Casing

Attached is a memorandum from Roy Bushey to Ralph Sommariva, referring to the memorandum, dated January 25, 1995 from Richard Spring to METS field inspectors addressing the continuous/non-continuous welding of backing bars used in conjunction with column casings.

After further discussion with METS, the following clarifications were obtained:

> When welding column casing sections together in the manufacturer's shop, the backing bars are to have a continuous full length weld.
>
> The backing bars used to weld the column casing sections together in the field will only be welded to the column casing on one side by non-continuous welds. These welds will be 2" long and at 8" centers. This backing bar does not need a continuous full length weld.

Attachment

c: BCR&P Manual Holders
RBushey, METS
BGauger, HQ Construction Program Manager
Consultant Firms

State of California

Business, Transportation and Housing Agency

Memorandum

To: MR. RALPH SOMMARIVA, Chief
Office of Structure Construction

Date: June 6, 1997

File: Policy, Materials, Inspection Guidelines

From: **DEPARTMENT OF TRANSPORTATION**
ENGINEERING SERVICE CENTER
Office of Materials Engineering and Testing Services - MS #5

RECEIVED
JUN 1 0 1997
BY _____

Subject: Column Casing Inspection

It has come to our attention that some of the Structure Construction personnel have questioned the noncontinuous weld on the backing bars used in conjunction with column casings. Back in 1995, the fabricators were having problems with distortion of the edge of the column casings due to the heat generated by the continuous weld. In as much as there was no real need to have the backing bar welded continuously in order to produce a satisfactory field weld, we allowed the fabricator to make the weld as stated in the attached memo dated January 25, 1995.

This memo also addressed some other concerns which were present at that time. The main purpose was to maintain consistency in our overall inspection process.

If you could make this information available to your construction personnel, it may help to relieve some of the questions.

Roy Bushey

ROY BUSHEY, Chief
Office of Materials Engineering
and Testing Services

Attachment

cc: PStolarski
RSpring
DHassler
FReed
SEllis
DJones
SMFiles

RJW/llb

State of California

Business, Transportation and Housing Agency

Memorandum

To: MR. HERNANDO MORALES
MR. LARRY WEBSTER
DMEs - Dist. 1,2,3,4,5,6,9,10,11

Datc: January 25, 1995

File: Policy, Materials, Inspection Guidelines

From : DEPARTMENT OF TRANSPORTATION
ENGINEERING SERVICE CENTER
Office of Materials Engineering and Testing Services

Subject : Column Casing Inspection

Due to some confusion and inconsistency, in the interpretation of column casing fabrication requirements, the following shall become standard inspection policy:

1) Fillet welds on backing bars for field welded joints shall be 2" long on 8" centers. Fillet welds on backing bars for groove welds made in a fabrication shop, where the backing is to remain in place, shall be full length.

2) Intersecting field welds shall be drilled out with a 1" or 2" hole depending on the size of weld at the intersection. No drilling will be required on intersecting shop welds, nor will drilling be required when a field weld intersects an existing shop weld.

3) Exterior casing welds need not be ground flush. However, weld profile must still meet the requirements of AASHTO/AWS D1.5 (Bridge Welding Code), Section 3.6.

This standard inspection policy is to be effective immediately and enforced on all current and future casing projects.

Richard J. Spring

RICHARD J. SPRING
Senior Materials & Research Engineer

RJS/mdb